MODERN GAS
AUTOMOBILE
PAGÉ

REVISED AND ENLARGED EDITION

Library of

Wellesley College.

Purchased from
The Horsford Fund.

No

THE MODERN
GASOLINE AUTOMOBILE

ITS DESIGN, CONSTRUCTION, OPERATION AND MAINTENANCE

A PRACTICAL, COMPREHENSIVE TREATISE EXPLAINING ALL PRINCIPLES PERTAINING TO GASOLINE AUTOMOBILES AND THEIR COMPONENT PARTS. THE MOST COMPLETE UP-TO-DATE TREATISE ON GASOLINE AUTOMOBILES EVER PUBLISHED

INVALUABLE TO MOTORISTS, STUDENTS, MECHANICS, REPAIR MEN AUTOMOBILE DRAUGHTSMEN, DESIGNERS AND ENGINEERS. EVERY PHASE OF THE SUBJECT BEING TREATED IN A PRACTICAL, NON-TECHNICAL MANNER

BY

VICTOR W. PAGÉ, M.E.

AUTHOR "THE MODERN GAS TRACTOR," "AUTOMOBILE QUESTIONS AND ANSWERS," "AUTOMOBILE REPAIRING MADE EASY," "AUTOMOBILE STARTING, LIGHTING AND IGNITION SYSTEMS," ETC.

1921 EDITION

A New Book From Cover to Cover

REVISED, ENLARGED AND RESET EDITION, SHOWING ALL RECENT IMPROVEMENTS

Illustrated by 1,000 Specially Made Detailed Illustrations and Diagrams

THE ILLUSTRATIONS DEFINING CONSTRUCTION OF PARTS ARE MADE FROM ACCURATE ENGINEERING DRAWINGS ACCORDING TO BEST AUTOMOBILE ENGINEERING PRACTICE

NEW YORK

THE NORMAN W. HENLEY PUBLISHING COMPANY

2 WEST 45th STREET

1921

Copyrighted, 1917, 1916, 1915, 1914, 1913 and 1912, by
THE NORMAN W. HENLEY PUBLISHING COMPANY

ALSO

COPYRIGHTED IN ENGLAND AND ALL OTHER COUNTRIES
WHICH HAVE BECOME PARTIES TO THE BERNE CONVENTION

All rights reserved

105594

TENTH IMPRESSION—REVISED AND ENLARGED

All illustrations in this book have been specially made by the publishers, and their use without permission is strictly prohibited

Printed in U. S. A.

Physics
TL
205
P2

PREFACE TO 1921 EDITION

The favorable reception of this treatise by the motoring public has been gratifying, to say the least, and in presenting the ninth edition of this work to the motoring fraternity the author wishes to thank those readers and reviewers who have made suggestions for improving or enlarging the scope of the exposition. The improvements in the automobile during the seven years this work has been on the market have been more in the nature of refinement of body lines and improvement of mechanical detail than any radical change in principles or basic design. The most pronounced tendency is the adoption of eight and twelve-cylinder V motors, such as used in aeroplanes, to automobile propulsion, but this is not general. All latest engine types and auxiliaries are described in this edition.

While the major portion of the 1919 edition of this work remains unchanged, owing to the highly developed state of the art at the time it was prepared, it has been found desirable to include much additional matter in this latest edition in order to keep pace with the progress of the industry. The entire work has been thoroughly revised and a number of corrections made in the text. Much supplementary matter has been added relating to ignition, the action of generators and basic principles on which they operate, so this subject should be more easy of comprehension. Entirely new material has been written on tractors in three- and four-wheel forms, cyclecars and agricultural tractors or automobile plows; combination gasoline-electric drive, front-wheel and four-wheel drive and steer systems, and other important developments in power-propelled vehicles. The discussion of power transmission methods has been augmented by consideration of the spiral bevel gear and two-speed direct drive rear axle, as well as several forms of worm gear drive. The subject of

electrical motor starting systems has been considered at length and leading systems and their components described. A discussion on ball and roller bearings, their maintenance and installation, has also been included, and a number of other features of timely interest, such as latest types of gasoline and kerosene carburetors, cyclecar power plants, the slide valve motor, detachable wire wheels, etc. have been added to bring the work thoroughly up to date. Many new illustrations have been made to illustrate the matter and the treatment of some of the subjects changed to some extent upon the advice of various educators to permit the work to be used to somewhat better advantage in teaching classes in engineering in various technical schools that have adopted this work as a text-book on elementary automobile engineering.

Victor W. Pagé.

ACKNOWLEDGMENT

In greatly increasing the scope of this work to make it of greater value as a text-book on modern automobile construction and design practice, the writer has followed the suggestions of many teachers who utilize this volume as a text-book and it is but fitting to express his appreciation of the kindly and constructive criticism that has been offered. Much material has been added to this new edition and an effort has been made to consider industrial vehicles more in detail than in previous impressions. An acknowledgment is due to the publishers of the "Automobile," "Motor Age," "Horseless Age" and "Commercial Vehicle" because of frequent reference to these publications in preparing this new edition.

THE AUTHOR.

CONTENTS

CHAPTER I

MOTOR-CAR TYPES, THEIR PARTS AND FUNCTIONS

PAGES

Defining Trend of Modern Practice—Explaining Components of Motor Cars and Considering Functions of Each Group of Mechanism—Parts of Typical Pleasure Car Chassis—Assembling Typical Chassis—Arrangement of Truck Parts—Wind Resistance and Body Design—Classification of Motor Car Types—Standard Body Nomenclature—General Trend in Pleasure Car Bodies—Detachable and Permanent Top Types—Four-Passenger Roadsters—New Body Designs and Seating Arrangements—Body Dimension Data—Motor Truck Design Tendencies—Three-Wheel Tractor—Four-Wheel Tractors—Trailer Types—Two-Wheel and Four-Wheel-Drive Trucks—Light Cars and Cyclecars—Agricultural Tractors and Truck Tractors—Automobile Plow—Farm Tractors—Armored Automobiles—Mobile Repair Shops—Ford Truck Conversion Sets—Combination Gasoline-Electric Car—Drawbar Pull of Motor Trucks—How to Use Chart—Grade Determination 17–116

CHAPTER II

MODERN ENGINE TYPES AND THEIR OPERATING PRINCIPLES

Forms of Power Plants Commonly Used—How Power is Generated—How Gasoline Engine Works—Comparing Cannon and Gas Engine—Four-Cycle Engine Action—Internal Combustion Motor Parts and Functions—Low Speed Single Cylinder Auto Engine—High Speed Single Cylinder Engine—Sequence of Cycles in One- and Two-Cylinder Engines—Sequence of Cycles in Multiple Cylinder Engines—Actual Duration of Different Strokes—Typical Engine Types Described—Two-Cylinder Opposed Motor—Four-Cylinder Engines—Features of Knight Slide Valve Motor—How Knight Motor Works—Sleeve Valve Action—Eight-Cylinder V Engine—Torque of Various Engine Types—Eight-Cylinder Advantages—Twelve-Cylinder Engines—Operating Principles of Two-Cycle Engines—Two-Port Two-Cycle Engine Action—Three-Port Two Cycle Engines—Differential Piston Two-Cycle Engines—Why Two-Cycle Engine is Not Used in Modern Automobiles—Amplex Two-Cycle Engine—Legros Two-Cycle Engine—Cote Two-Cycle Engine—Rayner Two-Cycle Engine—Power Plant Installation—Three- and Four-Point Support—Unit Power Plants—Motor Location—1917 Automobile Engine Practice—Typical Modern Engines—Power Plant Equipment of Various Cars—Horsepower Table—Cyclecar Engines—Diesel Engines for Automobile Work—Constant Pressure Cycle Possibilities 117–213

CHAPTER III

CYLINDER CONSTRUCTION AND VALVE SYSTEMS

PAGES

Method of Cylinder Construction—Individual Cylinder Castings—Block Casting Advantages—Removable Head Construction—Water Jackets Cast Integral—Influence on Crank Shaft Design—Combustion Chamber Design—Bore and Stroke Ratio—Meaning of Piston Speed—Advantages of Off-set Cylinders—Influence of Cylinder Construction on Engine Design—Valve Location of Vital Import—"T" Head Construction—"L" Head Construction—Valve-in-the-Head Types—Concentric Valves—Valve Design and Construction—Composite Construction—Valve Operation—Cam Forms—Valve Lift Plungers—Valve Operating Means—Valve Placing Methods Reviewed—Methods of Driving Cam Shaft—Silent Chain Drive—New Valve Operating Systems—Overhead Camshafts—Positively Closed Valves—Valves Operated by Drum Cams—Why Four Valves Per Cylinder Give More Power—Novel Sixteen Valve Designs—Unconventional Valve Arrangement—Piston and Rotary Valve Motors—Slide Valve Motors—Miesse Engine—Itala Rotary Valve Motor—Reynold's Rotary Valve Design—Miscellaneous Rotary Valve Forms—Rotary Cone Valve of Carbon—Sphinx Ring Valve Motor—Darracq Rotary Distributor Motor—Hewitt Piston Valve Motor—Fisher Slide Valve Motor—Valve Timing—Blowing Back—Exhaust Closing, Inlet Opening—Closing the Inlet Valve—Time of Ignition—Typical Timing Diagrams 214–303

CHAPTER IV

PISTONS, CRANKSHAFT AND CRANKCASE PARTS

Constructional Details of Pistons—Piston Forms—Wrist Pin Retention Methods—Piston Ring Construction—Leak-Proof Rings—Aluminum Cylinders and Pistons—Connecting Rod Forms—Connecting Rods for "V" Engines—Cam Shaft Forms—Crankshaft Types Outlined—Built-up Crankshaft—Ball Bearing Crankshafts—Counterweighted Crankshafts—Lanchester-Packard Vibration Damper—Fly Wheel Construction and Retention—Positive Fly Wheel Retention Important—Fly Wheel Marks—Engine Base Construction—Barrel Type Crankcase—Steel Engine Cylinders . . . 304–348

CHAPTER V

FUELS, FUEL SUPPLY AND CARBURETOR ACTION

Liquid Fuels and Distillates of Crude Petroleum—Gasoline—Kerosene—Benzol and Its Properties—Special Vaporizers Needed for Kerosene—Advantages and Disadvantages of Alcohol—Alcohol-Benzol Fuel—Taylor-White Process—Solid Gasoline as a Fuel—Principles of Carburetion Outlined—Air Needed to Burn Gasoline—What a Carburetor Should Do—Liquid Storage and Supply—Storage in Cowl Tank—Rear Tank Location—Fuel Tank Location—Advan-

PAGES

tages Summarized—Stewart Vacuum Fuel Feed—Air Stoves—Church Fuel Feed—Carter Diaphragm Pump—Early Vaporizer Forms—Wick Surface Vaporizer—Bubbling Type Vaporizer—Spraying Type Carburetors—Mixing Valves—Lanchester Wick Feed Carburetor—Development of Float Feed Carburetor—Maybach's Early Design—Elements of Carburetor Design—Venturi Type Mixing Chamber—Concentric Float and Mixing Chambers—Problem of Float Bowl Design—Gasoline Spray Nozzle Forms—Typical Auxiliary Air Valves—Methods of Gas Supply Regulation—Centrifugal Governors—Hydraulic Governor—Kramer Governor 349–391

CHAPTER VI

TYPICAL CARBURETORS AND FUEL SYSTEM AUXILIARIES

Construction of Modern Carburetors—Schebler Model E—New Schebler Metering Pin Type—Kingston—Ford Carburetor—Holley Carburetors—Mercedes—Stromberg One-Nozzle Type—Compound Nozzle Zenith Carburetor—Duplex Carburetor—Stromberg Type "M.B." Carburetor—Claudel—Stewart Metering Pin Type—Scott-Robinson—Rayfield Mixed Type—Multiple Nozzle Vaporizers—Stromberg Two-Jet Type—Novel F. I. A. T. Design—Sauer Economy—Tillotson Two-Jet Type—Ball and Ball Two-Stage Carburetor—Marvel-Buick Carburetor—Krice Annular Spray Carburetor—Master Multiple Jet Form—Utility of Gasoline Strainers—How Kerosene May be Utilized—Holley Kerosene Carburetors—Compound Manifolds—Supplying Kerosene by Direct Injection—Vaporizer Using Water Spray—Bi-fuel Carburetors—Bennett Kerosene Carburetor—Good Kerosene Vaporizer—Partial Combustion Type Carburetor—Fuel Mixing Valve—A Camphor Vaporizer—Pre-heating Fuel—Air Cleaner—Primers for Easy Starting—Vapor Humidifiers—Fuel Economizing Devices—How High Altitude Affects Power—The Diesel System—Intake Manifold Construction—Compensating for Varying Atmospheric Conditions—Disposition of Exhaust Gases—Exhaust Silencers—Ejector Type Exhaust Manifold—Utility of Cut-out Valve Explained—Multiple Exhaust System Advantages 392–482

CHAPTER VII

MODERN ELECTRICAL IGNITION SYSTEMS

Automobile Power Plant Ignition Systems Outlined—Chemical Current Producers—Mechanical Generators of Electricity—Essentials of Battery Ignition Systems—Functions of Timers and Distributors—Operating Principles of Induction Coil—Spark Plug Construction and Action Defined—Advantages of Two-Spark Ignition—Typical Battery Ignition Groups—Low-tension Ignition Systems—High-tension Magneto Forms—Typical Double Ignition Systems . 483–571

CHAPTER VIII

LUBRICATION AND ENGINE COOLING SYSTEMS

PAGES

Reason for Lubrication of Mechanism—Definition of Friction—Theory of Lubrication—Requirements of Engine Oils—Derivation of Lubricants—Classification of Lubricants—Correct Oil Body of Vital Importance—How Viscosity is Tested—Oil Destruction Due to Exposure to Heat—Sight-Feed Oil Cups—Gravity Feed Systems—Mechanical Oiling Methods—Oil Pump Forms—Oil Distribution Methods—Oil Supply by Constant Level Splash System—Saxon Air Lock System—Hupmobile Flywheel Oil Distribution—Distributing Lubricant by Pressure—Function of Oil Pressure Gauge—Regulating Oil Pressure—1917 Pierce-Arrow System—Oiling V Engines—Individual Pump Oilers—Lubrication Don'ts—Why Cooling Systems are Necessary—Cooling Systems Generally Applied—Cooling by Positive Water Circulation—Cooling Action of Radiator—Water-Circulating Pumps—Water Circulation by Natural System—Radiator Location—Cooling Fan Construction—Radiator With Air Shutters—Thermostatic Temperature Regulators—Radiator Construction—Solderless Radiator for Trucks—Direct Air Cooling Methods—Utility of Auxiliary Exhaust Valves—Air Cooled Two-cycle Engine—Blower Cooled Engines 572–630

CHAPTER IX

CLUTCHES AND CHANGED SPEED GEARING

Utility of Clutch and Gearset Defined—Why Clutch is Necessary—Clutch Forms and Their Requirements—How Friction Clutches Transmit Power—Materials Employed to Increase Friction—Forms of Cone Clutches—How Leather Facing is Attached—Securing Easy Engagement—Three-and Five-Plate Clutches—Features of Multiple Disk Clutches—Why Change Speed Gearing is Necessary—Face Friction Gearing—Planetary Gearing—Individual Clutch Transmission—Gearbox Using Silent Chains—How Sliding Gearsets Operate—Progressive Shift—Selective Gear Shift—Four Speed Gearboxes—Change Speed Gear Installation—Unit Power Plant—Combined With Countershaft—Transmission Gear for Four-Wheel Drive—Gas-Electric Systems—Hoadley System—Couple Gear System—Entz Electric Transmission—Magnetic Centrifugal Clutch System—Vulcan Electric Gearshift 631–710

CHAPTER X

THE CHASSIS AND ITS COMPONENTS

Frame Design and Construction—Underslung Frames—Materials Employed in Frame Construction—Tubing—Wood—Steel—Typical Steel Pressed Frames—Raised Frame Side Members—Cambered Frames—Brush Frame—Suspension of Motor Vehicles—Design of

PAGES

Leaf Springs—Common Forms of Springs—Semi-Elliptic Springs—Full Elliptic—Three-quarter Elliptic—Cantilever Springs—Unusual Spring Designs—Quarter Elliptic Springs—Double Springs—Springs Without Shackles—Spring Attachment—Modern Chassis Designs—Adjustable Clutch and Brake Pedals—Universal Joint Types—Spring Plate Universal Coupling—Why Fabric Couplings are Preferred to Steel—How Automobiles are Steered—Steering Gears—Worm and Worm Wheel Reduction—Nut and Rack Types—Lubricants for Chassis Parts—Suggestions for Oiling . . 711–754

CHAPTER XI

FRONT AND REAR AXLES AND BRAKES

Front Axle Types—Steering Knuckle Forms—Power Transmission System—Chain Drive—Bevel Gear Drive—Trend of 1917 Motor Truck Driving Systems—Worm Gear Drive—Internal Drive Axles—Rear Axle Forms—Live Rear Axle—Stationery Axle—Rear Axle Nomenclature—Semi-Floating Axle—Three-Quarter Floating Axle—Full-Floating Axle—Purpose of Differential Gear—Differential Gear Action—Differential Substitutes—Positive Drive Differential—Typical Worm Gear Drive Assembly—Skew Bevel Drive Gearing—Two Speed Direct Drive Axle—Differential Locks—Single Chain Drive—Four Wheel Drive and Steer System—Front Wheel Drive System—Utility of Motor Car Brakes—Forms of Motor Car Brakes—Internal Brakes—External Brakes—Multiple Disc Brake—Front Wheel Brakes—Vacuum Operated Brake—Hydraulic Brake—Anti-Friction Bearings—Ball Bearing Types—Roller Bearing Types 755–829

CHAPTER XII

WHEELS, RIMS AND TIRES

Wood and Wire Wheels Compared—Resilient or Spring Wheels—Steel Disc Wheels—Advantages of Pneumatic Tires—Pneumatic Tire Construction Outlined—Forms of Tire Treads—Tire Protectors and Non-Skid Attachments—Demountable Rim Forms—Features of Cushion Tires—Solid Tire Types—Tools and Supplies for Tire Restoration—Faults of Tires and Their Elimination—Apparatus for Tire Repairing 830–882

CHAPTER XIII

AUTOMOBILE STARTING AND LIGHTING SYSTEMS

Self-starters for Gasoline Engines—Types of Starters—Features of Ignition Starters—Compressed Air Starting Systems—Electric Starting Systems—One Unit System—Two Unit Systems—Function of Generator—Types of Generators—Storage Batteries—Automatic Controls—Circuit Breaker—Governors—Ampere Meter—Auto-Lite Starting System—Delco Starting System—Typical Starting Motors—Automatic Pinion Shift—Overrunning Clutches

PAGES

—Electric Lighting Systems—Bulbs and Lamp Forms—Combination Lamps—Novelties in Electric Lamps—Kemco Fan Generator —Care of the Storage Battery—Battery Charging Methods—Inspection and Care of Generator and Starting Motor—Lamp Troubles and Their Causes 883–925

CHAPTER XIV

MOTOR CAR EQUIPMENT AND ACCESSORIES

Gas-Lighting Appliances and Their Use—Wind-Shield Forms—Shock Absorbers—Bumpers—Speedometers and Mileage Indicators—Tool Equipment for Ordinary Repairs—Miscellaneous Supplies of Value to the Motorist—How Supplies are Carried 926–955

CHAPTER XV

HOW TO DRIVE AND CARE FOR AN AUTOMOBILE

Operating Advice and Explanation of Automobile Control Methods—Utility of Spark and Throttle Levers—Obtaining Various Speed Ratios with Friction Transmission—How Planetary Gearsets are Controlled—Shifting Sliding Gears by Progressive and Selective Systems—Standard Automobile Control Systems Described in Detail—Maintenance Hints of Value—Suggestions for Oiling—Winter Care of Automobiles 956–985

CHAPTER XVI

PRACTICAL HINTS FOR LOCATING ENGINE TROUBLES

Practical Hints to Assist in Locating Power-Plant Troubles—Systematic Detection of Conditions to which Imperfect Operation Can Be Ascribed—Faults in the Ignition System—Derangements of the Carburetion Group and Their Symptoms—Cooling and Lubrication Group Troubles 986-997

CHAPTER XVII

UPKEEP OF CHASSIS, BODY AND UPHOLSTERY

Keeping Up the Motor-Car Chassis—Common Defects of Clutches and Gearsets—Faults in Chain- and Shaft-Driving Systems—Troubles in Front and Rear Axles—Adjustment of Brakes—Care of Miscellaneous Chassis Components—Maintenance of Body Finish, Tops, and Upholstery 998–1011

GENERAL INTRODUCTION

The modern motor car has reached that period in its development where one can safely say that it has become perfected to such an extent that further improvements must be in matters of detail only and not in alterations of essential components. It has been so widely adopted and is used in so many industrial applications that even the most conservative must admit the automobile has ceased to be an experiment and it is a reliable method of transportation that has demonstrated its worth conclusively.

It is said that there are over 8,500,000 motor vehicles in use in the leading countries of the world, and the yearly output of the world's manufactures is approximated at about 1,750,000 cars per annum. Of this number 6,500,000 power-propelled vehicles are used in the United States and the 1919 output of domestic producers is estimated at nearly 1,500,000 automobiles. The enormous demand existing for this practical conveyance has impelled the manufacture of well-developed types of motor cars which can be sold at very moderate prices because they are produced in large numbers. This has resulted in a wide increase in the number of motorists and many who formerly could not afford the higher priced automobiles have become motor car operators because they can maintain the moderate priced cars at present obtainable without too great expense.

The ranks of motorists might be augmented by many who have the means to purchase but who believe that the maintenance cost would exceed that of a horse-drawn conveyance of equal capacity, and the natural impression which prevails that only those well versed mechanically can operate motor cars successfully can be dispelled only by a better understanding of motor car construction. When one takes cognizance of the many vehicles successfully operated by compara-

tively inexperienced persons it is apparent that operating is not difficult, but it is the repairing and maintenance costs that deter many from owning motor cars.

There has been no lack of instruction books or elementary treatise dealing with motor vehicle construction, maintenance or operation, but in these, for the most part, a common error has been made of assuming that the reader had more or less knowledge of mechanics. It is evident that any work which presupposes a certain amount of training on the part of the reader cannot be successfully employed in teaching the rudiments of any science. At the other hand, pamphlets which are too elementary in character cannot convey a practical working knowledge because so much is left for the motorist to learn after he has grasped the main principles underlying the design. Many business or professional men do not possess even an elementary knowledge of mechanical principles, and as this class forms the largest proportion of the motoring element, in defining the basic principles of an automobile, it is necessary to use simple exposition that oftentimes appears to be elementary to the student or engineer well versed in the subject under discussion.

In the present work the writer will endeavor to define the essential elements of the modern gasoline motor car, and after explaining the basic principles upon which the successful use depends, it is proposed to describe actual forms and typical mechanisms so that their practical application and the relation the various parts bear to each other can be easily understood. It is obvious that familiarity with the machinery of an automobile will enable the operator to give intelligent attention which will insure the longest life and minimum operating expense.

It is believed that a systematic and logical arrangement of the subject will enable the reader to gain an understanding of the functions of each part, and the typical groups of mechanism illustrated

and described should make for a better understanding of the various parts as they actually are in the leading automobiles. While it has been the practice in works of this character to include a general exposition of all types of self-propelled conveyances, including gasoline, steam, and electric automobiles, in the present instance, matter relating to the steam or electric motor car will not be given. The writer will discuss only those automobiles in which the gasoline engine or hydro-carbon motor is utilized as a prime mover.

The omission of the historical matter which usually prefaces a work of this character may be criticized as well as the elimination of many machine details that are commonly presented chiefly because of their value in showing progress made. As the science of automobile engineering has reached that point where radical departures from the conventional or standard construction are not considered with favor, it is safe to assume that the era of standardization and stability of design is at hand.

The repair hints and suggestions given for maintenance and equipments are based on a wide practical experience which dates since the inception of the industry as a designer, repairer, and operator of motor vehicles, and should be of exceptional value to those who have not had an opportunity to become familiar with automobiles but who can apply the experience of others to good advantage. More detailed information on automobile repairing may be secured from a special treatise that is a companion volume to this one, "Automobile Repairing Made Easy." Price $3.50, and published by the same publishers as this book. The hints given in this volume are only intended for the owner-operator, or chauffeur, not the expert repairman.

THE AUTHOR.

July, 1921

THE
MODERN GASOLINE AUTOMOBILE

CHAPTER I

MOTOR-CAR TYPES, THEIR PARTS AND FUNCTIONS

Defining Trend of Modern Practice—Explaining Components of Motor Cars and Considering Functions of Each Group of Mechanism—Parts of Typical Pleasure Car Chassis—Assembling Typical Chassis—Arrangement of Truck Parts—Wind Resistance and Body Design—Classification of Motor Car Types—Standard Body Nomenclature—General Trend in Pleasure Car Bodies—Detachable and Permanent Top Types—Four-Passenger Roadsters—New Body Designs and Seating Arrangements—Body Dimension Data—Motor Truck Design Tendencies—Three-Wheel Tractor—Four-Wheel Tractors—Trailer Types—Two-Wheel and Four-Wheel-Drive Trucks—Light Cars and Cyclecars—Agricultural Tractors and Truck Tractors—Automobile Plow—Farm Tractors—Armored Automobiles—Mobile Repair Shops—Ford Truck Conversion Sets—Combination Gasoline-Electric Car—Drawbar Pull of Motor Trucks—How to Use Chart—Grade Determination.

DURING the past decade great progress has been made in all branches of engineering and science. This is especially true in mechanics, and one of the most notable achievements has been the advancement of the self-propelled vehicle from a crude and unsatisfactory construction to one of great refinement and practicability. In ten years the growth of the automobile industry stands unparalleled in the industrial history of the world. One familiar with the improvement of the motor conveyance during that time and who remembers the early types marvels at the refinement of detail and the changes in design which exist in the vehicles of the present day. The modern gasoline automobile fills every need as it is comparatively light, powerful enough for all road conditions, easily controlled and capable of running for thousands of miles without adjustment of the mechanism. It surpasses the powerful locomotive in speed and reliability, and has a radius of travel greater than any other conveyance.

There are numerous standard principles upon which motor-car

construction is based, and some of these differ from each other radically, both in theory and practice. Many constructions, if looked at from a purely academic point of view, will appear to possess advantages which cannot be questioned, though on further consideration a car of apparently inferior design which does not have the same method of accomplishing a like object may be a better seller and a more popular car among motorists.

The tendency of the motor-car designer of the present day is toward simplicity and increasing efficiency of the mechanism. There are many rules of practice leading to this end generally known to engineers, though not accepted by all as the best methods of construction for motor vehicles. It is the writer's purpose to review all the types of the various automobile components that have merit, and the qualities of each design will be given as stated by those favoring it. This is not intended as a criticism, but to enable the motorist not informed regarding details of motor-car building to make intelligent comparison with other forms.

Within the last few years the design of automobiles has been considerably changed, and the difficulties that previously retarded development have been for the most part eliminated by modern automobile engineers. This gradual modification of the automobile from a crude mechanism to a practical product has been attained without radical changes that many confidently forecasted at the inception of the industry. The essential elements of the motor car of to-day remain practically the same as far as basic principles of design are concerned, as those which formed the basis of the first motor car. Only the details have been changed and the forms which have resulted from the gradual process of evolution show a steady tendency toward uniformity of design.

Important Components of Modern Motor Cars.—In this era of progress, one would hesitate to assert that the motor car had been perfected or that it had reached a finality in design, though the experience of the last few years would justify one in assuming that the principles of construction now applied so successfully may reasonably be considered permanent. The elements which have been proven essential to insure successful operation of all self-propelled conveyances may be easily defined as follows:

First: The endeavor of modern constructors is to make all operating parts of such material, size, and strength, that the severe strains imposed by the rough nature of the average road surface will be resisted adequately and to secure endurance and serviceability under all possible conditions of operation.

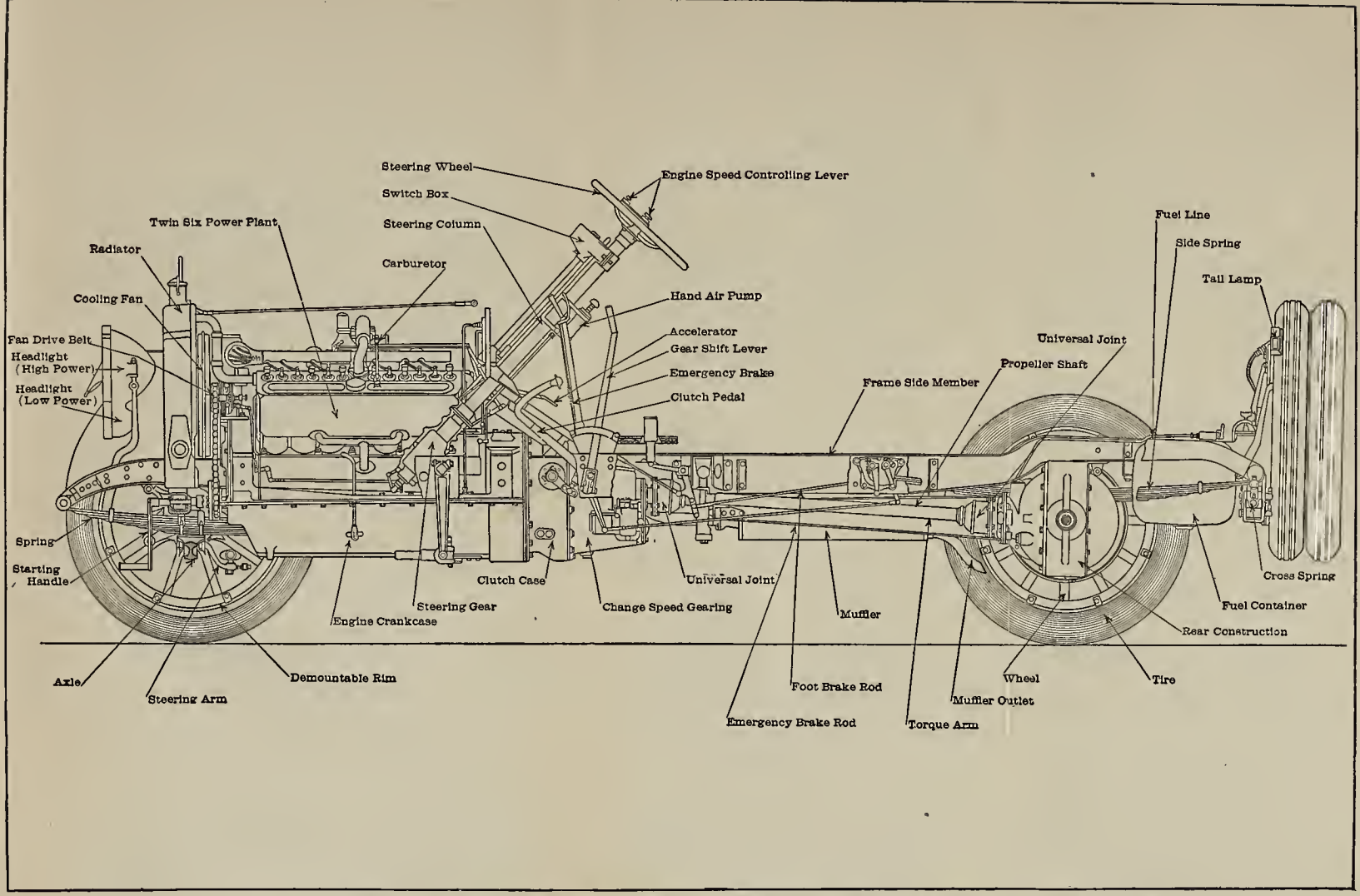


Fig. 1—Side View of Packard Twin-Six Chassis, Showing Important Parts and Mounting of Gear Box with Motor to Form Unit Power Plant.

Second: The mechanism should be as simple as it is possible to make it, as this promotes ease of repairing, facility in handling, and lessens the liability of trouble by reducing complications. The parts should be in proper proportion and arranged in such a manner relative to each other that one may be removed or replaced without disturbing other correlated appliances.

Third: The power furnished by the gasoline motor carried in the frame must be transmitted to the traction wheels or to the revolving shafts to which they are fastened with as little friction and power loss as is possible.

Fourth: The driven wheels (usually the rear ones, though four-wheel drives are sometimes found) must be connected to some form of compensating or balance gear which enables each wheel to revolve independently of the other at times and at different velocities, because in turning corners the outer wheel describes a larger arc and consequently a longer path than the inner member. The differential gear was one of the most important elements which made for the successful development of the automobile.

Fifth: The steering in most cases should be done by the two front wheels which are carried at the ends of a yoke axle which is securely fastened to the chassis frame by means of the springs. The wheels are carried on steering knuckles which must be arranged to assume different angles when the vehicle is turning corners or deviates from a straight path in order to secure positive steering. On four-wheel drive commercial cars all wheels are sometimes used for steering.

Sixth: Springs must be provided, which will have sufficient strength and elasticity to neutralize vibration and allow for unevenness of the road surface by their yielding qualities and thus reduce body movement. In order to relieve the machinery, running gear and passengers of the inevitable vibration which obtains at even moderate speed on ordinary roads the wheels should be provided with very resilient tires, preferably of the pneumatic or inflated forms for pleasure cars, and cushion or solid rubber on the heavier and slower moving motor trucks.

Seventh: The gas supply to the motor, the ignition of the charge, and the continuation of the engine cycle of operations should be automatic and require no attention from the operator after the motor is once started. To secure continued operation, mechanical means must be provided for constant lubrication of all moving parts. All components which have movement relative to other parts should move with as little power loss by friction as possible, in order to conserve the available motor energy for tractive purposes. Anti-friction bear-

ings of the ball or roller type should be employed on all rotating shafts in the power plant, transmission system, and in the wheels to save power.

Eighth: The center of gravity must be carried relatively low, which involves placing the body as close to the ground as practical considerations will permit. The wheel base, which is the distance between front and rear wheel centers, should be long, in order to secure the best result in tractive effort, steering, and comfortable riding. The power plant and other essential mechanism should be carried on a frame which will be supported in such a manner that road shocks will not be transmitted to them and so coupled together that no frame distortion will produce disalignment of the driving shafts.

Ninth: The control elements must be designed with a view to easy handling. This means that the steering gear should be irreversible—i. e., the hand wheel should not be affected by side movement of the front wheels, thus relieving the driver's arms of all undue strain while driving. Motor regulation should be by levers placed convenient to the driver's hands or feet, and gear shifting should be accomplished without difficulty. Powerful brakes must be employed to insure positive check of vehicle motion whenever it is desired to bring the conveyance to a stop. It is evident that the levers through which the brakes are operated should be so proportioned that a minimum of effort on the part of the operator will serve to check the vehicle immediately. Electric engine starting systems should be fitted.

Division of Motor-Car Mechanism in Groups.—In order to deal systematically with the subject of motor-car construction, one may divide the essential mechanism into groups and treat each of these assemblies in detail. In order to understand the functions of the various parts, views of typical pleasure and commercial car chassis, with all components clearly indicated, are presented in Figs. 1 to 7. These show conventional arrangements of parts in vehicles which are adapted to a wide range of work. Of the many elements comprising the automobile, the source of power is the most important. Then comes the method of power transmission, and last the various chassis parts which have to do with suspension, control, etc.

By referring to illustrations, which show the construction of typical gasoline car chassis so clearly, the functions of the various parts and their relation may be easily understood. The basis of any conveyance, whether animal drawn or power propelled, is a running gear. This consists of a frame supported on springs which rest on the axles, which in turn carry the wheels on which the whole assembly can roll

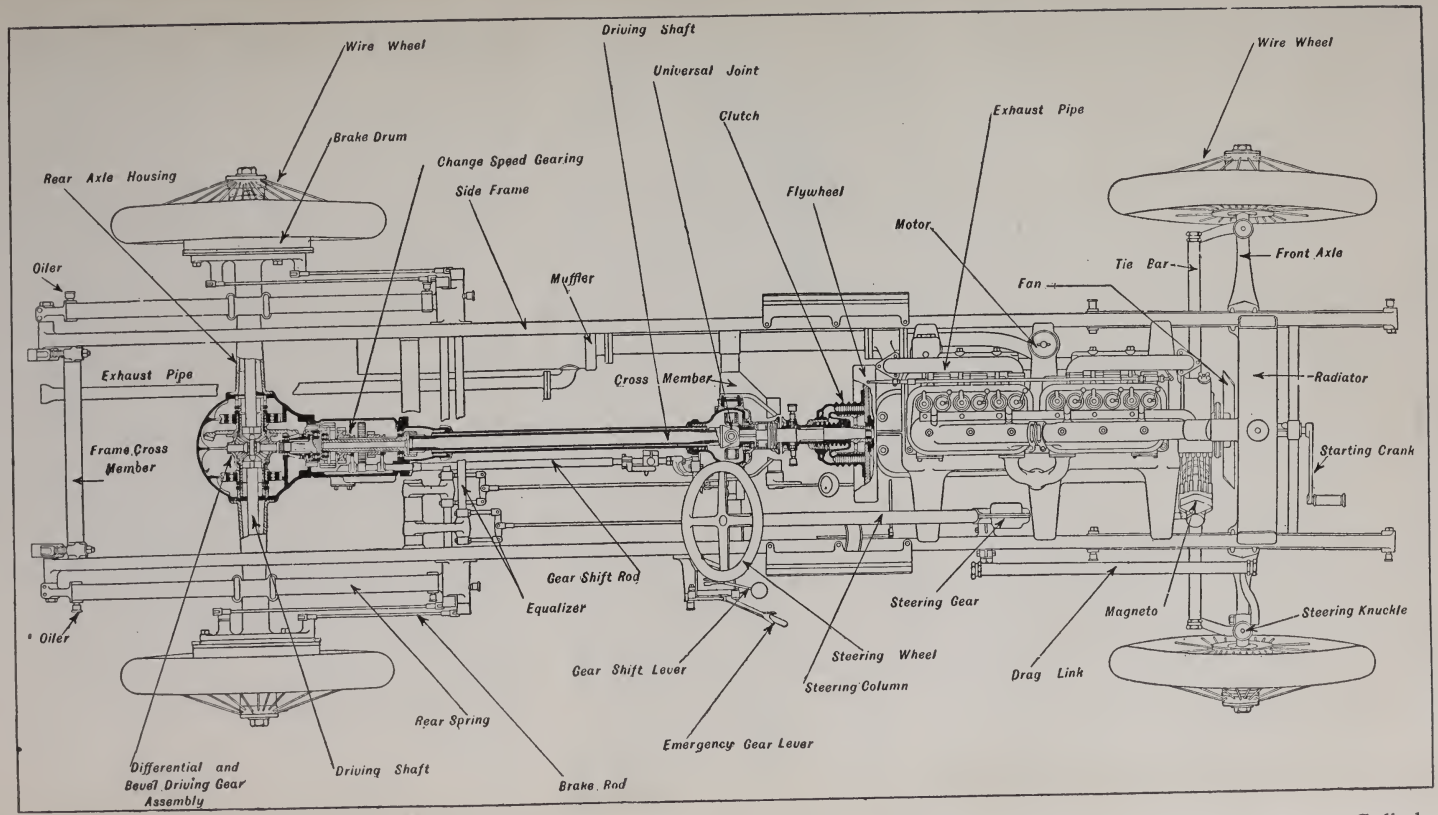


Fig. 2—Plan View Depicting Important Parts of a Prominent English Pleasure Car Chassis, in Which Power Is Furnished by a Six-Cylinder Internal Combustion Engine.

over the ground. In the horse-drawn carriage where there is no necessity for a heavy or strong supporting frame, because of the light weight of the body it is possible to attach the springs directly to the sills on which the body rests. In a motor vehicle, however, the frame is usually separate from the carriage work, because it is often necessary to remove the body to gain access to some portion of the mechanism which may need attention. The frame of an automobile must be strong, because the engine and parts of the transmission system are installed thereon, and also because the speed possibilities of the automobile make it necessary that the frame be of sufficient strength to resist the stresses due to car movement when driven over uneven road surfaces. These strains are not present in other forms of conveyances. The locomotive which is capable of high speed and which is very

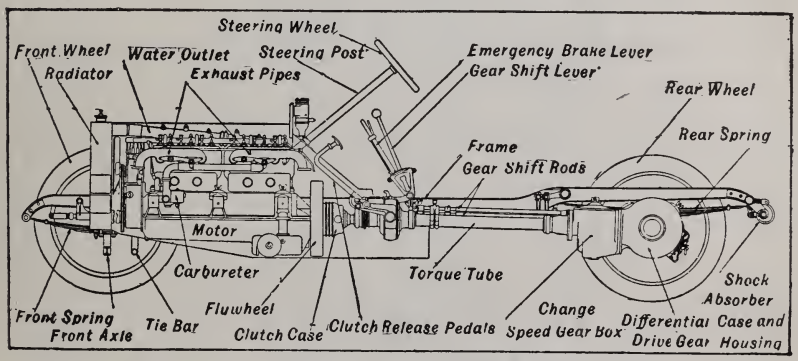


Fig. 3.—Side Elevation of Sheffield-Simplex Six-Cylinder Chassis, a Typical Design of English Derivation.

heavy, travels on a smooth track, while ordinary horse-drawn carriages are not affected materially by the roughness of the path on which they travel because of their low speed and light weight. In the frame, or chassis group, one may include the main frame, subframe, steering gear, clutch and brake pedals, hand levers for varying change speed gear ratios, and applying emergency brakes; the front axle and its steering connections, the driving axle and brakes, the wheels, the tires, and the springs which form a yielding connection between the axles and the frame.

The power plant of a gasoline automobile is composed of a number of distinct devices of which the engine proper is the most important, though all of them are necessary to insure practical operation. In order to describe power plant construction logically, it may be divided into six distinct assemblies, each of which may be resolved into the various parts of which they are composed. The most im-

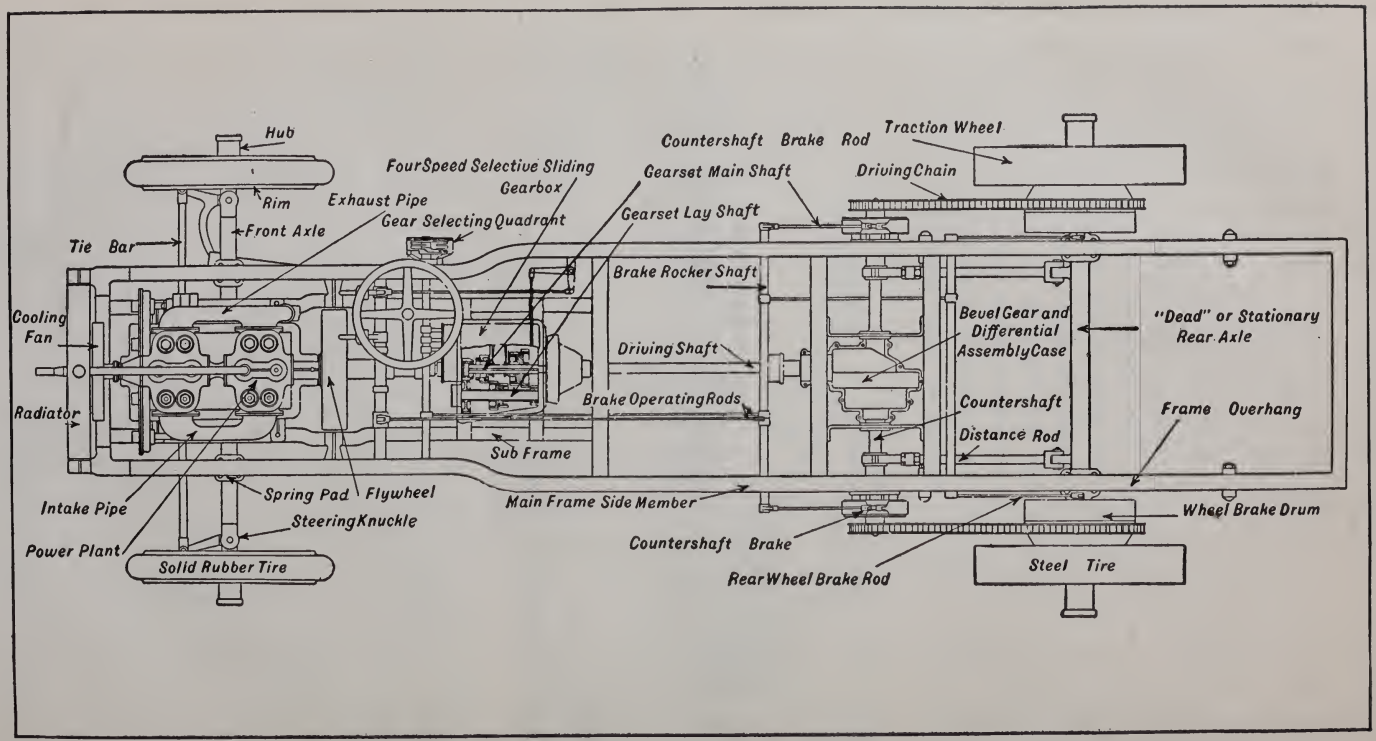


Fig. 4—Plan and Side Elevation of Heavy Commercial Truck Chassis of Foreign Design, Showing Essential Elements and Their Location in the Frame.

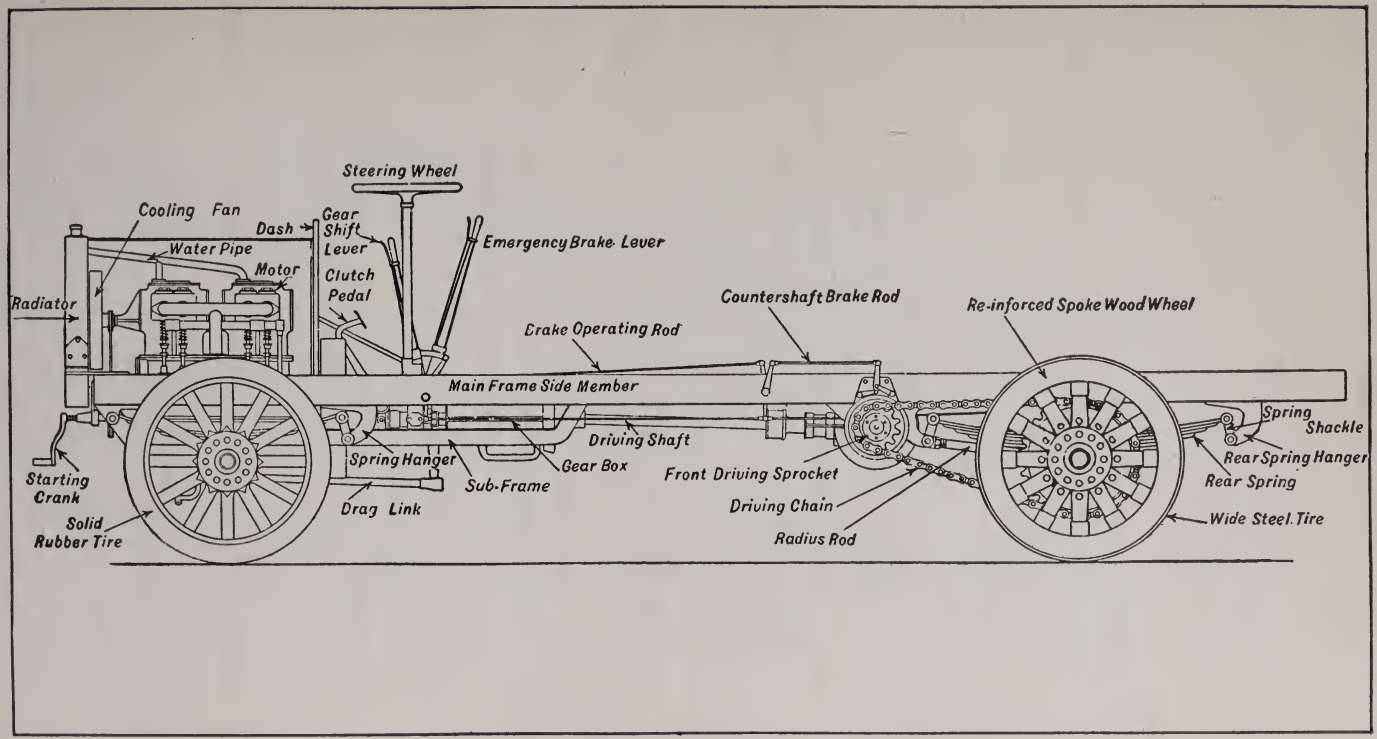


Fig. 4—Continued.

portant assembly is the motor; then the gas-supply system, the ignition apparatus, the devices used for lubrication, the system of cooling, and the muffler assembly.

The power transmission mechanism is the next group of importance. In this assembly one places the clutch, the gearset, the driving means, and, in most instances, the rear axle and traction members.

Arrangement of Parts Varies.—In the conventional car the motor is usually placed at the front end of the frame, and the various auxiliary devices are grouped around it. This is the modern method of power plant placing, but even now there are cars used in which a horizontal engine is placed longitudinally in the frame parallel with the side members. This arrangement was formerly more popular than it is at present, because it permitted a simple method of power transmission by use of single driving chain. The final drive to the rear wheels may be by means of shaft and universal joint connection, as shown at Figs. 1 and 2; this being the common arrangement on pleasure cars; or by means of a combination of shaft and chains sometimes used on commercial vehicles. This form of drive is shown at Figs. 4, 5, and 6. The power delivered by the motor crank shaft is transmitted to a countershaft which is placed across the frame by means of a shaft, and from each end of these countershafts the energy is delivered to the rear wheels by chain and sprocket connection.

There are many other variations in arrangement of parts which will be described in proper sequence. The examples mentioned are given merely to show that the essential elements may be placed at various points in the frame without impairing their utility. The complete frame assembly, including power plant and exclusive of the body or other carriage work, is usually termed a "chassis." There is no marked difference between pleasure or commercial vehicle construction. The same essential elements are incorporated in both, though obviously the parts of a conveyance intended for industrial transportation are made much heavier because of the severer duties they perform than those employed in pleasure cars which, nevertheless, may have much greater power.

Parts of Typical Automobiles and Their Functions.—A brief explanation of the function of each part of the gasoline car chassis depicted at Fig. 1 will serve to afford a better understanding of the construction of an automobile. The purpose of the front axle is not unlike that of a horse-drawn vehicle, but it is much different in construction. The wheels are installed on movable spindles, or steering knuckles, which are supported by yokes permitting one to move the

wheels for steering rather than turning the entire axle on a fifth wheel, or jack-bolt arrangement, as in a horse-drawn vehicle. This axle is attached to the frame by spring members which allow a certain degree of movement without producing corresponding motion of the frame.

The radiator, which is placed directly over the axle in front of the motor, is employed to hold the water used in keeping the engine cool and is an important part of the heat-radiating system. The starting handle is a crank by which the motor crank shaft is given sufficient initial movement by the operator to carry the engine parts through one or more portions of the cycle of operations, this starting the engine. The tiebar joins the arms of the steering spindles on which the wheels revolve, and insures that these will swing together and in the same direction, either to the right or left. The steering link, often called the "drag link," connects one of the steering knuckles of the front axle with the steering gear.

The motor may be one of the many forms to be described and one of two distinct types. The dash is a wooden or metal partition placed back of the power plant to separate the engine from the seating compartment. It is often employed to support some of the auxiliary apparatus necessary to motor action or some of the control elements. The clutch is a device operated by a pedal, which permits the motor power to be coupled to the gearset and from thence to the driving wheels, or interrupted at the will of the operator. It is used in starting and stopping the car and whenever the change speed gears are shifted. The accelerator is a small pedal which actuates a valve on the gas-supply device to permit more explosive mixture being fed to the engine when it is desired to increase the motor speed. Its function is comparable to that of the throttle of a steam engine. The pedals are foot-operated levers; one of which releases the clutch, the other applies the running brakes. The motor control levers on the steering column are used in conjunction with the accelerator to vary the rotative speed of the motor and thus regulate the energy produced in proportion to the work to be performed. The emergency brake lever applies a powerful braking effect when it is desired to stop the car quickly and also when one wishes to lock the brakes if car movement is arrested on a down grade. The change speed lever operates the sliding gearing, which is utilized to produce varying ratios of velocity between the engine shaft and the rear wheel. The steering wheel actuates the mechanism which moves the wheels to the right or left when one wishes to describe the circle, turn a corner, or otherwise deviate from a straight line.

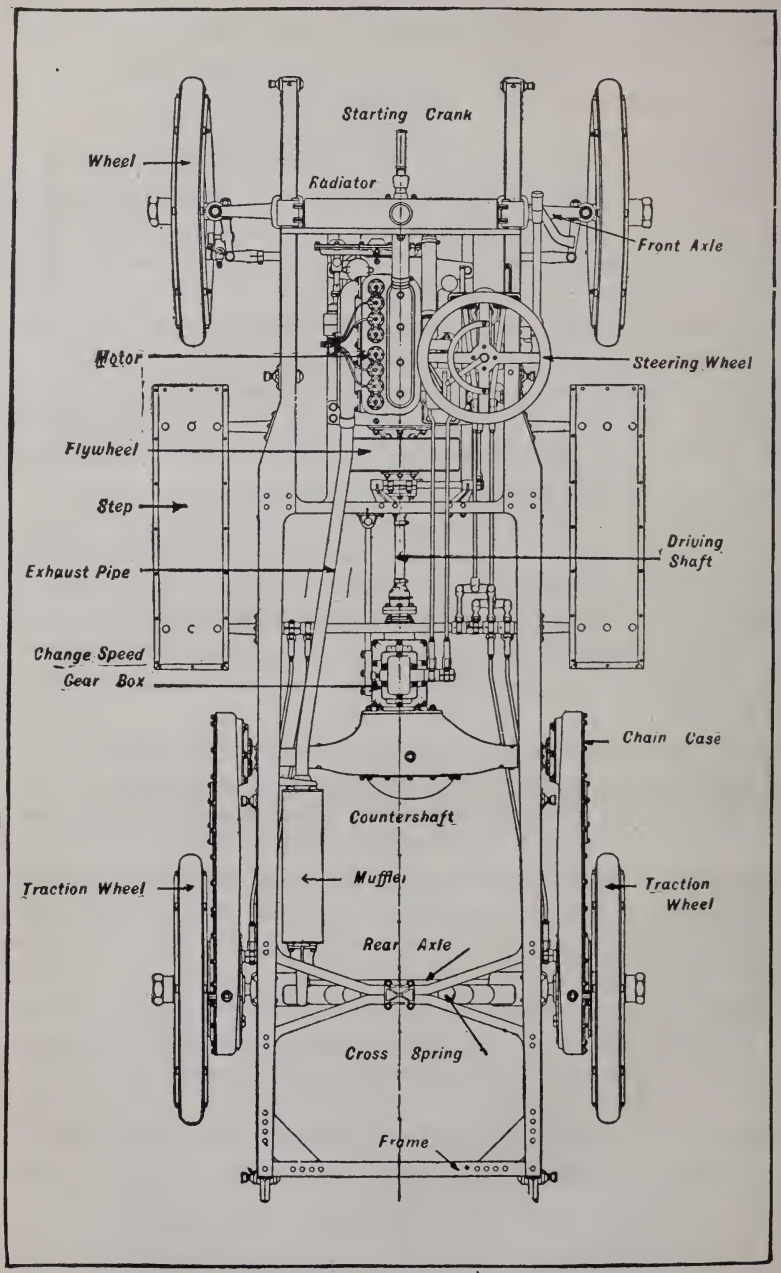


Fig. 5.—Plan View of Light American Motor Truck Chassis.

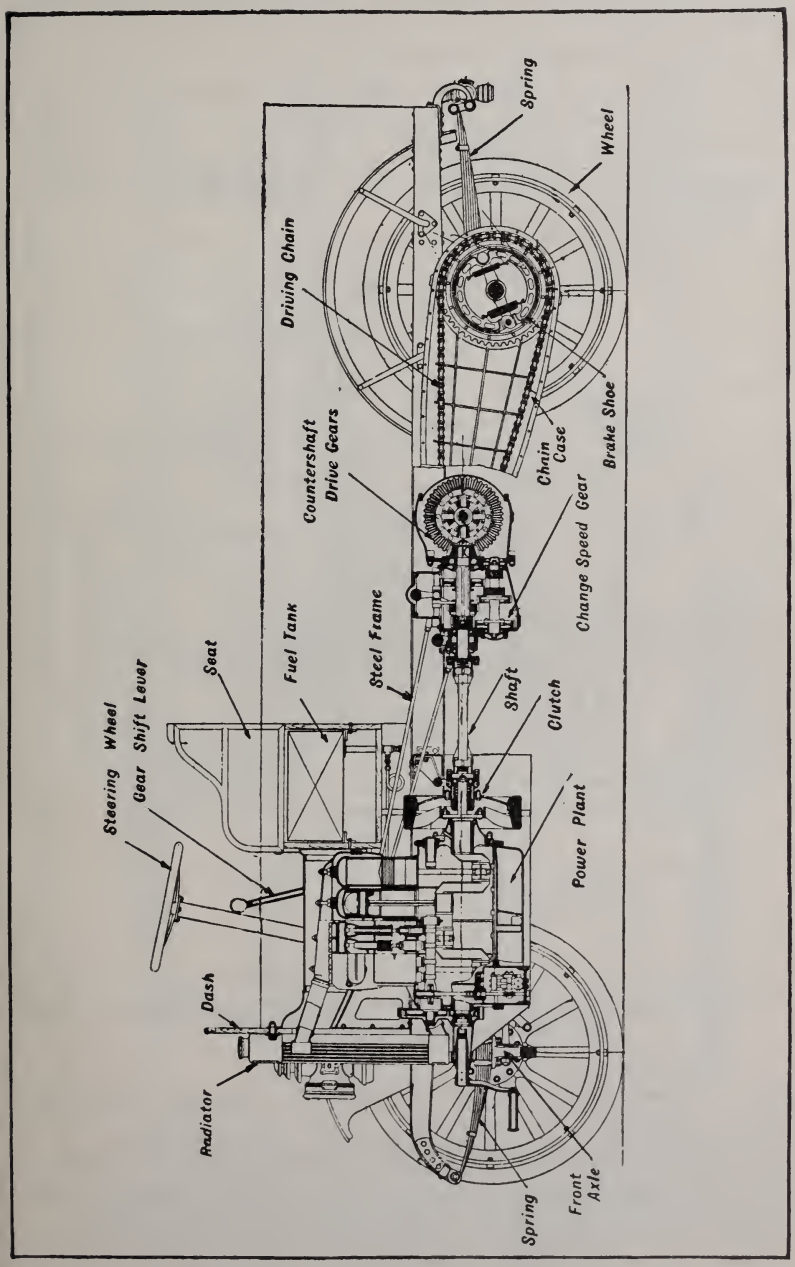


Fig. 6.—Side Elevation of Light Truck Chassis, Showing Important Mechanism.

The change speed gear is one of the most important elements of the power transmission system and in connection with the clutch it is much used in operating and controlling the vehicle. The function of the frame has been previously described. The exhaust pipe is employed to convey the inert gases discharged from the motor cylinders to a device known as the muffler which is designed to reduce gas pressure by augmenting the volume and thus diminish the noise made as

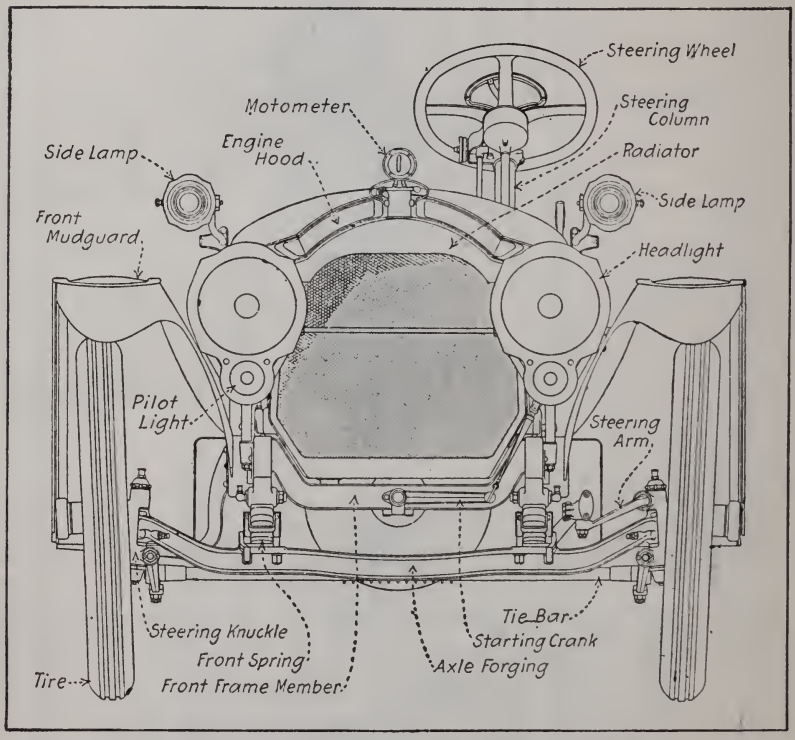


Fig. 7.—Front View of Typical 1917 Pleasure Car Chassis, the Packard Twin Six, with Important Parts Outlined.

it issues to the atmosphere. The driving shaft transmits power from the change speed gearset to the bevel gearing in the rear axle.

A universal joint is a positive connection which permits a certain degree of movement between two shafts which must be driven at the same speed. One or the other, or both, may move in a lateral or vertical plane to a limited extent without interrupting the drive or cramping the moving parts. The rear construction houses the differential and driving gears, and the shafts or axles which transmit the power

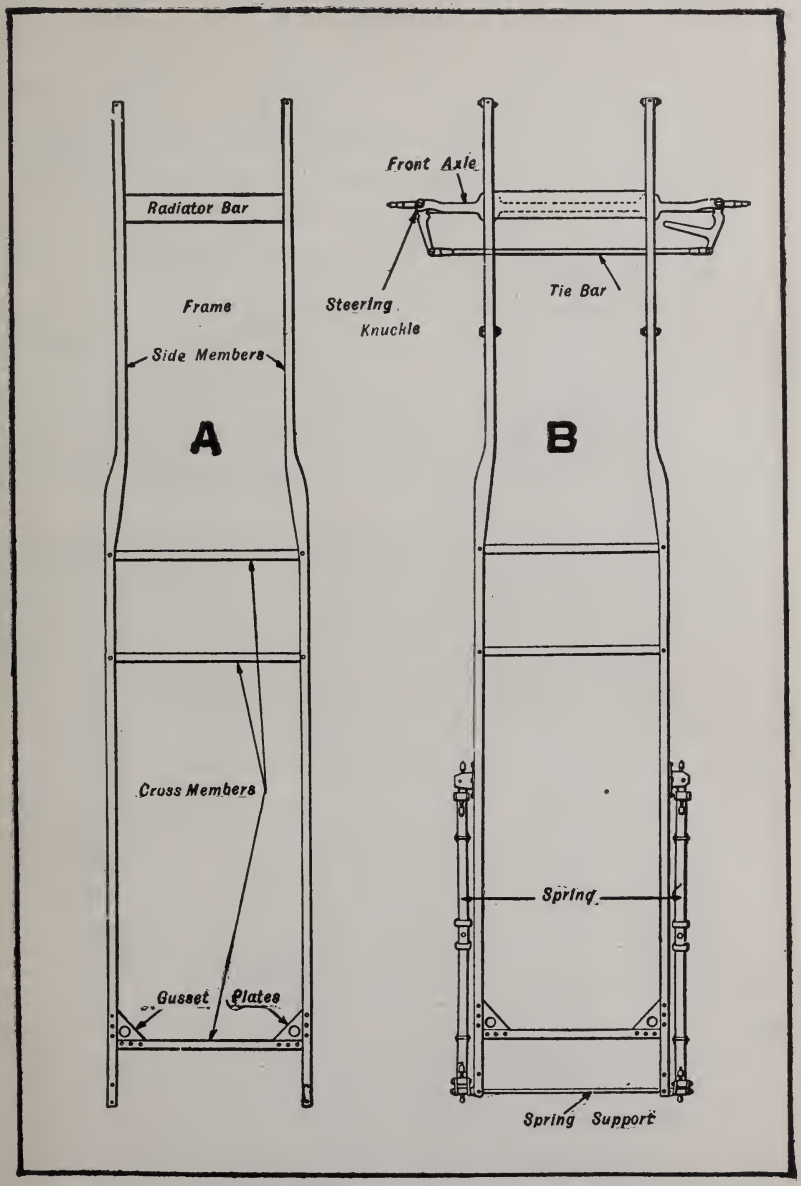


Fig. 8.—Showing Typical Pressed Steel Frame, which Forms the Foundation of a Modern Gasoline Automobile Before Placing Parts of the Mechanism.

to the traction wheels. Brakes are used to retard, or stop, the movement of the wheels, and are operated by rods which transmit the force the operator applies at the brake pedal or hand lever to the brake band. Torque members are used to maintain a definite relation between the driving gears in the axle and those in gearset, and to take the driving thrusts off the axle and the strains imposed by braking and driving from the springs. The principles underlying operation of each of the parts shown and the number of different forms in which they may exist, will be described more extensively in the chapters dealing fully with the various groups.

Assembling Typical Chassis.—The parts which compose the modern automobile and their relation to each other can be very easily ascertained and understood by even those deficient in mechanical knowledge, by consulting Figs. 8 to 13, inclusive. These show the various steps in assembling a typical American car, and have been prepared by the Locomobile Company to show the ease with which their cars may be assembled, or dismantled.

At Fig. 8, A, is shown the bare pressed steel frame which forms the basis of practically all motor cars, before any of the other parts have been added to it. It will be seen that it consists of two side members of pressed steel, these usually being a channel section. The two side members are joined by a series of four cross pieces. The wide one at the front end serves to support the radiator and the starting crank. The two which are placed a little forward of center in the chassis are utilized to support the change speed gear case. The rear cross member is employed solely as a bracing piece, and is reinforced by two triangular gusset plates. All the frame members are securely joined together by steel rivets. It will be noticed that the front end of the frame is narrower than the rear portion. This is to permit the front wheels to assume a more abrupt angle than would be the case if the frame bars were not cambered. This permits one to maneuver the car more easily in narrow streets because it permits one to turn more briskly.

At Fig. 8, B, several parts have been added to the frame. The front springs have been attached directly under the front end, and the front axle has been installed and fastened to the springs by means of clips. The supporting springs at the back end as well as the front and rear shackles or hangers have also been installed. Attention is called to the method of supporting the rear ends of the rear springs by a through bar which passes through the two side members, serving very effectively as an additional brace.

The illustration at Fig. 9, C, depicts the chassis after the headlight

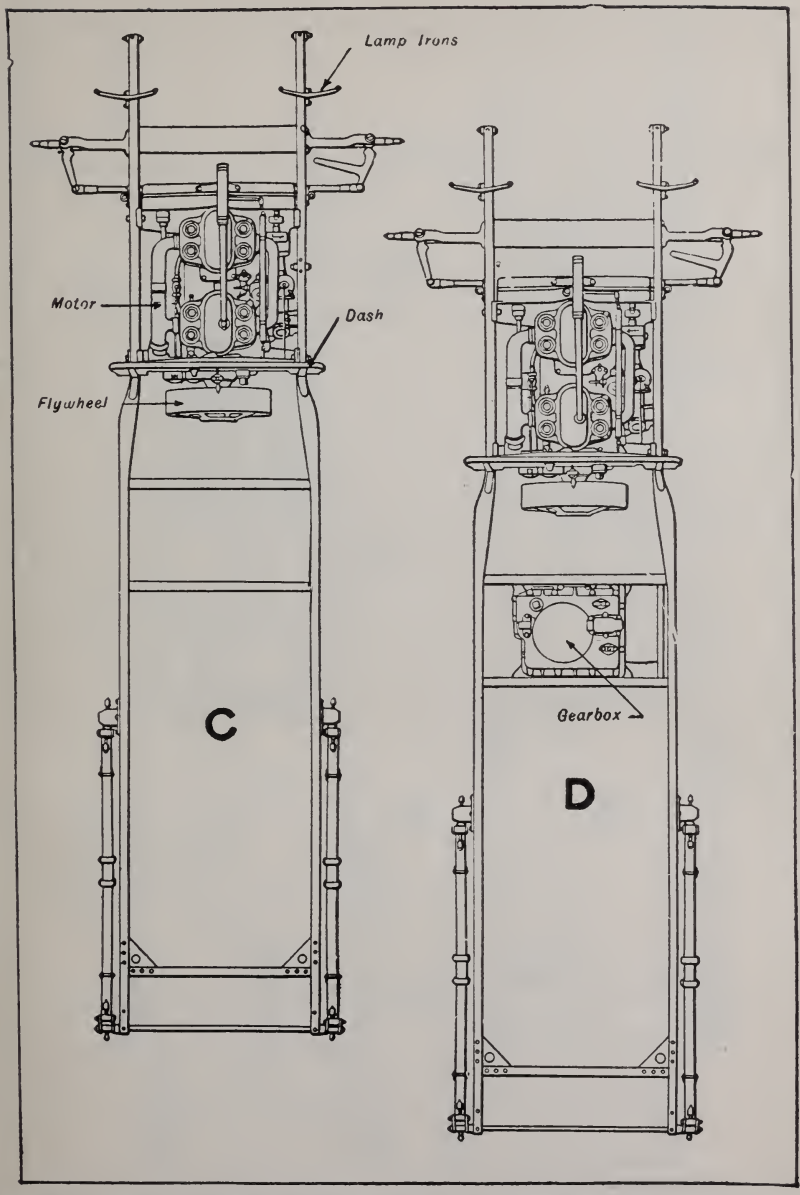


Fig. 9.—Views Detailing Further Steps in Assembling Typical Gasoline Car Chassis Showing Location of Motor and Gear Box.

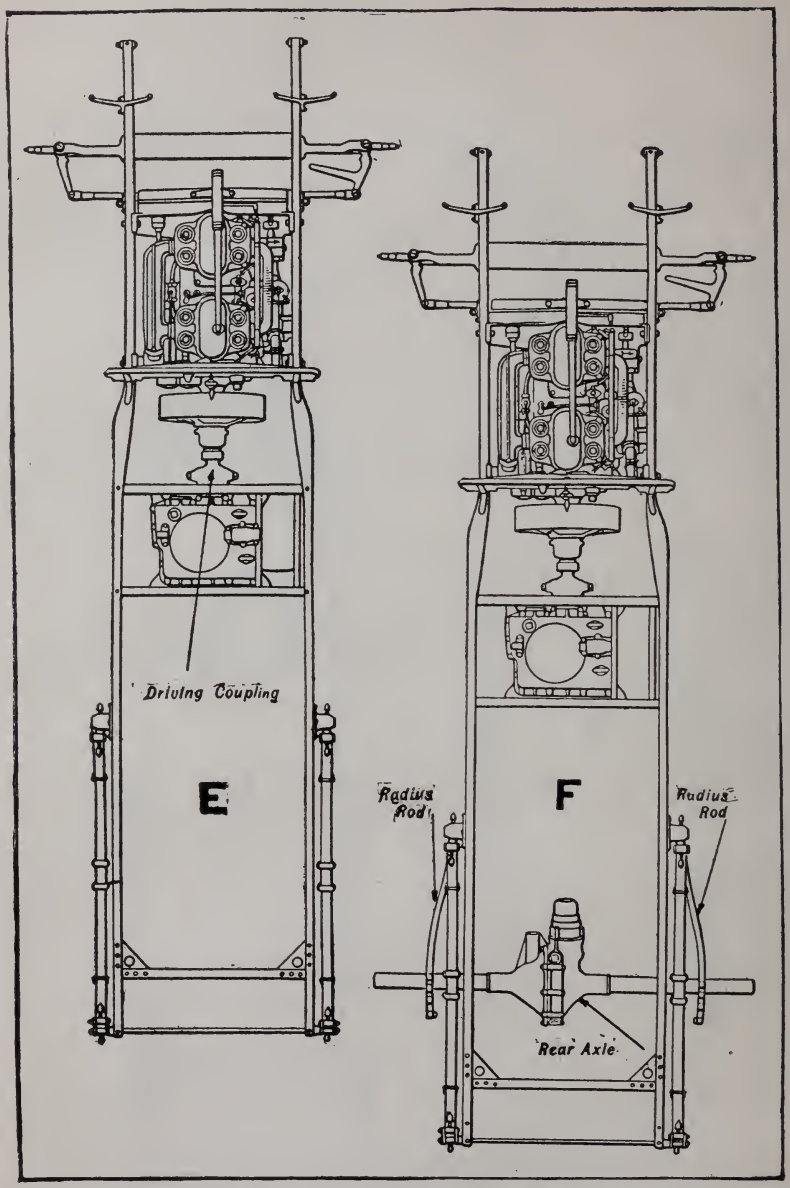


Fig. 10.—How the Pleasure Car Chassis Looks with the Rear Axle Installed and Gearset Coupled to the Engine.

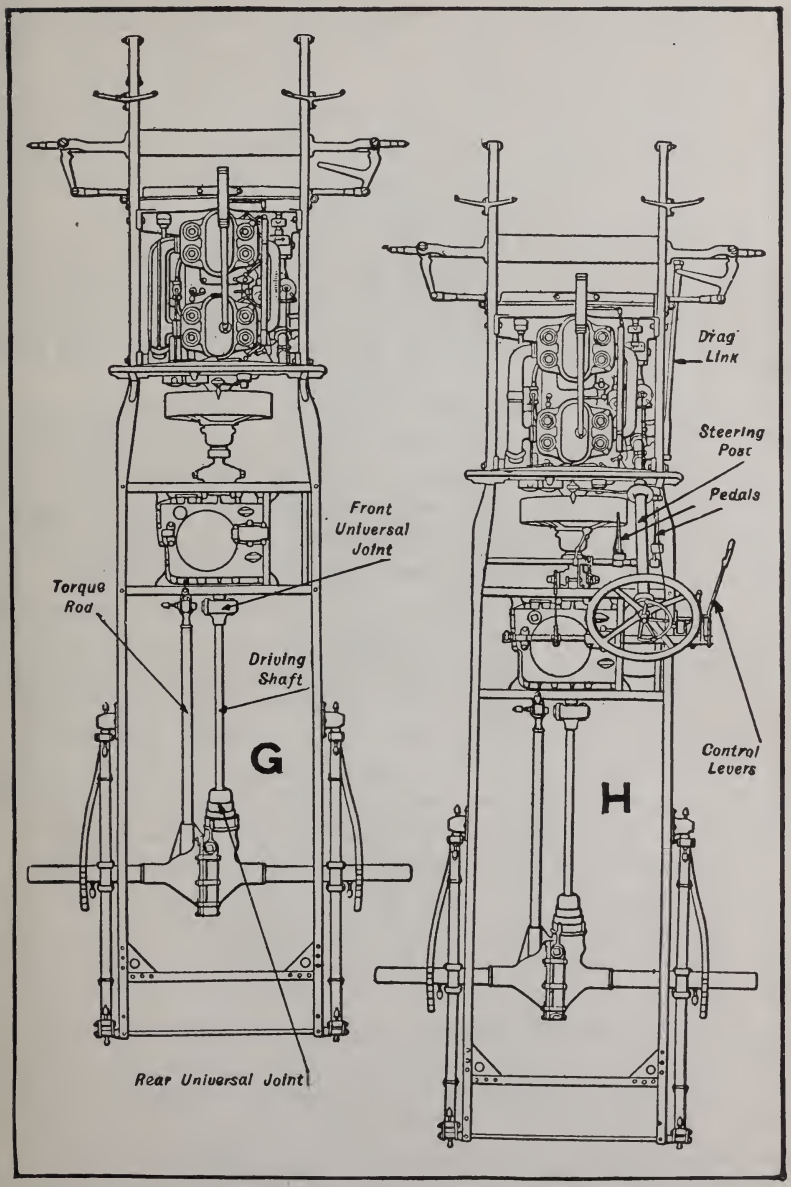


Fig. 11.—After Driving Shaft, Steering Gear, Torque Rod and Control Levers are Added the Chassis Begins to Assume a Finished Appearance.

supporting brackets, or lamp irons, the motor or complete power plant and the dash have been placed in their proper positions. The appearance after the change speed gear box has been fastened to the two center cross members is shown at D. It will be noted that the power plant is attached directly to the frame side members by means of arms or lugs extending from the engine base. These are firmly bolted to the frame sides and the motor bed forms a very strong member which serves to keep the two sides of the frame together.

The views at Fig. 10 show further steps in the process of making a motor car. At E, the motor fly wheel has been joined to the gear box by means of a clutch and driving coupling. At F, the rear axle has been bolted to the springs and the radius or distance rods have been installed.

At Fig. 11 the chassis begins to assume a more finished appearance. Referring to G, it will be seen that the gear box has been connected to the rear axle by means of a driving shaft which has a universal joint at each end. The torque rod, which is a member designed to resist braking and driving torque stresses and to maintain a fixed distance between gear box and rear axle, has been put in place. At H, the steering post, on which are placed the motor control levers and steering wheel, has been fastened to the frame side member and the steering mechanism has been joined to the front axle by the drag link. The gear shift and emergency brake levers have also been placed.

Inspection of Fig. 12 will show the radiator and cooling fan on the extreme front of the frame, almost directly over the front axle, and that the power plant has been joined to the radiator by a piece of rubber hose. The exhaust pipe and muffler have also been fitted.

The appearance of the complete chassis, ready to receive the body, is shown at Fig. 13. The parts added are clearly indicated. The front axle has been made complete by the addition of the wheels and tires. The rear construction has also been finished by supplying the traction wheels, tires, and brake drums. The brakes have been connected to the operating pedal and lever by rods; and step hangers, which support the running boards, have been riveted to the frame sides. The chassis, as shown at Fig. 13, is made a finished car by the addition of a suitable body, gasoline tank, sheet metal under-pan to protect the mechanism and mud guards which extend from both extremities of the running board to the front and rear, respectively, over the wheels to protect the body from mud thrown by the wheels.

Wind Resistance and Body Design.—The reader who studies closely modern motor-car design will see that the bodies which are popular at the present time are of different form than those which were for-

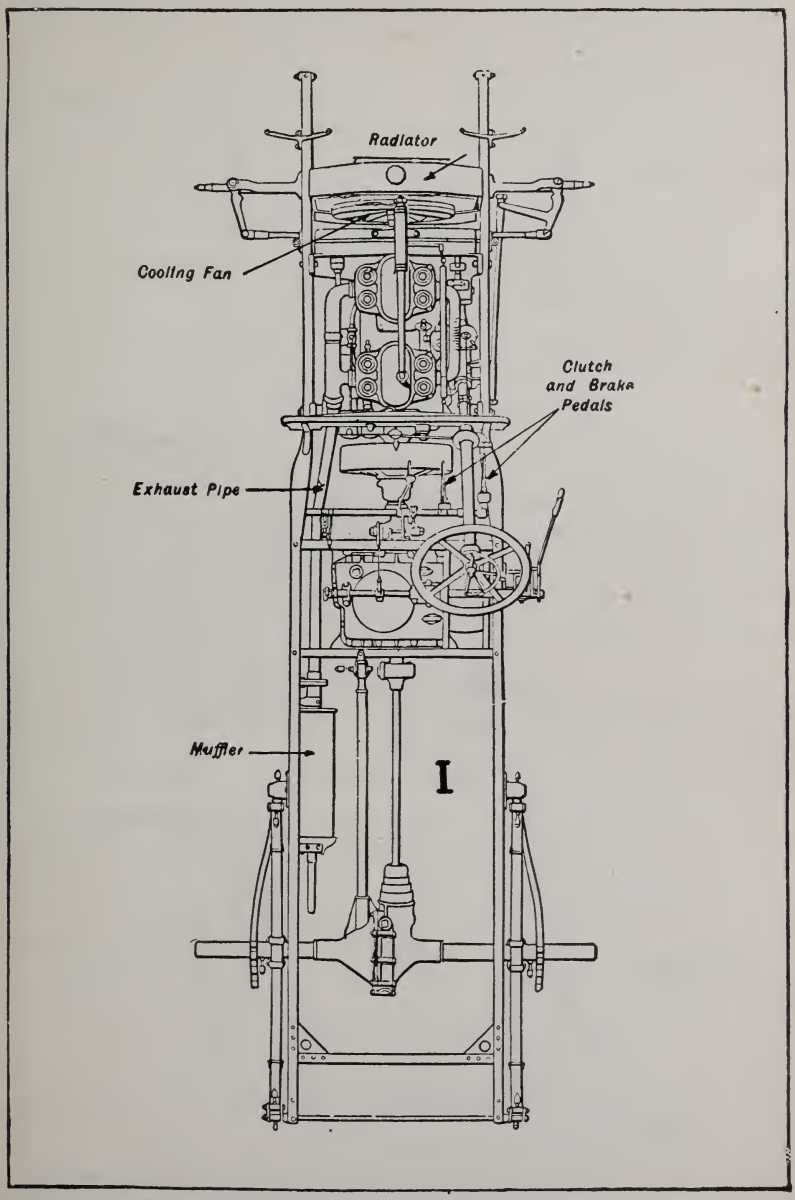


Fig. 12.—Plan View of Chassis when Radiator, Cooling Fan and Muffler Have Been Put in their Proper Places.

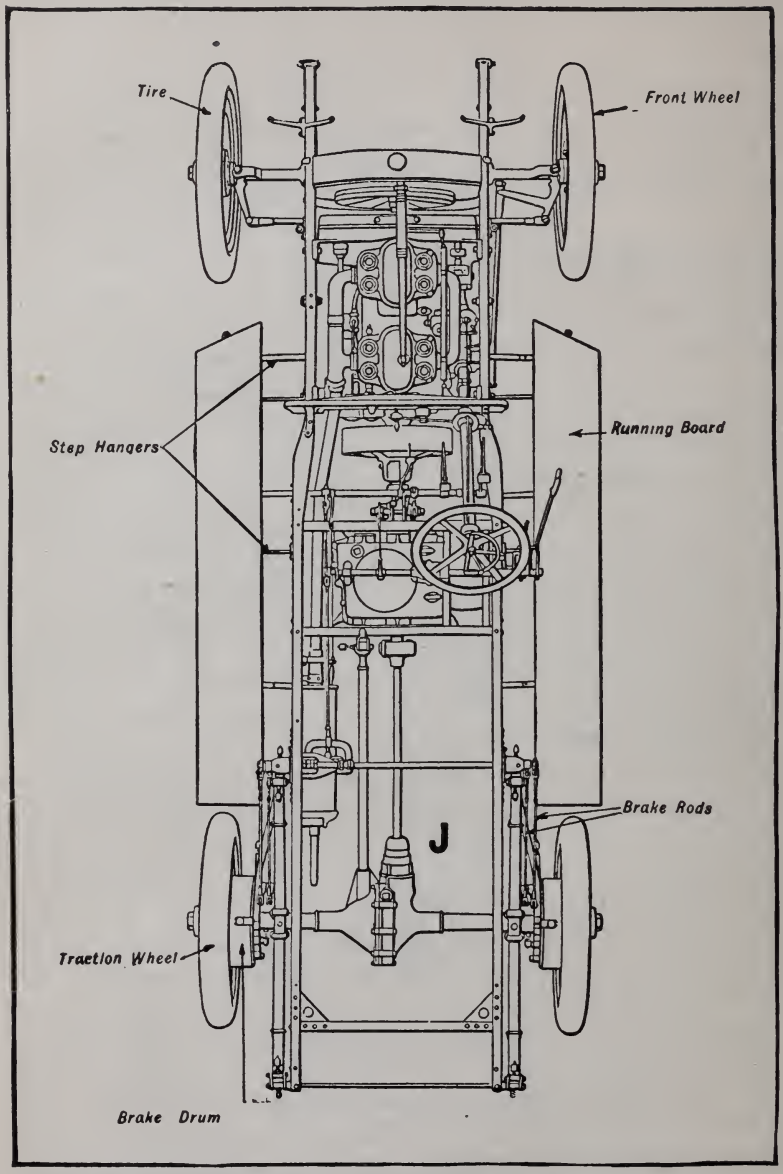


Fig. 13.—The Finished Chassis as it Appears After the Front Wheels, Tires, Traction Wheels, Brakes, Controls, Running Boards and Other Finishing Touches Have Been Made.

merly used. They are lower and have gradual curved sides. The object of this new construction, or torpedo body, as it is called, is to reduce wind resistance and also lessen the dust-raising proclivities of high speed automobiles. The effect of the air disturbed by a rapidly moving vehicle may be easily observed during the Fall when the weather is settled and the ground is well covered with leaves. When a car is driven along the road at moderate velocities a careful observer will detect movement of leaves fifteen or eighteen feet away from and at the side of the car. This shows that they have been affected by the large volume of air set in motion by the car body. It is obvious that dry dust would be disturbed in a similar manner, and if special attention was not directed toward reducing the air movement any motor car, even if moving at moderate speeds, would leave a cloud of dust in its wake.

Dust disturbance is not the most important factor, however, in determining body form, but it is the resistance of the air that is taken into consideration because of power absorbed. The object in designing should be to reduce end on resistance area to as low a point as possible, because the less area one has to push through the air, the less power it will take to overcome air resistance and more energy can be expended in driving the car.

At Fig. 14, the front view of a typical motor car is shown with dimensions which indicate the approximate size. To ascertain the total area, one or two points require consideration. The radiator, which is the largest member setting at a vertical plane, cannot be considered as offering an area that its overall dimensions would indicate. A large volume of air passes through it, but by no means all the air that passes between the tubes and the radiator discharges without resistance. Some of it flows easily around the power plant, and some streams out under the floor boards, especially if these are inclined. The greater part of the air which passes through the radiator must be deflected by the vertical dashboard which separates the motor compartment from the body, and the reaction due to this cause is comparable to the resistance which would obtain if the radiator was practically solid. It is estimated that the resistance of the average radiator may be safely considered at about half that of a solid plane surface of equal dimensions.

The resistance of the curved mud guards can be assumed to be that of their projected area, because the usual angle of inclination is such that the total pressure upon their underside may be taken as the same that would exist if they were not inclined appreciably. In addition, one may figure the area of a wind shield and top, and when

all these factors are considered, the approximate end on resistance of the average touring car will vary from twenty to twenty-five feet.

The amount of power which will be needed to overcome this resistance can be easily computed on a basis of speed of thirty miles per hour. The power required to overcome air resistance varies as the cube of the speed, though air resistance itself varies as the square of the speed. Therefore if the velocity is doubled, making it sixty miles per hour, the power absorbed at half that speed will be increased in

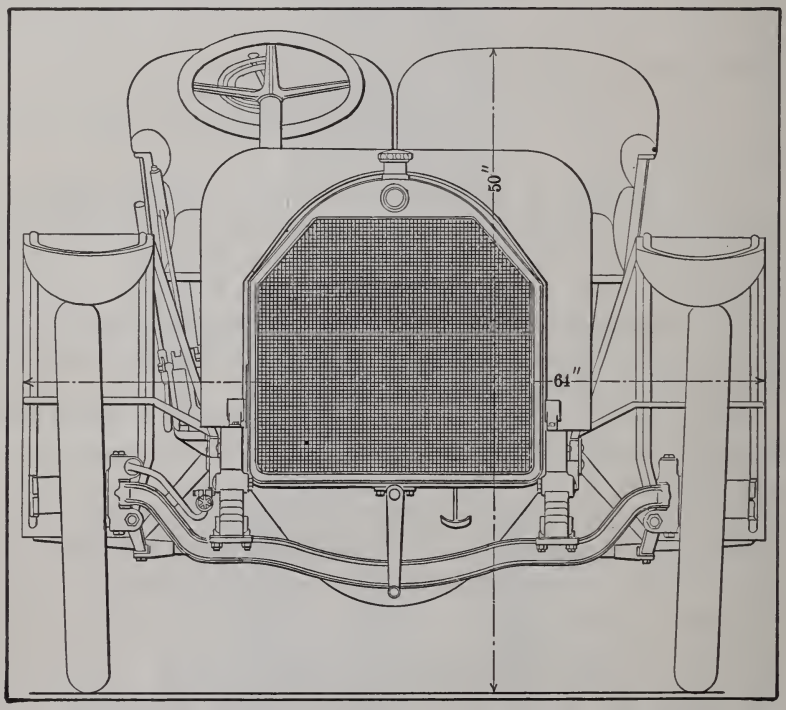


Fig. 14.—Front View of Typical Gasoline Car of Modern Design, Showing Parts which Tend to Impede Speed of Car by Producing Air Resistance.

value eight times. The following table indicates the power absorbed by air resistance at various speeds, assuming a total end on area of twenty-three square feet:

M. P. H.	H. P. Absorbed	M. P. H.	H. P. Absorbed
10	.174	50	21.75
20	1.392	60	40.00
30	5.000	70	59.68
40	11.136	80	89.08

If one consults the table presented above it will be evident that cars running at speeds of thirty miles per hour, or less, are not seriously affected by air resistance, but just as soon as the speed augments it will be apparent that it is very desirable to reduce the frontal area directly exposed as low as possible.

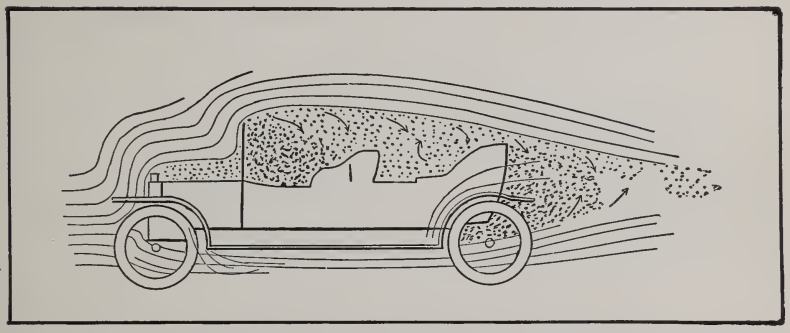


Fig. 15.—Side View of Old Style Gasoline Car Demonstrating Influence of Old Body Form on Air Flow.

At Figs. 15 and 16, diagrams are presented to indicate the probable direction of the air currents around an ordinary type fore door body with square dashboard and wind shield raised to a vertical position. These may be compared to advantage with the views shown

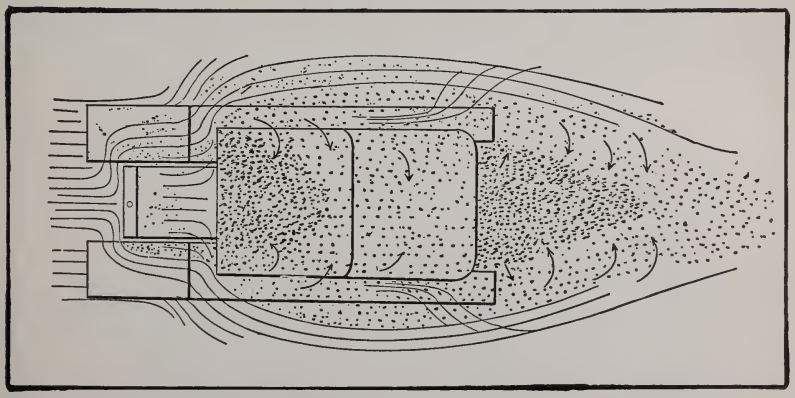


Fig. 16.—Plan View Showing Path of Air Currents Around Body of Old Style Gasoline Car when No Attempt was Made to Reduce Air Resistance.

at Figs. 17 and 18, which represent the same phenomena, except that the car is provided with a better designed body and a tapered hood, and that the wind shield is tilted instead of being set vertical. The diagrams are very instructive, and it should be noted in this connec-

tion that eddy currents would be largely increased if no side doors were fitted to the front seats. With a body of the stream line form the air currents are not deflected abruptly but follow the outline of the curved body and do not tend to raise as much dust or offer the same resistance as that present at Figs. 17 and 18.

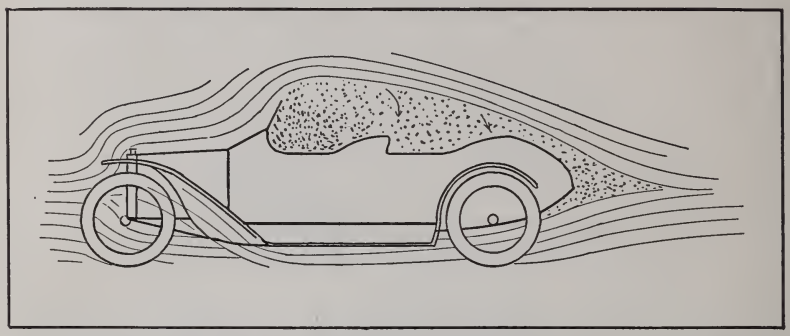


Fig. 17.—Depicting Flow of Air Currents Around Torpedo Body Design to Reduce Friction of Atmosphere at High Speed.

In order to show how much resistance may be obviated by the use of a stream line body, it is well to consider a typical example. Consider a car which is equipped with a seventy-horse-power engine and which track tests have demonstrated capable of ninety miles per hour. From the horse power available for overcoming the wind resistance

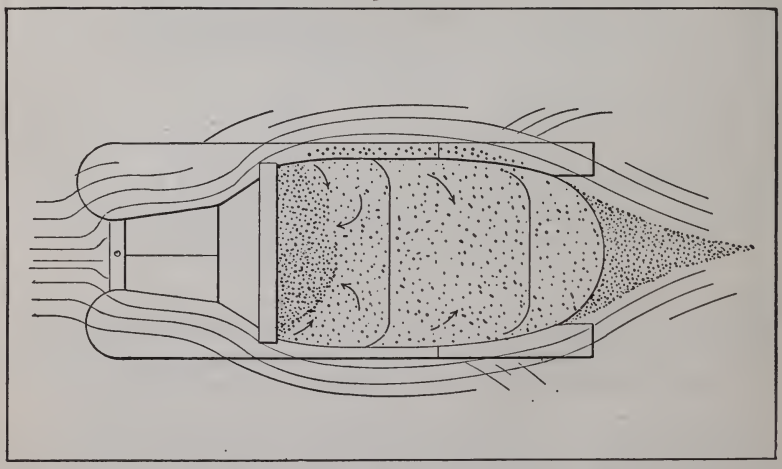


Fig. 18.—Plan View of Vehicle Body Shown in Preceding Illustration, which Clearly Indicates Influence of Symmetrial Body Forms in Producing Lessened Air Resistance.

we can deduct a certain amount which will be absorbed by friction of the transmission mechanism and loss between tires and track. The loss due to the driving gearing can be assumed to be twenty-five per cent, and that due to loss between tires and roadway is estimated at ten per cent. This will make a total loss of thirty-five per cent, which result will be sufficiently near the truth for purpose of approximation. The available horse power is therefore sixty-five per cent of seventy horse power, or in round numbers forty-five horse power. It would seem that the less area one had the greater speeds possible with the horse power available. In order to attain a speed of ninety miles per hour one could only have an exposed area of about eight square feet.

This would call for a stream line form racing body similar in design to that shown at Fig. 19. It will be seen that the air currents

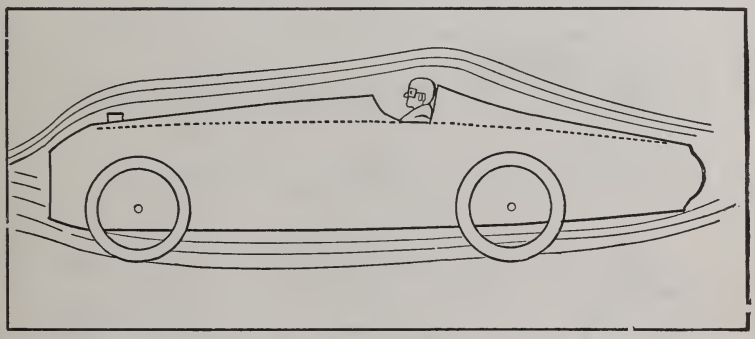


Fig. 19.—Outline of Exaggerated Torpedo Body Type Seldom Seen Except in Racing Cars.

follow the body contour very closely. As the body is flush sided with no openings or projections to disturb air flow, it will be evident that the minimum of exposed area will permit a maximum speed. Obviously, a practical touring car cannot be designed on exactly the same lines as a racing vehicle, as too much of the operator's comfort would have to be sacrificed to attain this end. A practical form of stream line body fitted to a speedway or racing chassis is shown at Fig. 20, A, while a two-door, five-passenger touring car, also following speedway lines, is depicted in outline at Fig. 20, B.

Factors Which Determine Power Required.—When a motor car is in operation there are various forces tending to resist its motion. On a level road these are the rolling resistance at the point of contact of the traction wheels and the roadway; friction in the power transmission mechanism and atmospheric resistance. If the vehicle is moving on a gradient there is still another factor to be considered,

and this is the amount of power needed to raise the weight of the car against the force of gravity. Obviously when the car is descending a hill the force of gravity assists the power plant instead of working against it.

The resistance of the road depends very largely upon the nature of the surface, and it is also dependent upon the size of the wheels and type of tire with which they are fitted. The second item, that of friction of rear axle, drive shaft, bearings and change speed gears, is comparatively low, and it is generally included with that of road resistance. It will be evident that other factors must also be con-

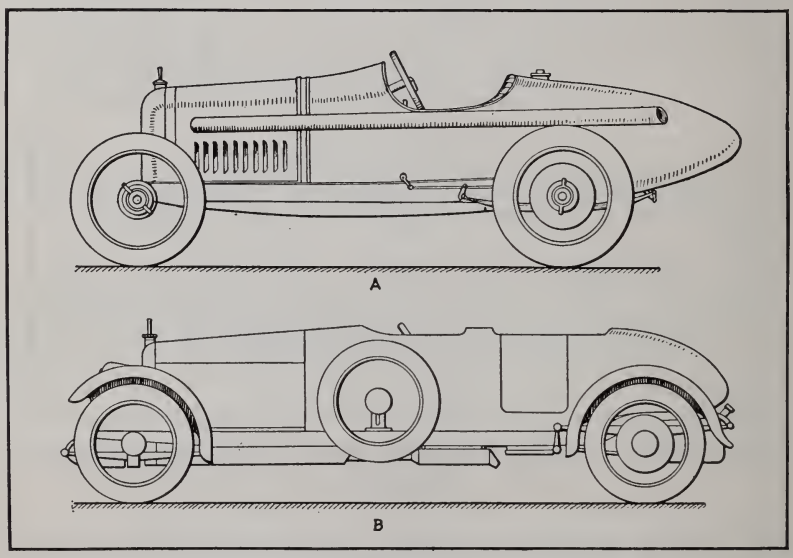


Fig. 20.—Stream Line Body on Two-Passenger Speedster Model Shown at A. Modern Two-Door Sporting Type Five-Passenger Body Outlined at B.

sidered in determining power required to propel a vehicle. One must figure on the total weight of the car, the capacity of the body, and the maximum speed it is desired to attain. All of these factors are considered by the designer, but the usual practice is to assume an average set of conditions and to provide a motor of more power than is absolutely needed to secure a margin of safety over the requirements. The average pleasure car has about one horsepower for every 75 pounds weight; the fast-racing cars may have one horsepower for every 25 pounds weight.

Classification of Motor-Car Types.—In considering the automobile one may divide it into a number of distinct types. These in turn

belong to one of two main classifications. When cars are used for industrial purposes, such as hauling freight and delivering merchandise, they are commonly termed commercial cars, or motor trucks. If the automobile is used solely for transporting people such as in tour-

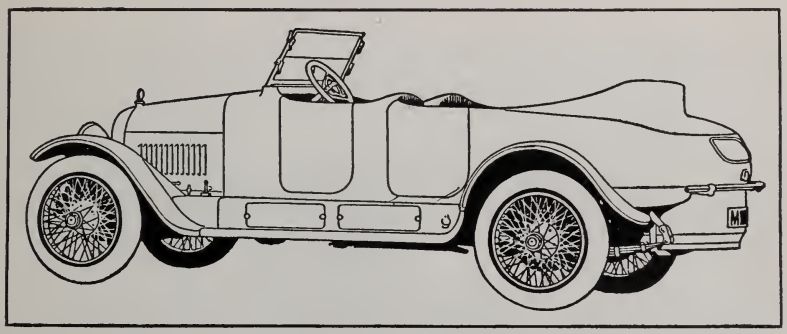


Fig. 21.—Latest Type of Seven-Passenger Pathfinder Touring Car with Stream Line Body.

ing, or even for business purposes, it is termed a pleasure car, though the line of demarcation between one class and the other is sometimes difficult to define.

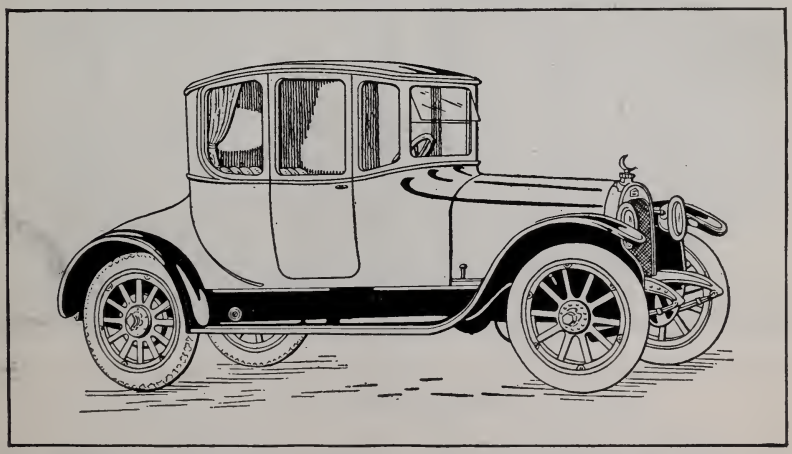


Fig. 22.—The Coupe, a Popular Form of Closed Body Favored by Professional Men.

There is no great difference in construction of the essential elements of either form. One chassis may be fitted with many different

body types, some of which may be specially designed for commercial use while others may be intended solely for personal transportation. The chassis of the vehicle contrived solely for use in conveying merchandise is built heavier and stronger than one built only to carry passengers, and there are certain modifications in detail. The princi-

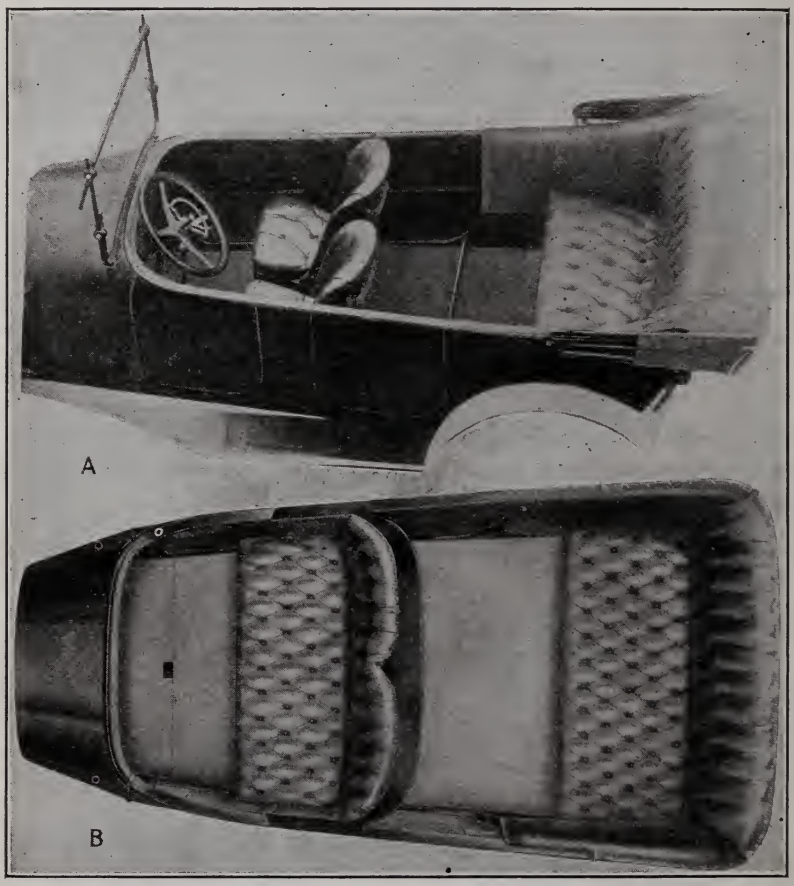


Fig. 23.—1917 Touring Car Body Forms. Salon Touring Car at A and Regula Touring Car Model at B.

ples of operation of the essential elements such as power plant, control systems, driving means, axle construction, etc., are the same, and no attempt will be made to differentiate between the types except in cases where the construction differs radically from accepted or general practice.

As an example of the difficulty in isolating the types, the taxi-

cab is a form which may belong to either classification. If used as a town car for social calls, shopping, etc., it might be classed

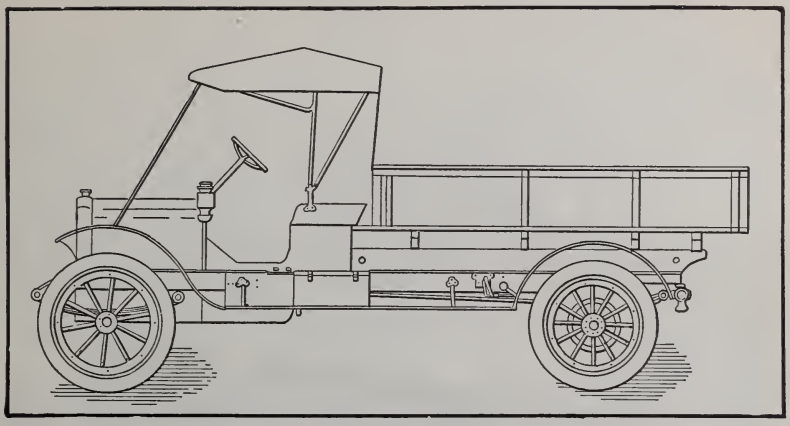


Fig. 24.—One and One-half Ton Capacity White Truck. A Conventional Example of American Commercial Car Having Power Plant Located under the Hood, as in Pleasure Car Practice.

properly as a pleasure car, whereas if employed as a public-service vehicle, or taxicab for hire, it belongs to the other classification. The truck shown at Fig. 24 is a good example of the way pleasure car prac-

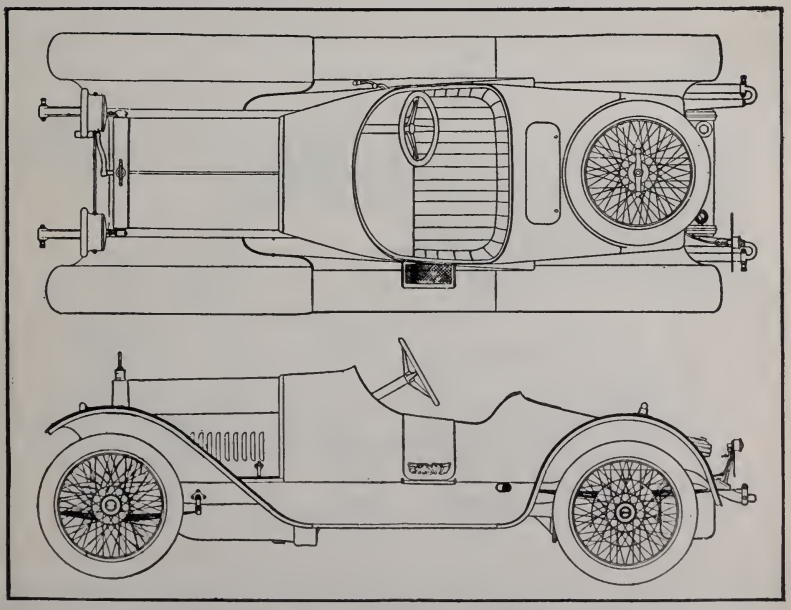


Fig. 25.—Stutz 1917 Two-Passenger Speedster Model.

tice may be altered for commercial purposes. The parts are strengthened, but the general design as regards disposition of the parts of the mechanism is very similar to that which obtains in representative

Fig. 26.—An Example of Special Duty Commercial Car, Combining Street Flusher and Cleaner.

pleasure cars. Figs. 26 to 28 inclusive depict vehicles which have been designed for special industrial requirements and can be placed in the commercial car class without hesitation, because the bodies fitted and the general design or arrangement of components does not permit

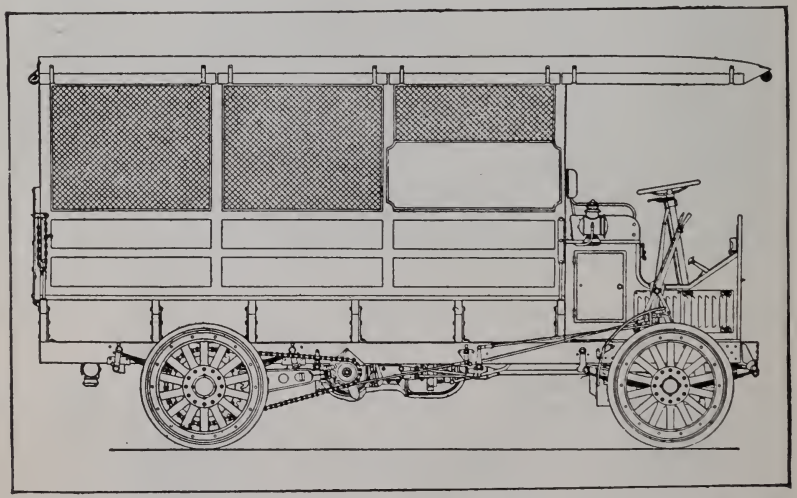


Fig. 27.—Showing Old Style American Motor Truck Design, in which Power Plant is Placed Under the Operator's Feet, thus Providing More Carrying Space for Body Without Lengthening Wheel Base.

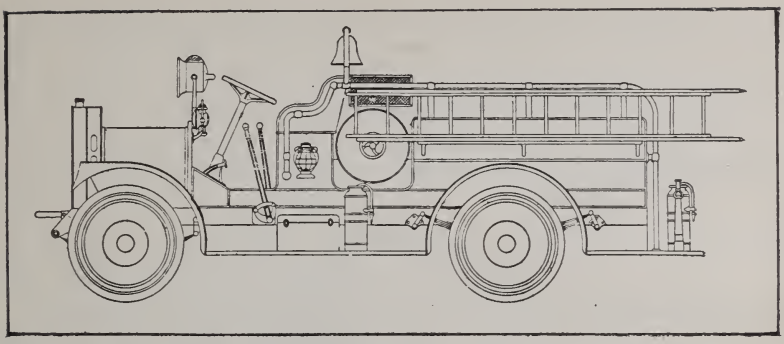


Fig. 28.—Motor Truck Chassis Fitted with Special Body for Fire Department Service—a New Field to which the Gasoline Motor is Particularly Well Adapted.

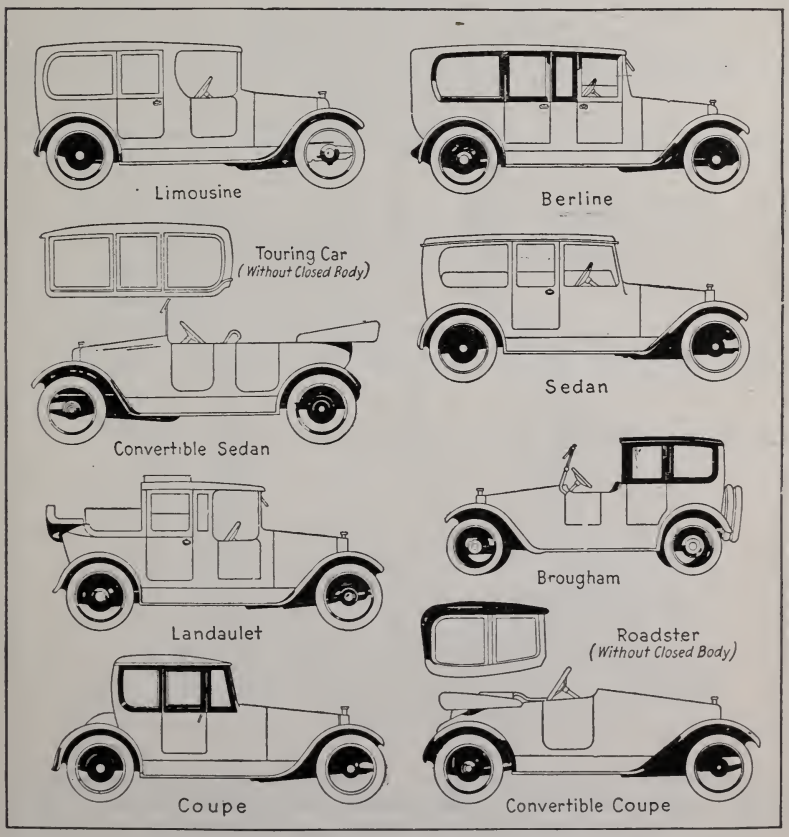


Fig. 29.—How Different Closed Body Forms May Be Fitted to the Same Chassis. Outlines Illustrating Standard S. A. E. Body Nomenclature.

their use for any purpose other than that for which they were con trived. All the body forms shown at Fig. 29 are applied to the same type chassis, and it is very common practice to design the running gear and frame so it may be adapted to a wide range of work without changing location of the mechanical parts.

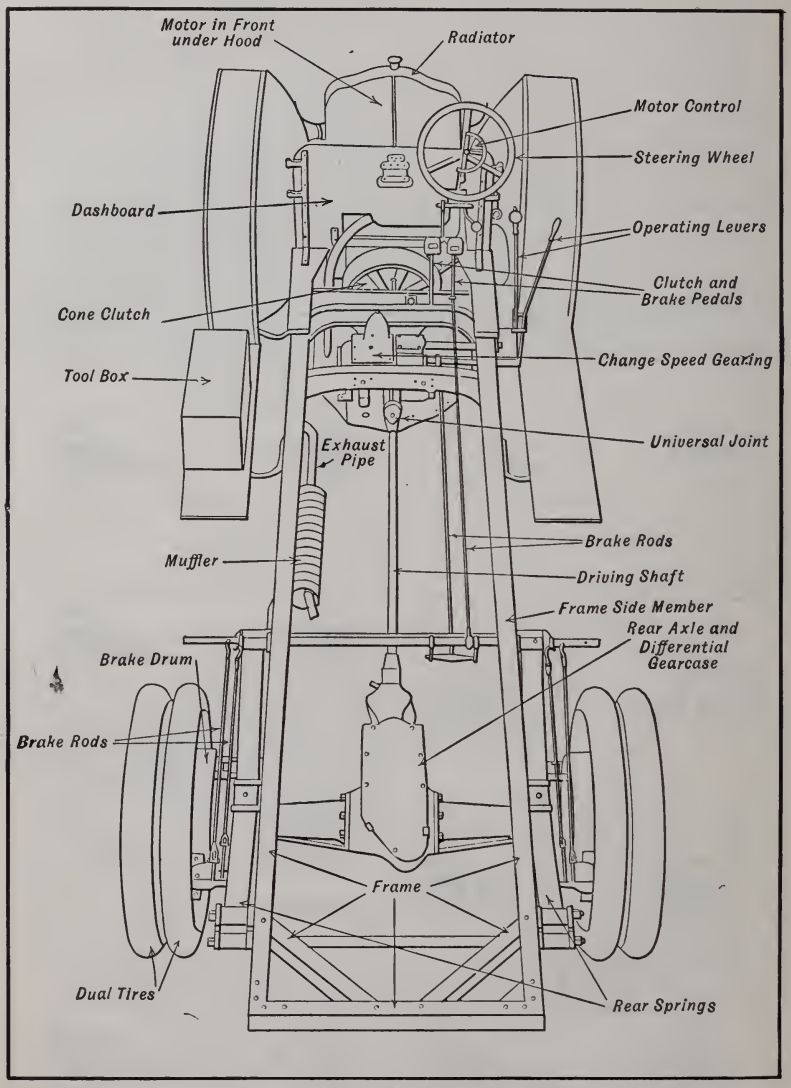


Fig. 30.—Light Motor Truck Chassis which Follows Typical Pleasure Vehicle Design Except in Size of Parts. The Frame and Running Gear Components are Heavier and Stronger, to Compensate for the Greater Load Carrying Capacity.

Standard Body Nomenclature.—The Society of Automotive Engineers settled on standard nomenclature of many parts of the car this year and the recommendations of the Society as to names of different car bodies should assist in clearing up the somewhat hazy condition of car-body nomenclature.

The different types of bodies and their definitions as adopted by the S. A. E. are given below:

Roadster—An open car seating two or three. It may have additional seats on running-boards or in rear deck.

Coupelet—Seats two or three. It has a folding top and full-height doors with disappearing panels of glass.

Coupe—An inside operated, enclosed car seating two or three. A fourth seat facing backward is sometimes added.

Convertible Coupe—A roadster provided with a detachable coupe top.

Clover Leaf—An open car seating three or four. The rear seat is close to the divided front seat and entrance is only through doors in front of the front seat.

Touring Car—An open car seating four or more with direct entrance to tonneau.

Salon Touring Car—A touring car with passage between front seats, with or without separate entrance to front seats.

Convertible Touring Car—A touring car with folding top and disappearing or removable glass sides.

Sedan—A closed car seating four or more all in one compartment.

Convertible Sedan—A salon touring car provided with a detachable sedan top.

Open Sedan—A sedan so constructed that the sides can be removed or stowed so as to leave the space entirely clear from the glass front to the back.

Limousine—A closed car seating three to five inside, with driver's seat outside, covered with a roof.

Open Limousine—A touring car with permanent standing top and disappearing or removable glass sides.

Berline—A limousine having the driver's seat entirely inclosed.

Brougham—A limousine with no roof over the driver's seat.

Landaulet—A closed car with folding top, seats for three or more inside, and driver's seat outside.

General Trend in Pleasure Car Bodies.—The body design, spring suspension, arrangement of controls and seating facilities of the 1917 cars will be materially better than in previous years. Manufacturers have learned that the lengthening of a frame by the addition of five

or six inches of metal does not add appreciably to the cost of production, but it does materially improve the riding qualities of the car because it permits a longer wheelbase. Bodies are roomier, as a rule,

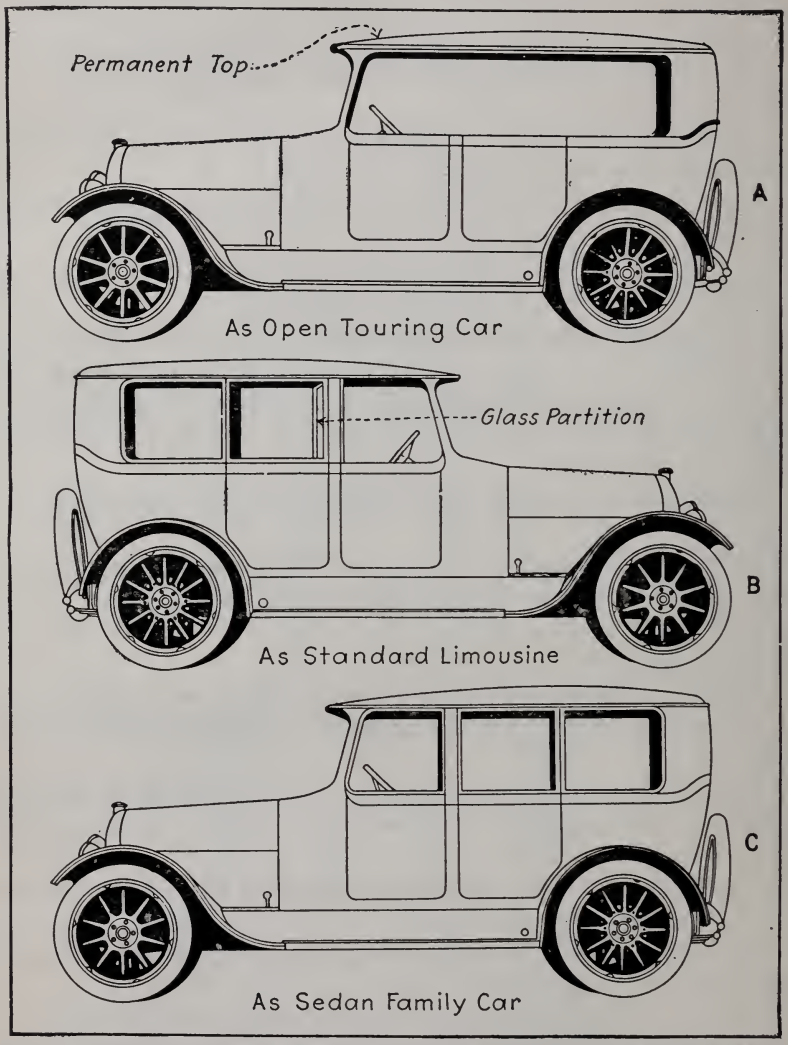


Fig. 31.—Showing Various Methods of Using a Permanent Top Body of Recent Development.

and while the augmented seat sizes have not been designed to carry more passengers, enough has been added to the width and depth of the seat and thickness of the upholstery to make the passengers more comfortable. One of the most noticeable tendencies is the application

of combination summer-winter bodies, and while the idea is not new, inasmuch as the detachable winter top was brought out several years ago, a newer type has made its appearance and will be supplied on many 1917 chassis. This is the form having a non-folding, permanent top which is designed so that it is supported only at the front and rear of the car and without intermediate pillars or supporting elements that would obstruct the view of the driver or passengers, or interfere with the circulation of cooling breezes in fair weather. Glass windows are provided which are so well concealed in the body panels that their presence is not suspected. They are put in place in a very few minutes and form a closed body, when properly attached, that is the equal of the permanent limousine or coupe forms as regards comfort and appearance. This type of body is well illustrated in Fig. 32. Many

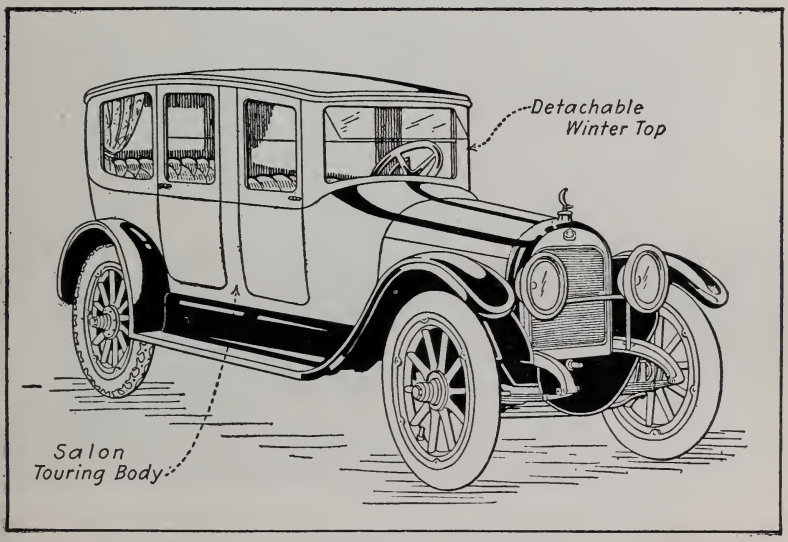


Fig. 32.—Showing Standard Touring Car Fitted with Detachable Winter Top.

of the detachable winter tops that have been offered, while very practical and substantial in construction, have the appearance of being makeshifts when in place and are open to criticism on that account. Some are very neat and conform nicely to the lines of the body, as shown at Fig. 32. This disadvantage does not apply to the permanent top construction. With this type of body it is believed advisable to revise the accepted seating arrangement on touring cars and to use but one door on each side, which gives access to the main body compartment. The front seats are in the form of individual chairs and not only is provision made for adjusting these to suit the build of the

driver as regards length of limb or size of body, but they may be completely turned around in some cases, so that the front seat passenger can chat sociably with those occupying the more conventional rear seat. In some of the closed cars heaters have been provided so that the waste heat of the exhaust gas may be made to serve a useful purpose by raising the interior temperature to that prevailing in any well-heated home regardless of the degree of cold outside.

The accepted body design for touring cars is the double cowl type, as outlined at Fig. 33, although on cars intended to be used either with a permanent or applied winter top, the sedan or salon arrangement is always followed. The lines of all types of cars have been materially improved by a simplifying process which has eliminated all projecting parts and any irregular angles or curves that would detract from a symmetrical form. Even quantity producers of very cheap cars, which heretofore have been most conservative regarding any change in the body lines of their product, have recognized the popular demand and have changed the body to as near an approximation of the stream line form as possible without an actual redesigning

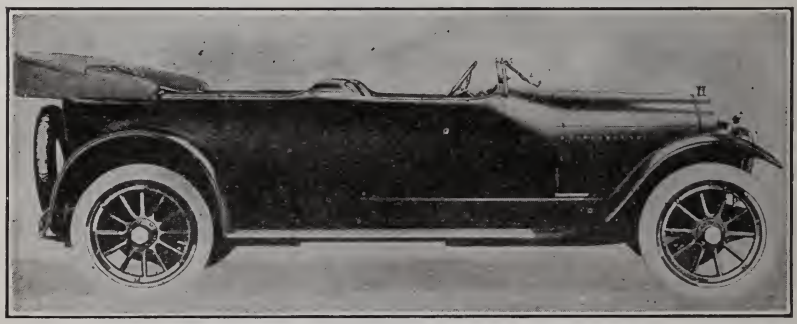


Fig. 33.—The White Seven-Passenger Touring Car for 1917 Has Double Cowl Body Design.

of the entire job. The lines from the radiator to the windshield in practically all well designed bodies are unbroken, as are the sides of the bodies. Another tendency is to reduce the height of the body without sacrificing the comfort of the passengers, by the simple expedient of placing the seats lower and allowing for the increased length made necessary to secure proper leg room by an increase in the wheelbase. A reduction of four to six inches in body weight will bring the passengers that much nearer the ground, and as it lowers the center of gravity of the car it makes for materially less side sway when traveling at speed around curves and over winding highways.

Last year several pioneers inclined the windshield as in Fig. 21. This was an improvement of considerable value that was well appreciated by any driver who had been disturbed by the reflection of glaring headlights of a car approaching from the rear when driving after nightfall. Tilting the windshield not only reduced the glare

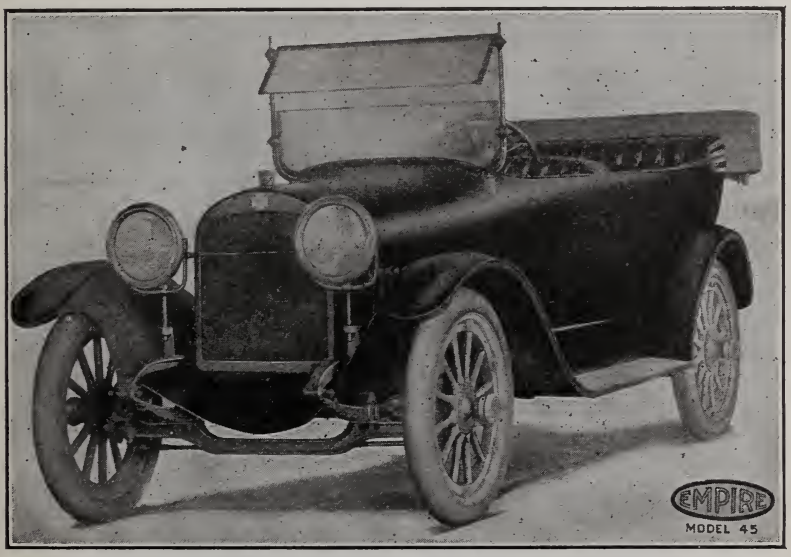


Fig. 34.—Three-quarter Front View of Empire Model 45 Touring Car, Showing Modern Body and Fender Lines.

and in many cases eliminated it altogether, but also gave the car a more rakish appearance. Inclined windshields will be found on practically half of the 1917 models. Another tendency to be commended is the provision of wider doors making for easier ingress and egress.

Four-Passenger Roadster.—The most pronounced movement in body design is the development of the four-passenger roadster, which is an improvement on the three-passenger clover-leaf types that were offered last season. The reason this body is popular is not hard to find. The conventional roadster design is intended only to seat two passengers comfortably. It provides no accommodations for a chance guest. The touring car does not solve this difficulty because in the case of the small family most of the time the car is used with an empty tonneau. The four-passenger roadster body, as outlined at Fig. 35, is a happy solution provided it is properly designed. It has been discovered that it is somewhat of a problem to build a close coupled

body that will seat four and yet have it present the proper appearance with only two passengers aboard. The problem has been given the proper amount of consideration during the past year and at least thirty makes of cars will be available in which the four-passenger roadster body design is well carried out.

Practically all automobile bodies are now made of metal, sheet steel being used on the cheaper cars and sheet aluminum on the more

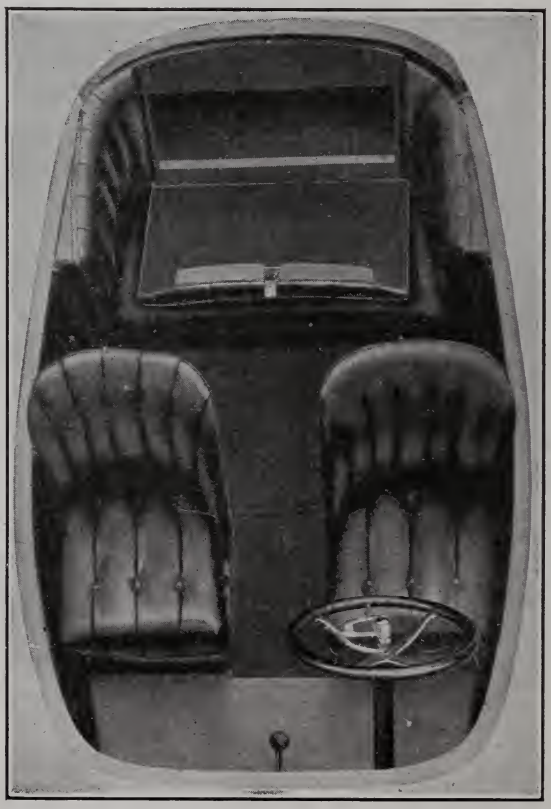


Fig. 35.—Plan View of Clover Leaf Roadster Body, Showing Back of Seat Tilted Down to Give Access to Storage Compartment in the Rear.

expensive models. Wood is still used to some extent, but only for body sills and frame work, floor boards, and similar parts for which it is very well adapted. Mud guards are made wider and of the popular rounded pattern. In most cases they conform to the curve of the wheel over which they are placed and join the running-board with a reverse curve that is very pleasing to the eye. The space between

the sides of the body and the running-board is now filled in with a suitable sheet-metal apron on even the cheapest cars. Splash guards are also provided at the front of the frame so that the front wheels will not fill the radiators with mud.

New Body Designs and Seating Arrangements.—The pronounced tendency in body design is to carry out the stream line effect so that there are no sharp angles anywhere on the body. The hood meets the body, which is provided with a cowl dash. An example of an extreme "boat type" body is shown at Fig. 36, A. Seating arrange-

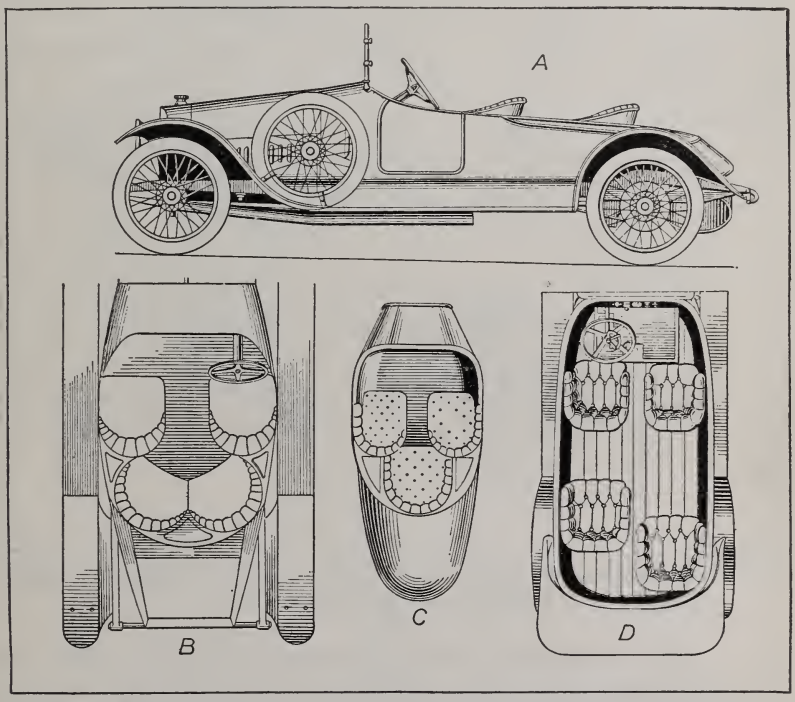


Fig. 36.— Recent Developments in Body Design and Seating Arrangement.

ments have been changed to some extent. At B a "cluster" system of arranging the seats for carrying four passengers in a body but little larger than that usually provided on a two-passenger car, is shown. The advantage of this arrangement is that it brings all passengers near the center of the body and between the springs, which makes for easy riding. A clover leaf seating arrangement for three passengers is shown at C. In the body outlined at D the seats are in the form of movable arm chairs which may be placed as desired, and securely locked after they are located to suit the convenience of the occupants.

In body designs that are intended to be convertible from five to seven passengers' capacity, more care is taken in concealing the folding seats when these are not in use than was formerly the case. A good example of a folding seat which may be folded completely out of the way when not in use is shown at Fig. 37, A. One of the seats is folded back into the rear portion of the front seat, while the other is shown ready for use. A refinement of detail which was intro-

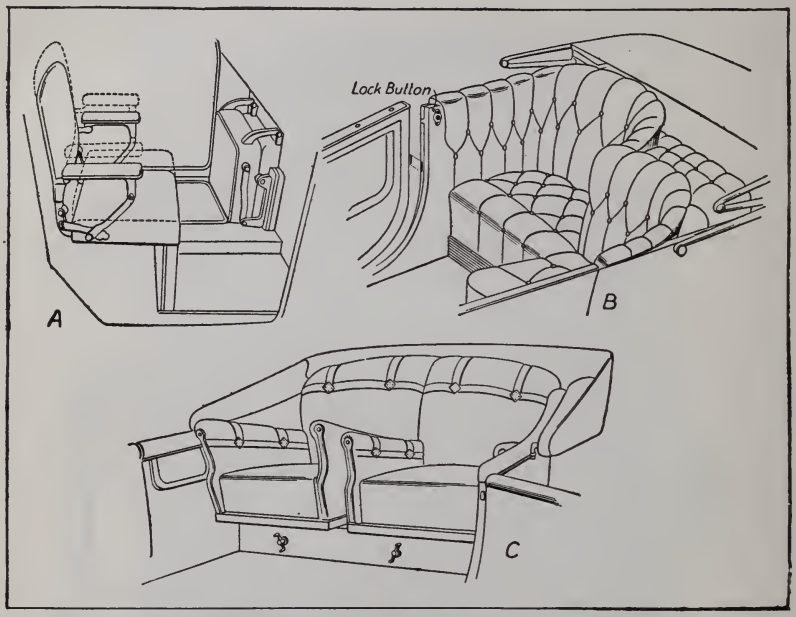


Fig. 37.—Refinements in Design of Automobile Seats at A and C. Scripps-Booth Electric Door Latch at B.

duced on the Scripps-Booth car is shown at Fig. 37, B. This consists of an electrically operated door lock which eliminates the projecting handle found on nearly all cars. Pressing a button at the side of the seat will send a current of electricity from the storage battery through the lock mechanism and will withdraw the bolt so the door may be readily opened. A good example of the degree of luxury found in the bodies of high-grade cars is shown at Fig. 37, C. In this the seats are in the form of luxuriously upholstered arm chairs having the seat and back as well as the arms independent of each other, so that by turning a small hand crank beneath each seat, these parts may be placed to best suit the comfort of the passengers. The seat back may be tilted, the cushion may be moved forward and the arms raised or lowered, as desired.

In an endeavor to increase the available body room, a novel form of automobile has been devised in which running boards are eliminated and the body area augmented by utilizing the space ordinarily taken up by the running board. The fenders are eliminated in the sense that the portion of the rear seat overhanging the rear wheel is curved to conform to that of the wheel and is utilized for a mud guard. A single entrance door is provided on each side, and when this door is open an undercut floor is brought into action by lowering a floor section which works automatically with the opening of the door and provides a step making for easy entrance, as shown in the illustration

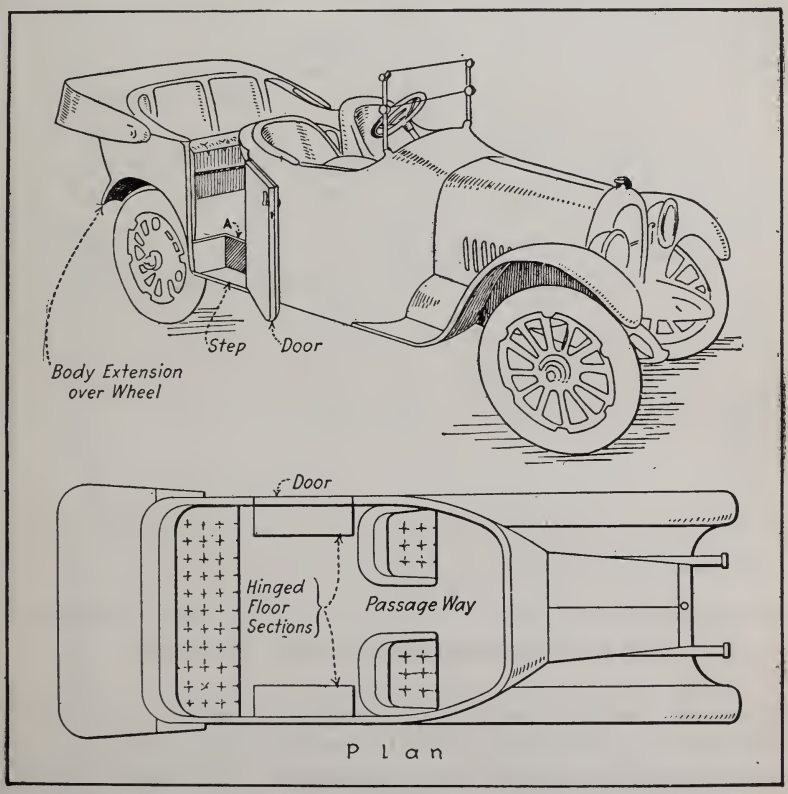


Fig. 38.—Special Body Design to Permit of Extra Wide Rear Seat.

at Fig. 38. When the door is closed the hinged portion of the floor returns in position and conceals the opening effectively.

The illustration at Fig. 39 is taken from "The Automobile" and shows a body upon which the designer is applying for a patent. The feature of the body is the front seat, which is divided and which is so

arranged that the left seat can be adjusted for a driver of any height and can be moved backward and forward so that it will give the necessary leg room to reach the pedals. The right seat can also be moved and if desired can be turned around so that its occupant can converse with comfort with the occupants of the rear seat. The idea of the body is two-fold. In the first place it is realized that the car cannot be designed to fit other than the average driver and since there

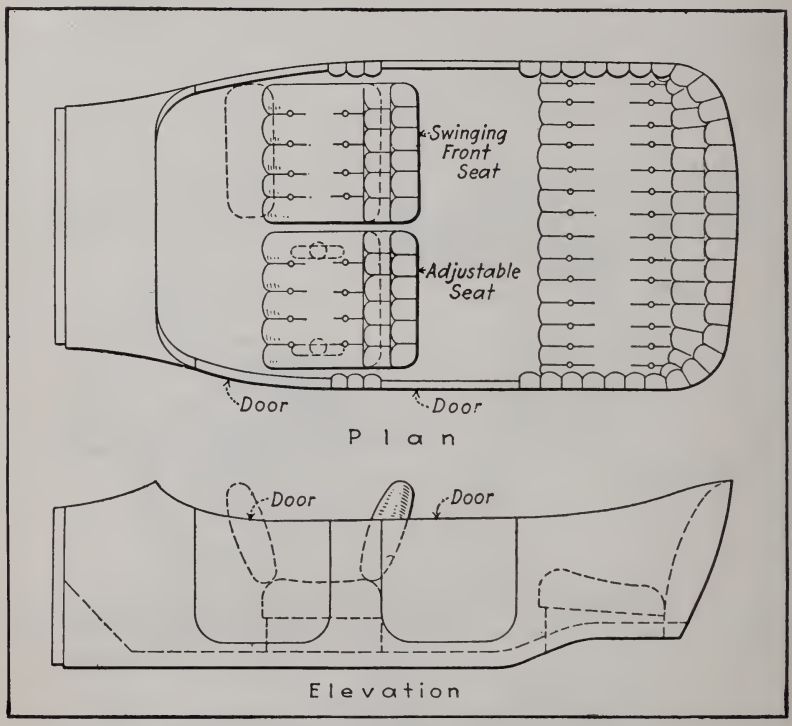


Fig. 39.—Body Design Having Swinging Front Seat.

are so many people in the world who are not average in stature it is necessary to provide some means for accommodating those who are exceptionally tall or short as the case may be. Thus any driver can take care of the car and operate it in greater comfort and efficiency. The right front seat, on the other hand, is often a very bad place to sit because the driver is generally too absorbed to give much of his time to conversation, and it is very difficult to talk over the shoulder to the occupants of the rear seat. If a chauffeur is employed the difficulties are greater, as the owner of the car, as a matter of form, is compelled to sit in the front seat with the chauffeur, while his three

guests are back in the tonneau. The movable right seat overcomes this objection.

Body Dimensions.—The dimensions of automobile bodies depend upon many factors, but there are certain minimum and maximum dimensions relating to the location of seats, steering wheel, control levers, available leg room, etc., that must be given careful consideration in designing the body if the comfort of the passengers is to be considered. The subject was carefully and completely considered in one of the leading automobile papers. The engineer responsible for the design of the Dort automobile has analyzed the figures and gives the following table, which refers to the dimensions indicated at Fig. 40, as worthy of consideration, as experience shows that a car following these dimensions will be easy to drive and comfortable to both driver and passengers:

DIMENSIONS OF STANDARD DORT TOURING CAR

	Dort	Recommended by Automobile	Recommended by Mr. Planche
A	8½	9	9
B	16	16	16
C	14½	14	14½
D	7¾	6	8
		Dort gives more room to pass by	
E	27½	27	27½
F	18	19	18½
G	16	19	17
H	None	12	10
		Dort foreign is 12	
J	5½	Over	Over 5½
K	No	No	No
L	None	No	No
M	19½	19½	19½
N	Note	Note	..
O	17½	18	17½
P	None	20	21
Q	19½	18	20
R	10½	11	10½
S	25	27	25
T	14	14 to 17	14
U	19	21	20
V	45½	46	48
W	19½	21	19½

Note—Drivers not quite erect.
K—Must one lean to shift gears.
L—Must one lean to apply emergency.

In view of the interest which obtains in the close coupled or "clubster" seating arrangements, the diagram at Fig. 41 shows the essential dimensions of a very comfortable body of this type found on

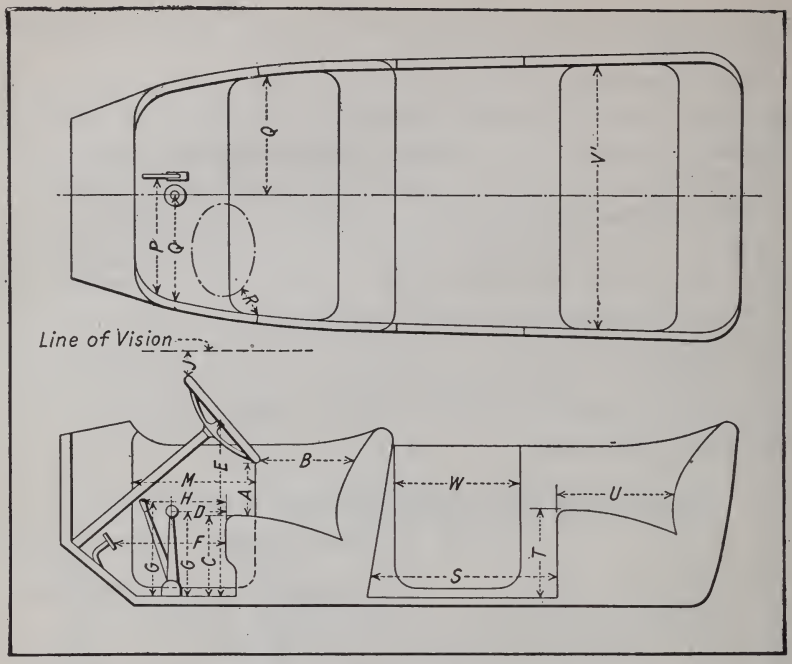


Fig. 40.—Cut Showing Standard Touring Body with Main Dimensions.

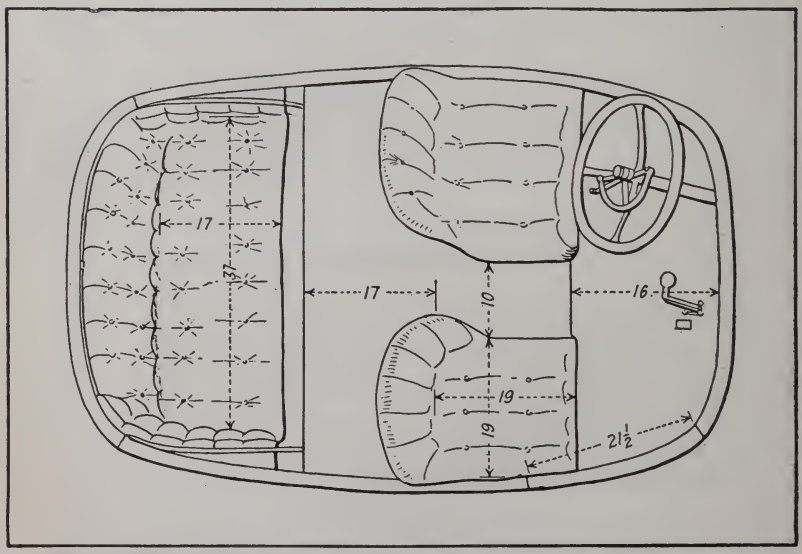


Fig. 41.—Seating Arrangement of Four-Passenger Roadster Body, Showing Principal Dimensions.

the Empire chassis. The principal dimensions of the Scripps-Booth eight-cylinder automobile, given at Fig. 42, indicate that comfortable seating is not incompatible with this compact arrangement.

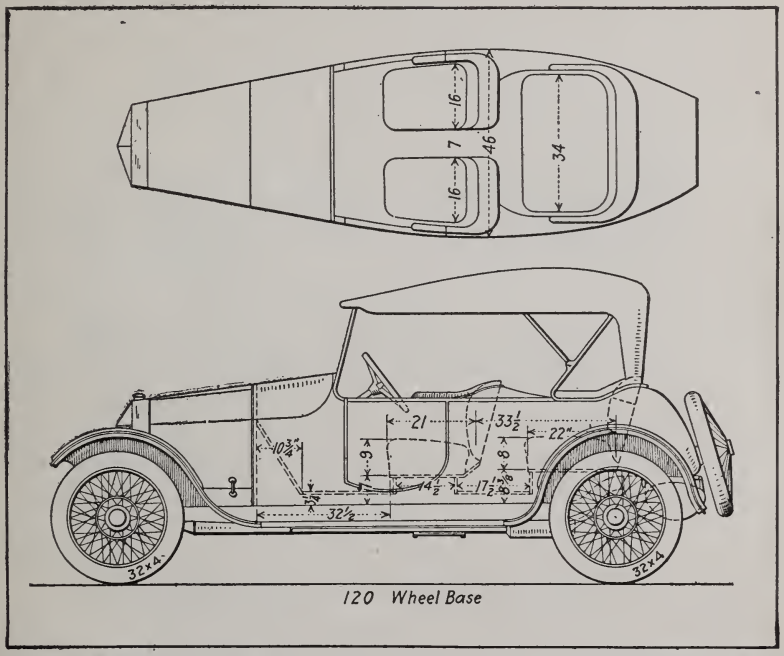


Fig. 42.—Plan and Side Elevation of Scripps-Booth Four-Passenger Body, Showing Principal Dimensions.

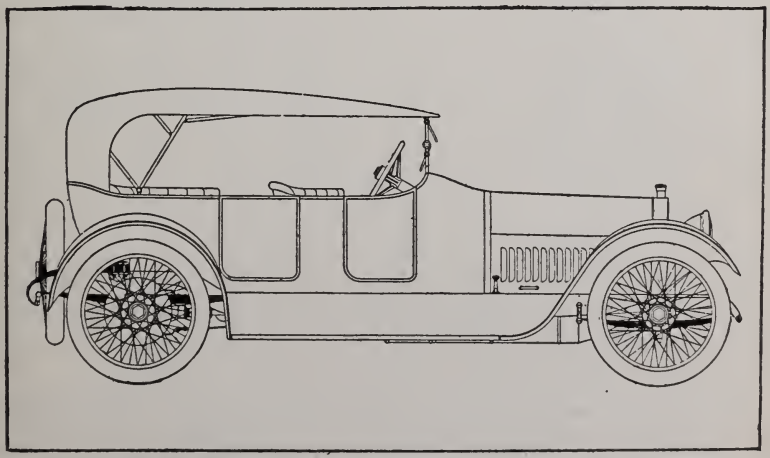


Fig. 43.—Typical Modern Touring Car with Stream Line Body, One-Man Top and Detachable Wire Wheels.

Motor Truck Design.—The large demand for motor trucks from the European belligerents, coupled with a greatly increased sale in this country, has kept the motor truck builders so busy during the past year, that but little time was spent in design development, although great improvements were made in details and construction, and production processes have been improved materially. Most of the makers were satisfied in continuing the designs that had been perfected at the close of 1915 as a result of the lessons learned by the severe service abroad, and it looks as though the truck of 1917 would not be very much different from its immediate predecessors. Last year's production of commercial vehicles was greater than that of any previous year, though the increase was not so marked as that of 1915 over its preceding year. The truck of 1917, however, will comprise a radically different construction from that of several years back. At that time the features of pleasure cars were beginning to be standardized, and the same desirable units were found in numerous cars of different makes that formerly differed widely from each other. The European war accelerated motor truck production and as standardization is the most important fundamental underlying economical manufacture of goods in large quantities, truck designs became more and more alike through a growing realization of the advantages of certain methods of construction and combinations of elements.

Considering first the range of models available, there are more of the intermediate capacities now offered, though the average size is about the same as it has been for two years past, viz., 5,000 pounds or 2½ tons capacity. There is a definite division into three main classes, the first being the delivery car; the second, the medium duty vehicle, and last, the heavy duty truck. Tractors are an entirely separate classification to be reckoned with because they have demonstrated their worth for heavy hauling in connection with trailers in an unmistakable way during the past several years. The first class includes capacities varying from 500 pounds to 1 ton; the second from 1 ton to 2½ tons; the third includes all vehicles of larger capacity than mentioned. Naturally there is a greater field for commercial vehicles coming into the first classification, and as the light chassis production is one easily carried out by the same methods developed for producing pleasure cars, their field of usefulness has been greatly increased because of the reduction in price possible.

Delivery cars usually follow pleasure car practice in most details and are largely built up of pleasure car components. A marked tendency noted in even the smaller cars is a change to truck practice in some essentials. As most delivery cars are intended for higher

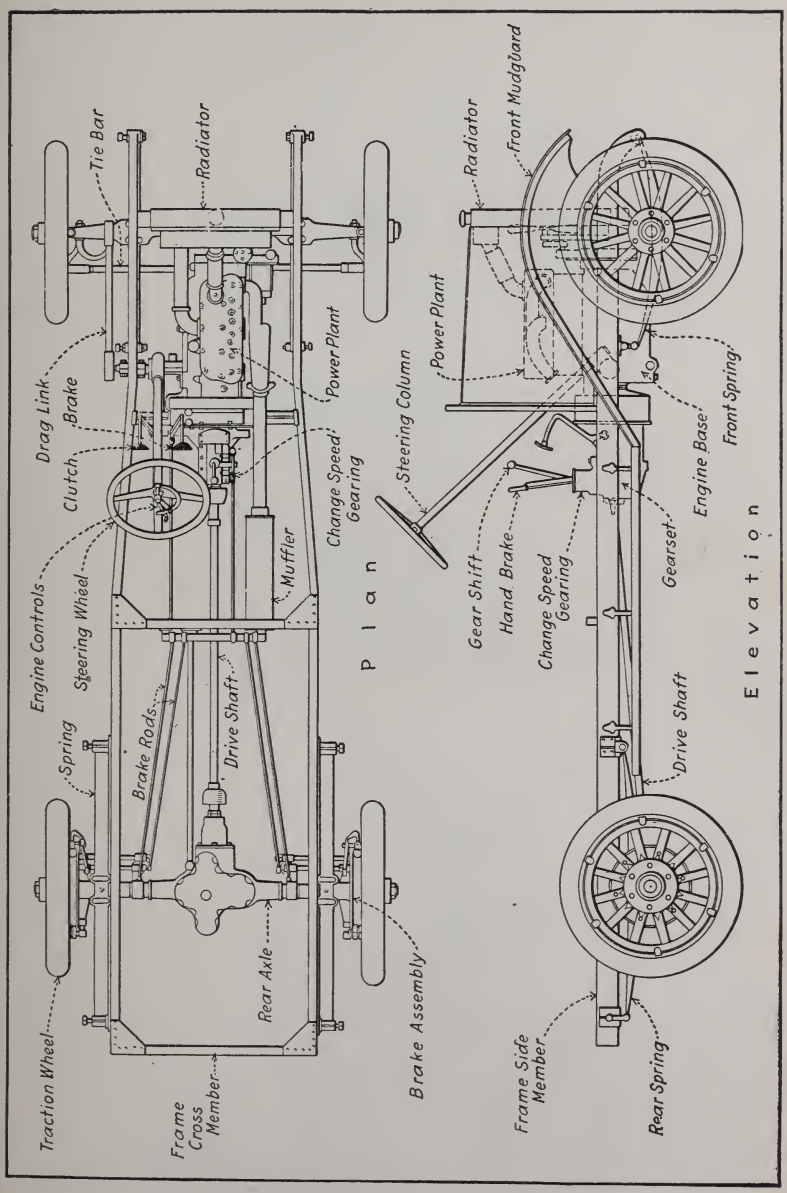


Fig. 44.—Plan and Side Elevation of Collier Light Truck for 1,500 Pound Load. Shows Modern Trend.

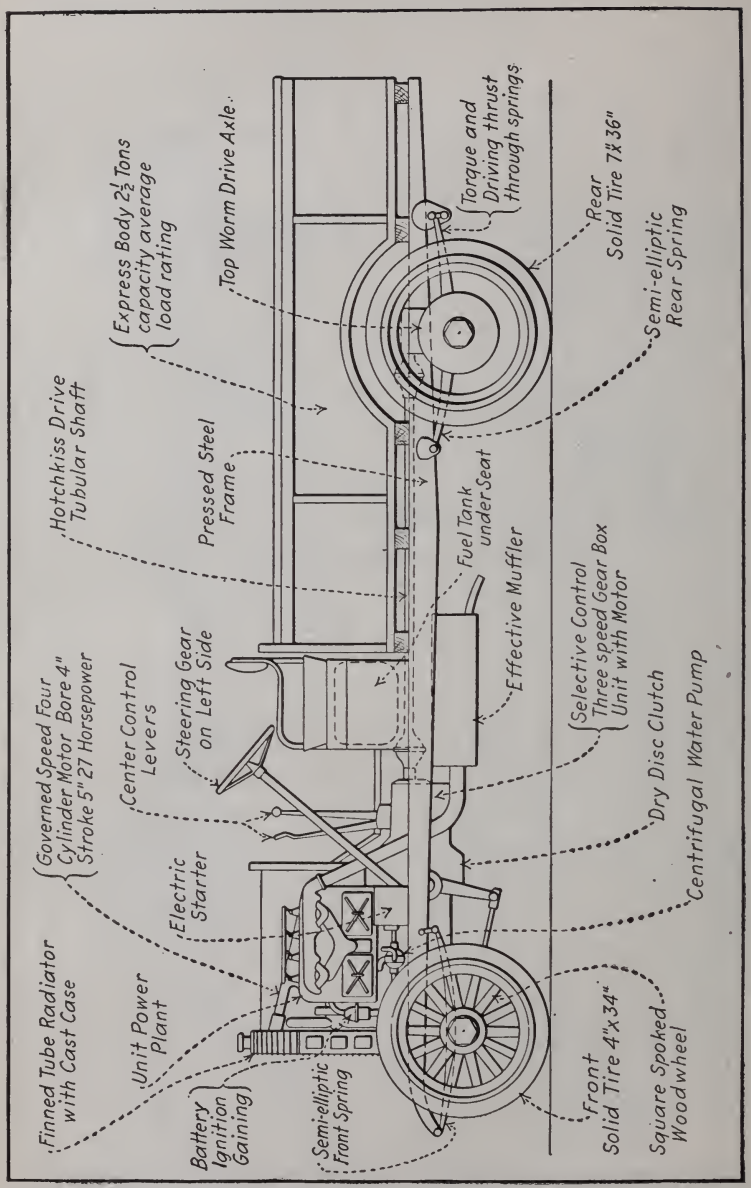

Finned Tube Radiator with Cast Case
Governed Speed Four Cylinder Motor Bore 4" Stroke 5" 27 Horsepower
Unit Power Plant
Electric Starter
Center Control Levers
Steering Gear on Left Side
Hotchkiss Drive Tubular Shaft
Express Body 2½ Tons capacity average load rating
Pressed Steel Frame
Top Worm Drive Axle
Torque and Driving thrust through springs
Fuel Tank under Seat
Effective Muffler
Rear Solid Tire 7" x 36"
Semi-elliptic Rear Spring
Selective Control Three speed Gear Box Unit with Motor
Dry Disc Clutch
Centrifugal Water Pump
Battery Ignition Gaining
Semi-elliptic Front Spring
Front Solid Tire 4" x 34"
Square Spoked Wood wheel

Fig. 45.—Composite Truck Showing Average Trend of Commercial Car Design for 1917.

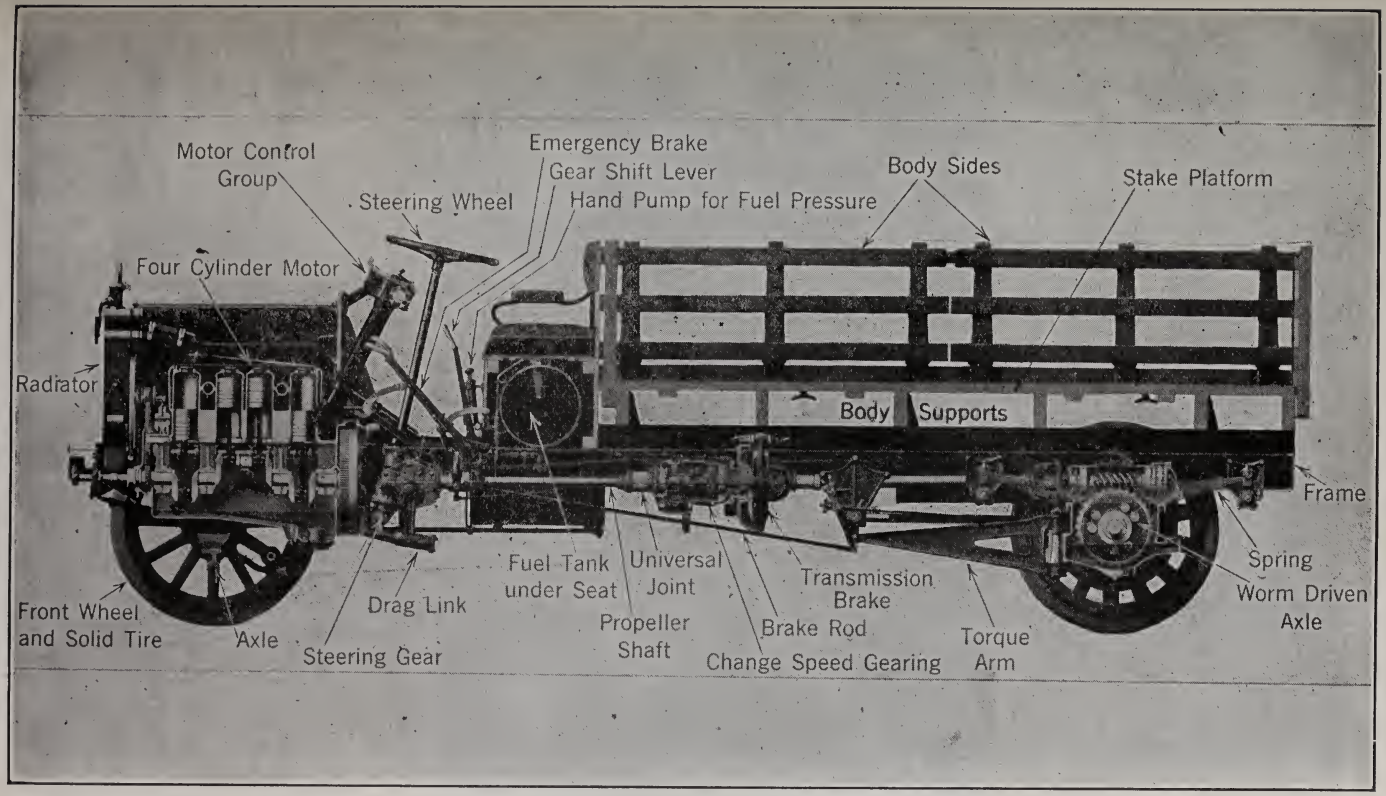


Fig. 46.—Sectional View of Packard Motor Truck, a Representative 1917 Design, Showing Many of the Now Accepted Features of Construction.

speeds than commonly advised for commercial work, pneumatic tires are always used, as shown in Fig. 44. Even when pleasure car chassis designs are followed, the frames, springs, wheels and other parts are made more substantial than in a pleasure car of the same power. This is necessary because a truck is used every day and covers more ground than a passenger carrying car would. The average delivery car capacity is 1,500 pounds and very few parcel cars of less than 1,000 pounds capacity are now being made. Those having 1-ton capacity are now being built along truck lines, several entirely new designs being offered for the 1917 season that combine the mobility and speed of the lighter cars with the strength and ability to stand

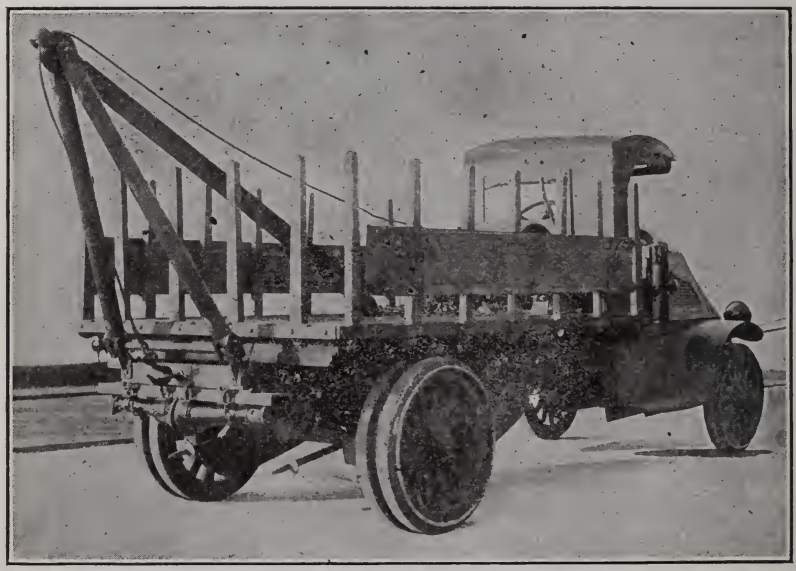


Fig. 47.—Special Mack Truck for Contractors' Use, Equipped with Winch and Derrick for Handling Heavy Loads.

continuous service usually attributed only to the heavier designs. The improvements made in heavy duty trucks are detail changes intended for the most part to secure much greater structural strength. The general trend of 1917 truck design is clearly outlined in the composite truck shown at Fig. 45, while a typical high-grade truck of latest construction is shown in part section at Fig. 46, which depicts a Packard worm drive design. Other details of truck construction will be considered as the various units are described.

Three-Wheel Tractor.—The Knox-Martin Tractor, which is shown at Fig. 48, detached and attached to a steam pumping engine at

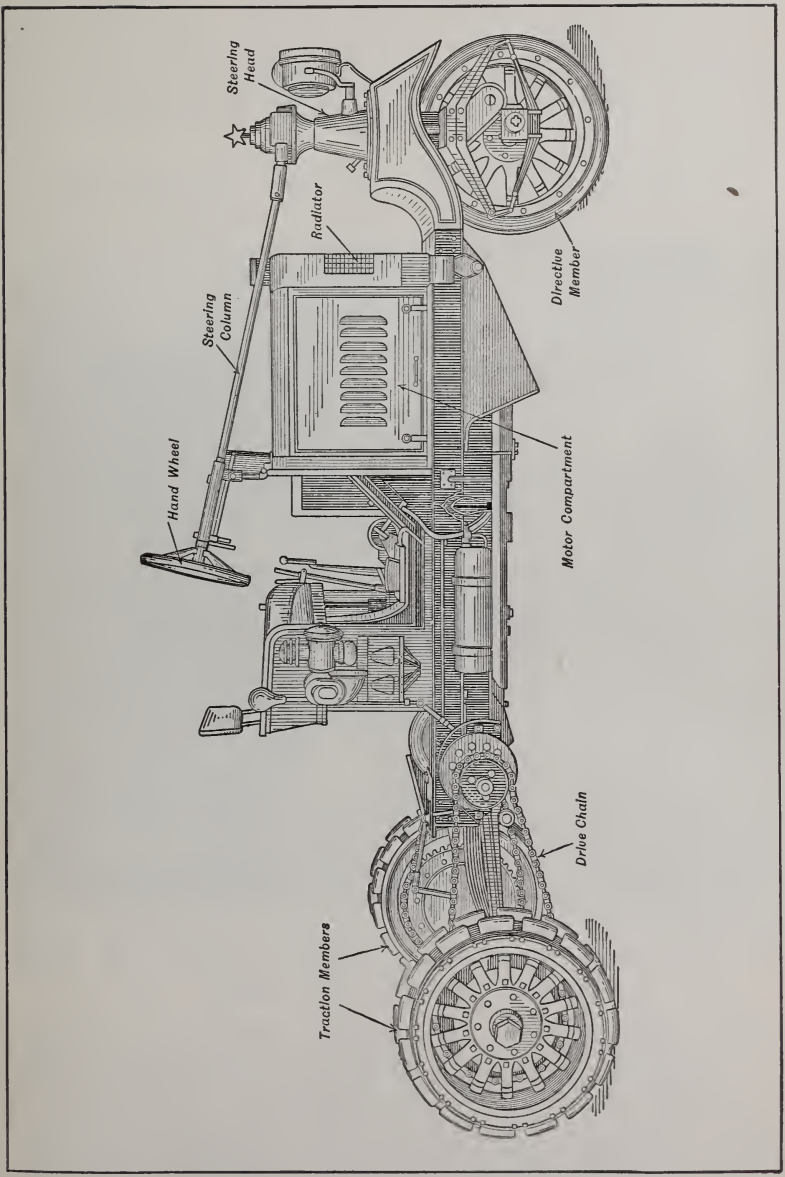


Fig. 48.—The Knox-Martin Three-Wheel Tractor, a Mechanical Substitute for the Horse.

Fig. 49, is really a mechanical horse, in so far as its method of application is concerned. The tractor has a number of advantages for fire department work as well as in the commercial applications, and it has been thoroughly tested out in connection with all types of apparatus. Before considering the application of the tractor in fire department work, it will be well to enumerate some of its principal advantages, as follows:

First—Ease of attachment to any present horse-drawn type of apparatus, thus saving the latter from the scrap heap or sale at sacrifice prices in order to effect motorization.

Second—Low first cost compared with a complete integral motor outfit to do the same work.

Third—The factor of interchangeability is an important one. The tractor can be readily attached to any vehicle at the fifth wheel or turntable by means of an ordinary king pin in a very few minutes' time. In small cities this is a distinct advantage, as one tractor can be made to serve several pieces of apparatus. Suppose, for instance, that after the fire engine had been taken to the scene of the fire and it was decided that a water tower would be needed to facilitate extinguishing the blaze, the front portion of the pumping engine could be jacked up without interfering with its operation and the tractor can go back to get the water tower, which is needed so seldom in the average small town or city that it would not be necessary or profitable to provide a separate tractor for this piece of apparatus alone. Another advantage of interchangeability is that the use of the tractor does not alter the piece of apparatus appreciably, and if for any reason the tractor is incapacitated, horses may be used to draw the apparatus.

Fourth—The tractor can haul a considerably heavier load with the same amount of power than where the power plant forms an integral part of the piece of apparatus. The flexible rear springs of the tractor absorb the driving and braking reaction and permit the starting of heavy loads on grades or the positive control of the apparatus when descending hills without damage to the essential parts of either the apparatus or the tractor. As an example of the hauling power of the tractor, comparison may be made with the pack mule, which is able to carry one-third of its weight on its back, whereas the same mule will draw four times its weight without exerting itself any more than when carrying one-twelfth of that load. The tractor does not push or carry all its load, as is true of the conventional truck construction. Therefore it is claimed by those favoring this device that the work of either the animal or the usual

form of motor truck may be accomplished at considerably less cost per ton mile.

It is generally conceded that horse-drawn vehicles are a development of many years, and animal-drawn fire apparatus has reached a state of proven commercial reliability. The expense of maintenance of such apparatus was never due to the apparatus itself, because the first cost of the wagon and equipment is low and the upkeep cost almost nothing. The expense and trouble of maintenance was with the animal power necessary to move the vehicle. The first cost of

Fig. 49.—Two Methods of Applying the Knox-Martin Tractor to Conventional Types of Horse-Drawn Fire Apparatus.

horses and the expense of keeping them are increasing, while the efficiency of the horse as a draft animal has remained the same. In fire department or commercial work the horse is very slow in comparison with mechanical power, so that when a tractor is attached to a horse-drawn vehicle the proven reliability of that piece of apparatus is retained, with the added advantage obtained by the use of the gasoline motor power.

The only three-wheel road tractor used at the present time was

made by the Knox Automobile Company, under the Martin patents. It has been discontinued and succeeded by the four-wheeled type shown at Fig. 49-A. As will be seen by referring to the lower illus-

Fig. 49-A.—The Knox Military Type Four-Wheel Tractor Equipped with Side Dumping Body.

tration in Fig. 49, where the tractor is attached to a steam pumping engine, this motor unit may be joined to any heavy vehicle that is designed to be drawn by horses, the combination making a five-wheeled motor-drawn vehicle. The tractor is easily attached, there being several possible methods. The simplest way, and one used when the tractor is to be employed for several pieces of apparatus or wagons, is to mount a turntable or fifth wheel on the tractor rear axle that will fit the corresponding member at the front end of the horse-drawn apparatus. The tractor may be easily attached by means of the usual king bolt, and in this case the rear axle of the tractor replaces the front axle of the horse-drawn vehicle. Another method is to bolt the front springs of the trailing vehicle directly to the tractor rear axle. All of the advantages previously enumerated for the three-wheel tractor apply just as well to the four-wheel, with the single exception of short turning radius. The group at Fig. 50 shows the tractor with rubber tires for use on hard or paved streets, and also the large variety of vehicles or trailers that can be used with it. The utility of such a tractor in hauling heavy loads is also evident from the photograph at

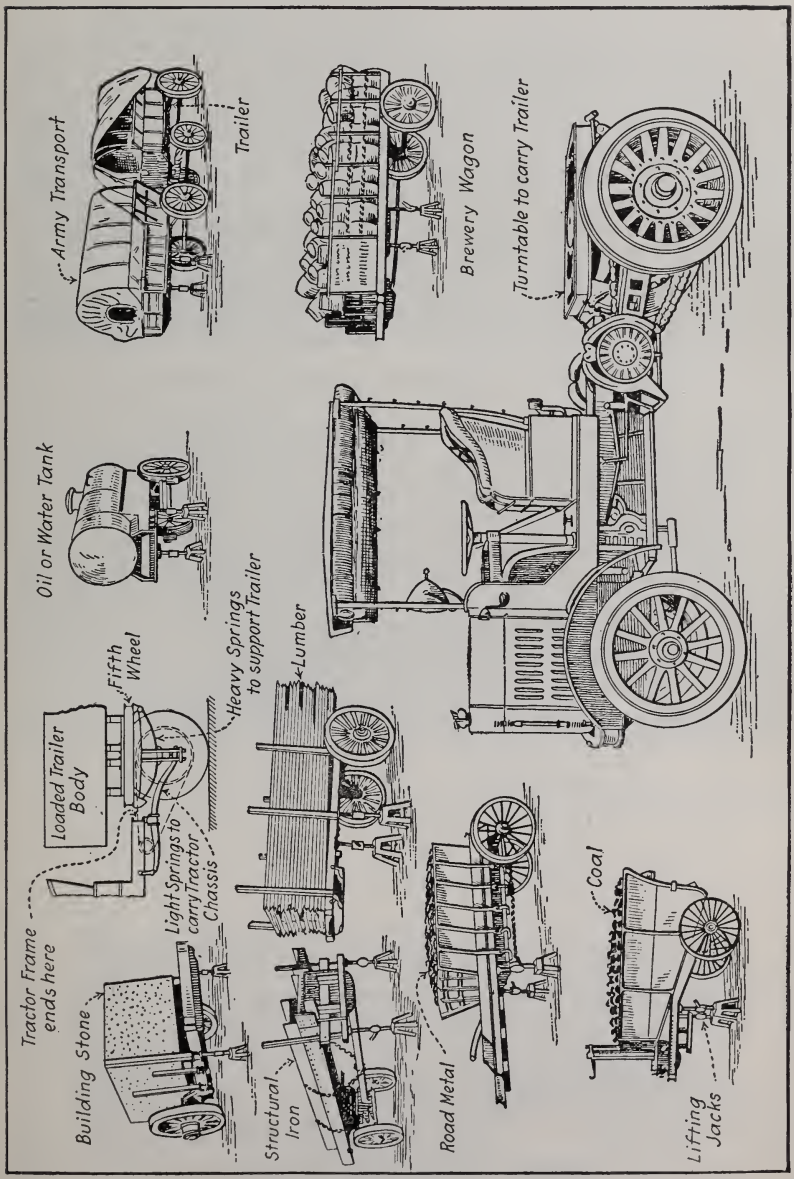


Fig. 50.—Representative Road Tractor and Various Special Trailers that May Be Drawn by a Single Tractor Unit.

Fig. 51, which was taken in Europe and which depicts a somewhat unusual load.

Fig. 51.—Showing the Use of Military Type Tractor in Hauling Heavy Guns.

Trailer Types.—There are three forms of trailers adapted for use with automobiles. The simplest is the two-wheeler form shown at Fig. 52, which can be adapted to any pleasure car chassis and used

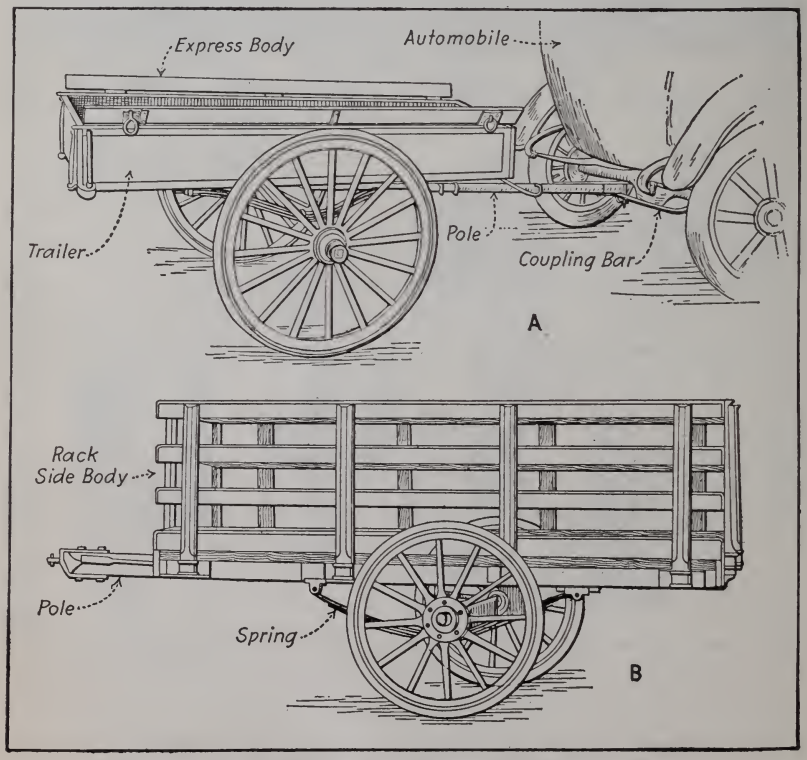


Fig. 52.—Light Trailers to Be Drawn by Pleasure Cars.

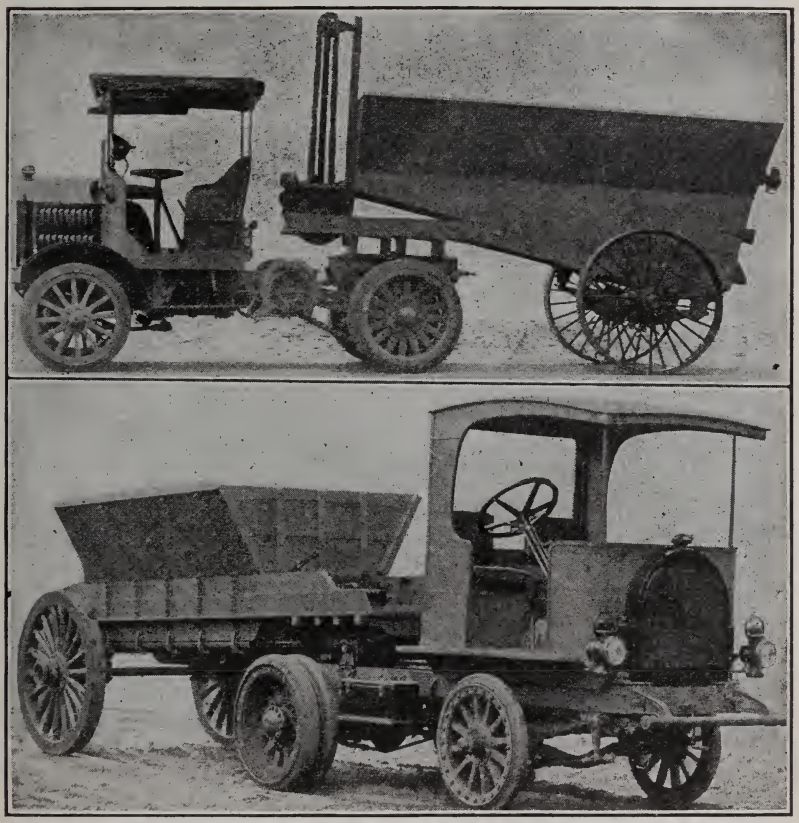


Fig. 53.—Two Semi-Trailer Outfits Adapted for Contractors' Use. The Knox Road Tractor is Shown at the Top and the Watson Tractor Hauling Bottom Dump Wagon at the Bottom.

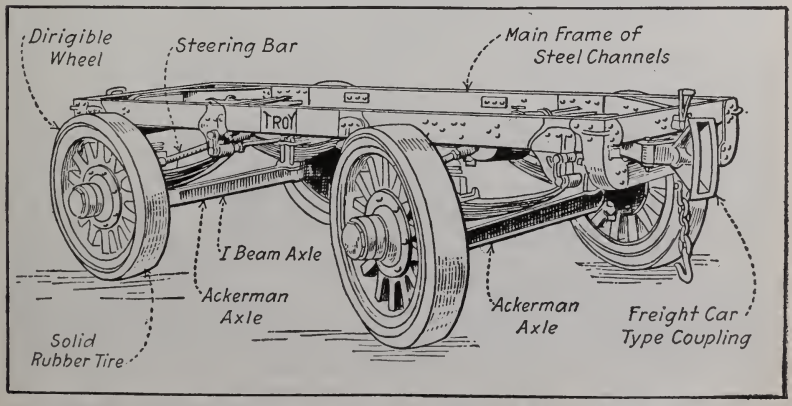


Fig. 54.—The Troy Trailer has All Four Wheels Movable for Steering.

Fig. 55.—How Road Tractor Can Handle Heavy Loads of Road Metal by Using Troy Trailers.

Fig. 56.—The Jeffery Army Trucks in Service at the Mexican Border Made Fewer Trips Because of Trailers.

for light work. The wheels are arranged at the center of the body and will carry practically all the load if it is properly distributed.

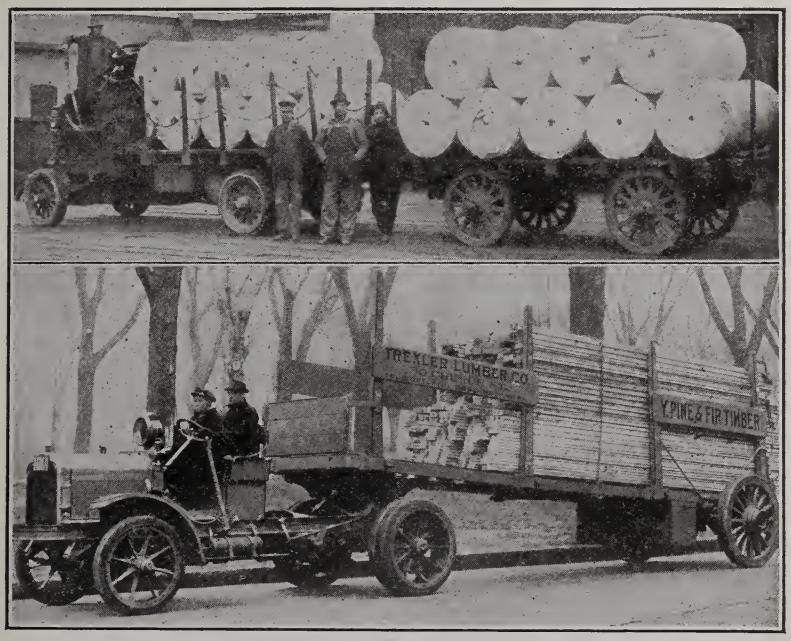


Fig. 57.—Trailer Outfits Capable of Carrying Very Heavy Loads.

They use wood wheels and small section solid rubber tires. The specifications of the smaller model, which has a capacity of 800 pounds,

Fig. 58.—The Use of Road Tractor and Trailer in Contracting Work.

are as follows: Body, solid panel, 72 by 51 inches, 10 inches high, with 6-inch flareboard; springs, semi-elliptic underslung; axle, ¼-inch square, bearings, ball; wheels, hickory with 30 by 1¾ solid clincher tires; painting, body red and wheels yellow with black striping; weight crated, 375 pounds. The 1,200-pound model specifications: Stake body, 8 by 4 feet; side and end gates, 18 inches high, all removable; springs, semi-elliptic underslung; axle, truck type I-beam section, 2 by 1½ inches; bearings, anti-friction roller; wheels, hickory with 32 by 2 solid clincher tires; painting, black; weight crated, 445 pounds. Automatic couplers are fitted, and these can be attached and detached in a few seconds. Then there is the semi-trailer, which has but two wheels, as shown at Fig. 53. These cannot be used without specially built tractors to receive their front end. They may be made in infinite variety and are well adapted for heavy loads. The Troy trailer, which is shown at Fig. 54, is a four-wheeler type having the wheels carried on steering knuckles so joined by levers that the wheels will track when rounding curves. This feature makes it possible to use several of these trailers, which are very substantial in construction, in the form of a road train behind any motor truck of sufficient capacity. As the trailers carry all the load, the truck is not called upon to carry any weight except that loaded into its body. In the semi-trailer type, part of the load must be carried by the tractor rear wheels, and we have what is in effect a six-wheeled automobile, articulated in the middle so the front and rear may assume different angles to facilitate steering. Very interesting applications of tractors and trailers are shown in Figs. 55 to 58, inclusive.

Other forms of tractors have been devised for hauling very heavy loads in which four driving wheels are employed to secure better traction. Some of the four-wheel drive tractors are of the gasoline-electric type and all four wheels combine directive and tractive functions, as the electric motor imparting power to the wheel is housed in its interior. The four wheels are mounted on steering knuckles, so they may be turned to any desired angle for steering. A tractor of this form is shown at Fig. 60, and is of the Couple-Gear type. The power is generated by a four-cylinder gasoline motor which drives a dynamo, and the current from this dynamo is directed through a suitable controller to the motors in the four wheels. This system of drive is specially well adapted to moving very heavy loads, and the adaptability of the Couple-Gear tractor in hauling an extremely large and heavy coal wagon is clearly depicted. A full description of this method of drive will be found in the chapter on Power Transmission.

Two-Wheel and Four-Wheel Drive Trucks.—Trucks have been devised in which the power is applied directly to the front wheels, which are also used for steering. The Hoadley system two-wheel tractor is shown at Fig. 59, attached to a low gear and demon-

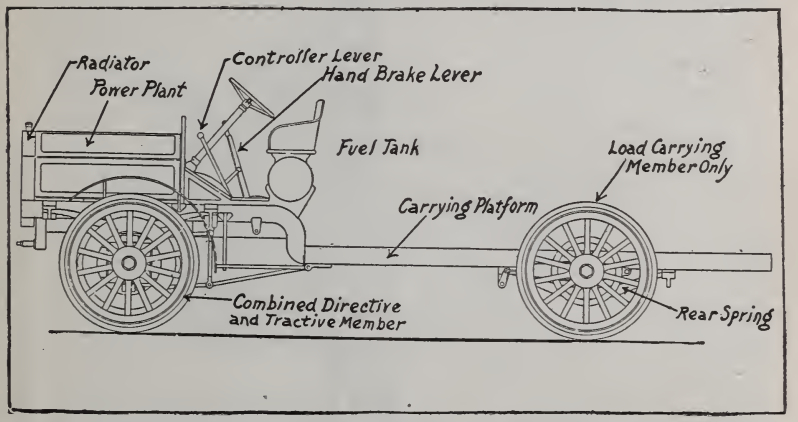


Fig. 59.—Application of the Hoadley System Two-Wheel Drive and Steer Tractor to Heavy Low Gear.

strates clearly the advantage of this method of drive under conditions where the usual system of automobile construction could not be carried out because of the low carrying platform. The front wheels may be turned at an angle for steering and receive power

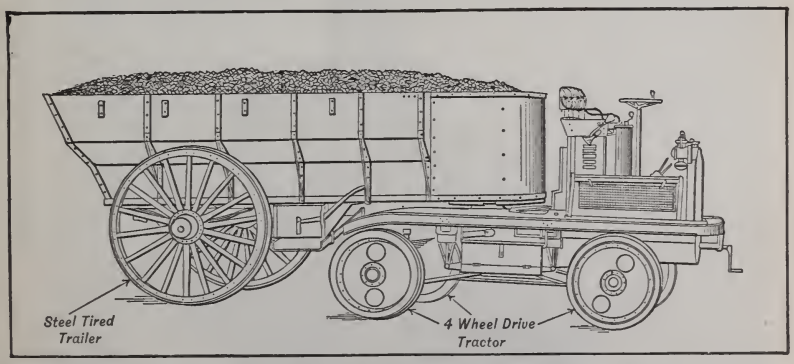


Fig. 60.—The Couple Gear Four-Wheel Drive and Steer Tractor Attached to Large Coal Wagons.

from electric motors, one being attached to each wheel. As is true of the Couple-Gear system, the Hoadley tractor uses a gasoline engine to generate electricity and uses the electric current to drive the traction members.

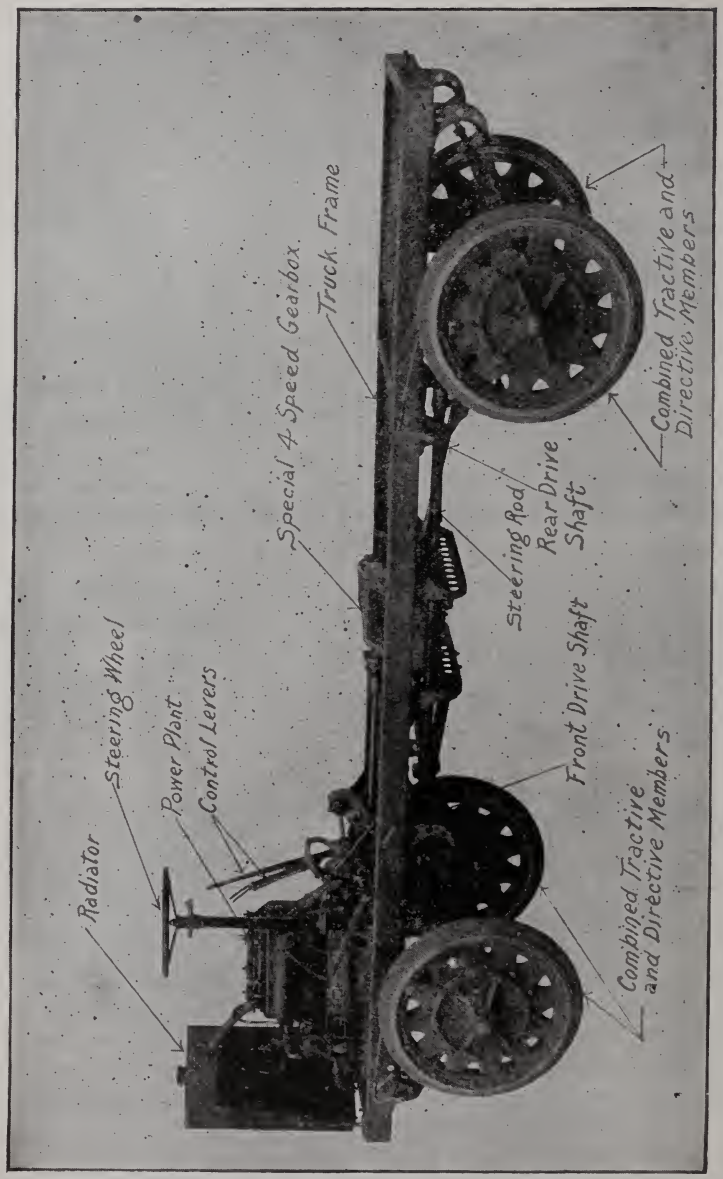


Fig. 61.—The Jeffery Four-Wheel Drive and Steer Motor Truck Chassis.

The Jeffery four-wheel drive truck chassis is shown at Fig. 61. This is a straight mechanical drive construction and the four wheels are adapted to be driven by gearing, as well as swung around at the

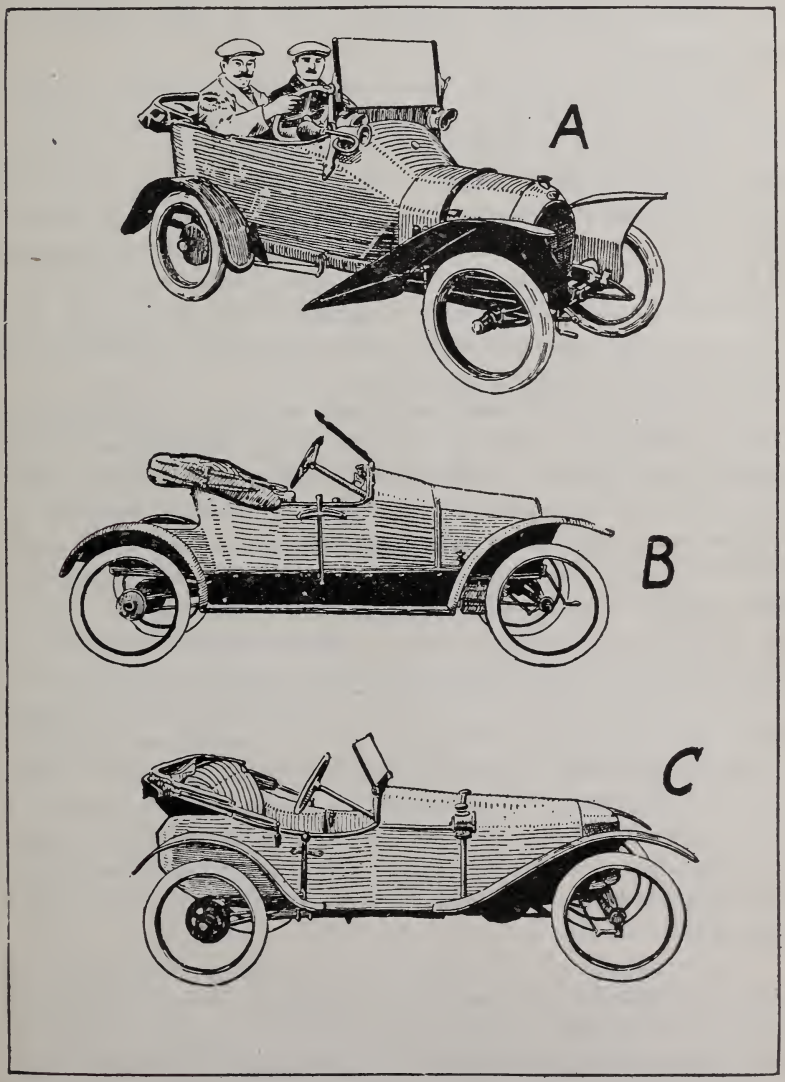


Fig. 62.—Forms of Light Cars of Foreign Design Included in the Cyclecar Class.

angle necessary for steering when desired. It is claimed that the four-wheel drive system of construction makes for better load distribution on the frame, springs and axles, and that superior traction

is obtained by the use of four driving members. Adherents of this construction contend that the four-wheel drive principle will enable a power-propelled vehicle to secure traction on any road or any other conditions of operation where animal-drawn vehicles can be used. Both the front-wheel and four-wheel drive are fully described in proper sequence.

Light Cars and Cyclecars.—Considerable interest was evinced during 1915-16 in a new form of motor vehicle, known as the "cyclecar." These small vehicles were of two general types, neither of which received wide application. Some of the vehicles that were termed "cyclecars," as shown at Fig. 62, are in reality miniature automobiles and do not conform to the precise definition generally accepted for cyclecars. While engineers and designers disagree upon the characteristics of the new vehicle, it is generally believed that the term "cyclecar" should be applied to light four-wheeled vehicles using motorcycle parts in their construction.

The cyclecar has received considerable attention abroad, and it is claimed that it is made in reasonably large quantities in both England and France. Cars of the miniature automobile type are not likely to be as popular in America as in Europe owing to the development of the many light, moderate priced cars, such as the Ford, Saxon and others. They cannot be built as cheaply as a certain light car that is produced in very large quantities in this country and which gives exceptional service. The car shown at A is the baby Pugeot and is a French design employing a four-cylinder water-cooled motor of about 10-12 H. P., a sliding gear transmission and shaft drive to a live rear axle. In all respects it follows automobile practice. The form outlined at B is an English design known as the "Humberette." This employs a two-cylinder air- or water-cooled motor. It uses a geared transmission and also has shaft drive to a live rear axle. The form depicted at C is the Auto-Carrier's four-cylinder model and is an English design patterned more after the automobile than the motorcycle.

As an example of the method of construction followed by the designers of miniature automobiles, the chassis of the Marlborough small car is depicted in both plan and side elevation at Fig. 63. As will be seen, the general design follows regular automobile practice very closely, starting with the four-cylinder water-cooled block motor at the front end and the flywheel clutch, sliding gearset, and shaft drive to a live rear axle. That it is a miniature car, however, is apparent if one considers that the motor is rated at about 12 H. P. and that the tread is but 36 inches. The frame is very narrow and is

arranged so that two passengers are carried tandem fashion, with the driver in the front seat. The only respect in which a chassis of this form may be considered as following motorcycle practice is in the use of wire wheels, small tires, and motorcycle type mud-guards. In all other respects it is a miniature motor car and will cost as much to build, if it is not actually more expensive in construction than the popular American runabout.

The original cyclecar was designed to take the place of the motorcycle and sidecar combination that has been very popular in Europe, even more so than in this country. This is shown at the top of Fig. 64, is known as the "Bedelia," and a model was built by M. Barbeau, of Paris, France, as early as 1910. This was a very small automobile driven by a motorcycle power plant. Its weight was less than 400 pounds and it had a tread of 36 inches. The wheel-base was 100 inches, and as it was very low, the passengers were carried very comfortably. It was made to accommodate two persons, the passenger being seated in front, while the driver sits over the rear axle. On the modern forms the twin-cylinder motorcycle engine of about eight H. P. is placed just behind the front axle and drives a countershaft which is crosswise of the chassis under the passenger's seat by a roller chain. Pulleys of the motorcycle type suitable to take the regular V belt are attached to the ends of the countershaft, and these impart motion to the large belt pulleys on the rear wheels by means of motorcycle belts.

An ingenious clutch action is obtained by drawing the rear axle forward when it is desired to stop the car, as this makes the belt run loose and enables the motor to turn without driving the wheels. A further movement of the hand lever brings the rear axle forward far enough so the belt pulleys engage fixed brake blocks or shoes which arrest motion of the wheels. The steering is by means of a wire-spoke hand wheel which turns the whole front axle through a drum on the steering shaft and a steel cable connection through pulleys. The axle is hung at a central point in a steering head very similar to that of the bicycle.

The first public appearance of the car was in a road race over a course one hundred and thirty-eight miles long, and this small vehicle surprised the public, and more so its inventor, by averaging thirty-eight miles an hour the entire distance. The same car attained a speed of fifty-five miles per hour on a track. This resulted in a large demand for these cyclecars and induced many manufacturers to enter the field.

The De Cross cyclecar, which is shown at Fig. 64, is an American design patterned largely after the Bedelia. The Lester is a

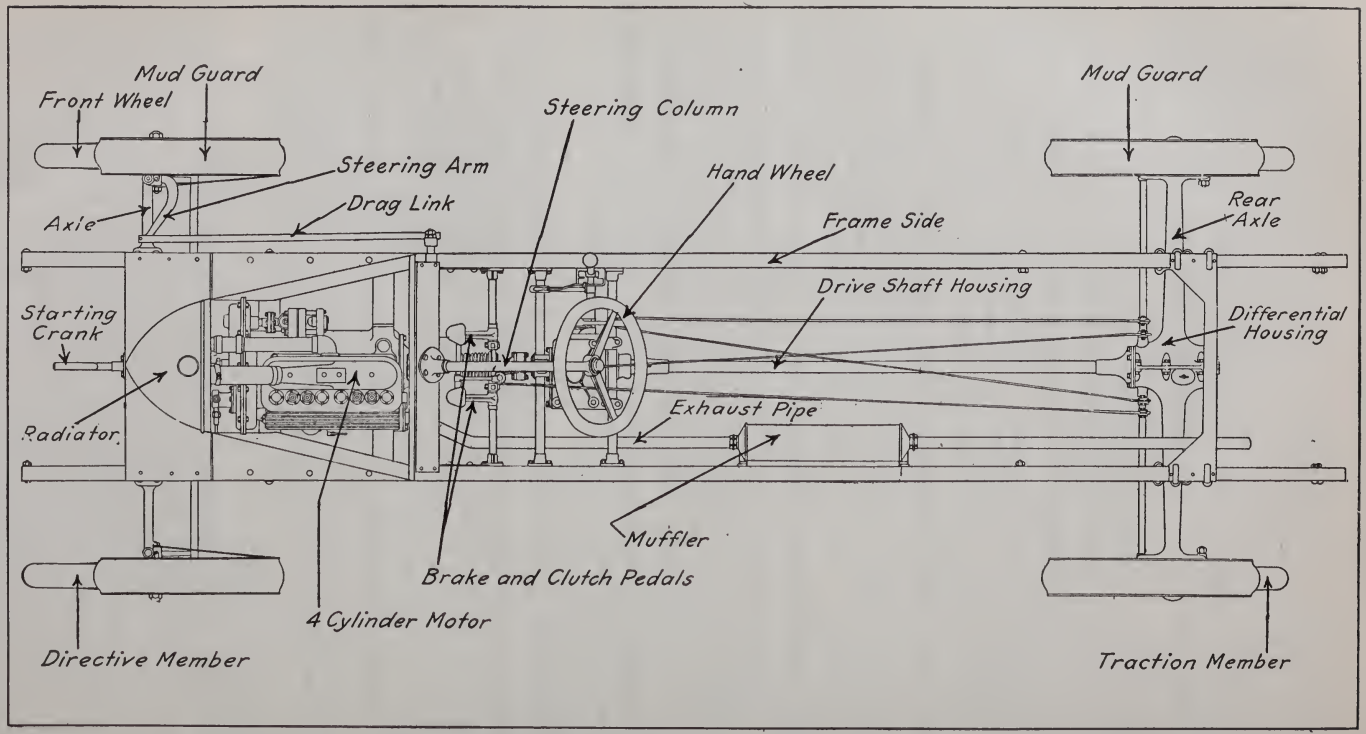


Fig. 63—Plan and Side Elevation of Marlborough (English) Cyclecar Chassis, Which Is Built on Regular Motor Car Lines, But on a Miniature Scale.

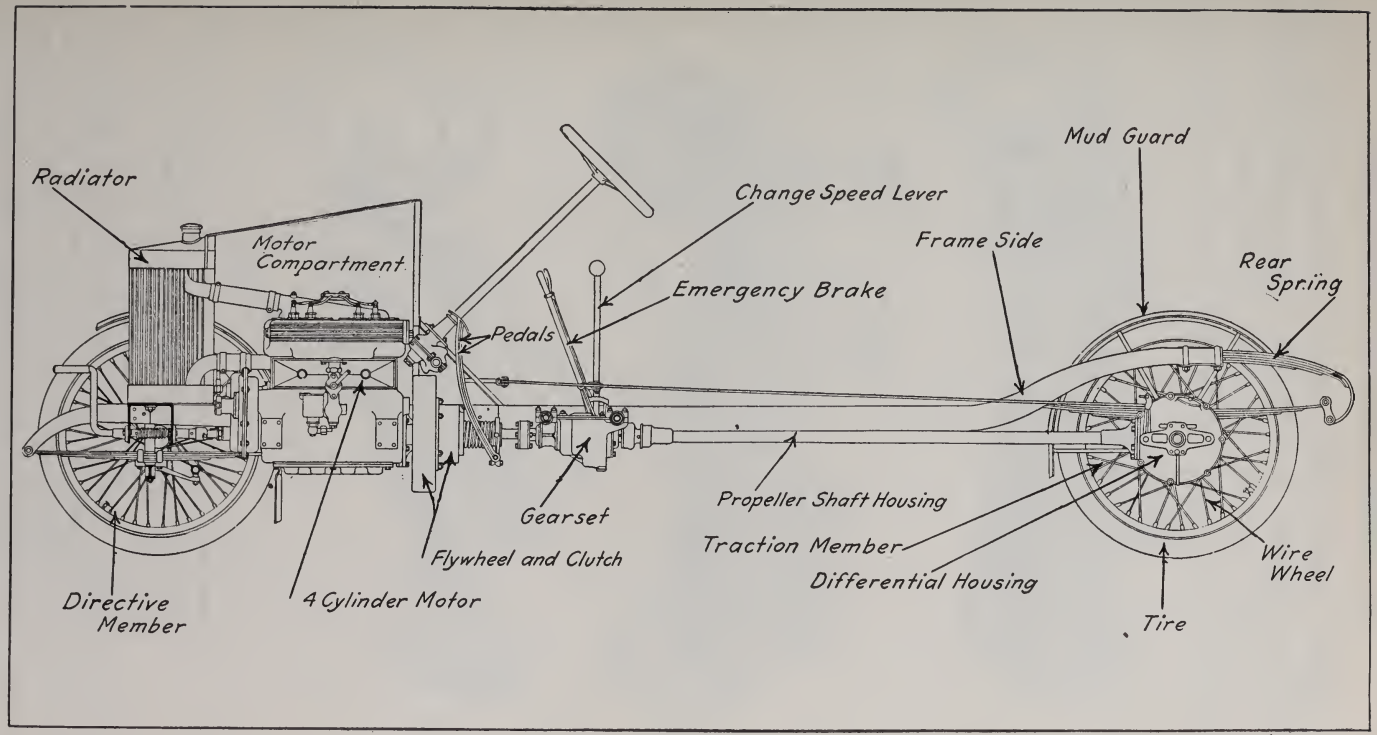


Fig. 63—Continued.

light English design adapted for but one passenger and is a true cyclecar in all respects, as the motor is an air-cooled type and the drive to the rear wheels is by means of motorcycle belts.

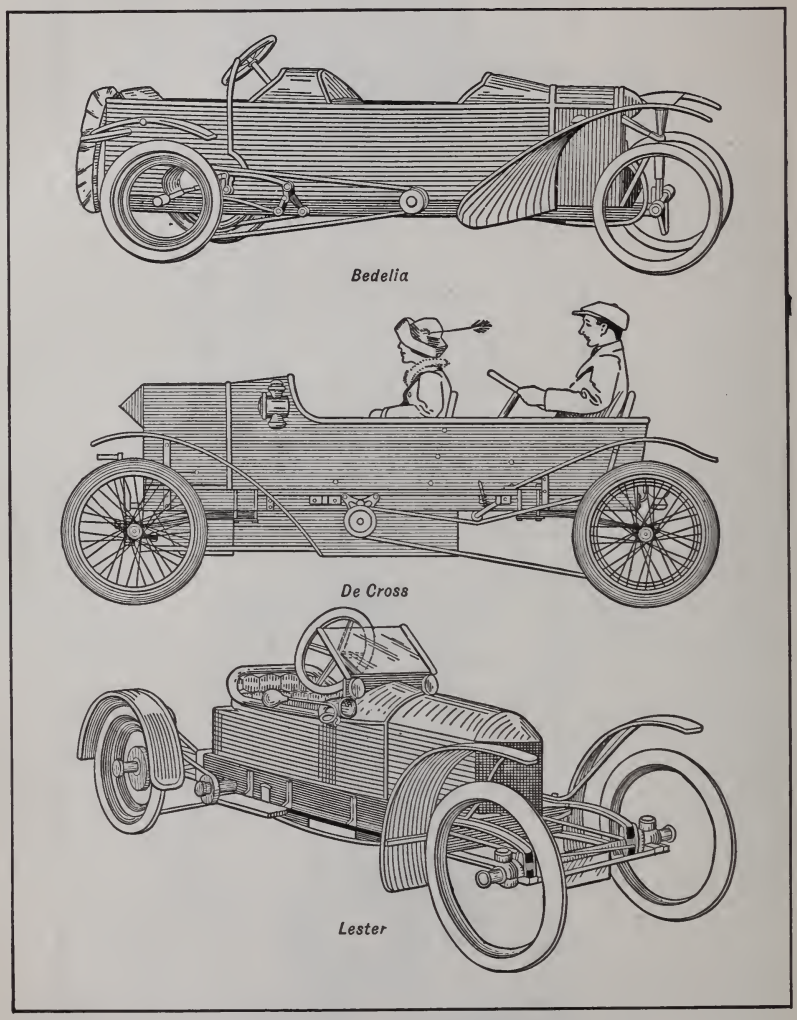


Fig. 64.—Representative Types of True Cyclecars.

The first Bedelia type cars built in England were patterned very largely after the original design, but very soon the demand was for more artistic body designs and more luxury, so that at the present time many of the vehicles produced in England that are called cyclecars are really small automobiles that sell for as high as $1,000,

although they still retain the narrow tread, which is considered a feature of decided advantage, inasmuch as it permits the cyclecar to be housed in a small shed and avoids the necessity of special full-size garage facilities. It is claimed that the 36-inch tread construction is not suitable for American roads because it will not track with other vehicles which use the standard tread of 56 inches. It is, of course, admitted that the main highways of Continental Europe and of England have exceptionally good road surfaces. In France, however, where the first cyclecars were produced, there are plenty of byways with ruts worn by traffic which, while perhaps not as bad as the majority of country roads in America, offered ample opportunity to test the practicability of the narrow-tread cyclecar. As there has been no change in the tread of the Bedelia in three or four years, and as the narrow tread has been continued by other French and English designers, it is apparent that the narrow tread gave satisfactory service. The usual width of the road ruts in America is 7 or 8 inches and they are 56 inches apart, which means that there is approximately a space of 42 inches between the wheel tracks, which should be ample to allow a vehicle of 36-inch tread to pass between them. Cyclecars were not well received in this country, and there are none manufactured here now, though it looked for a time as though there would be considerable demand for them.

The chassis of a simple form of English cyclecar in which a friction-disc transmission is employed to obtain the various speed ratios, and which derives its power from a small four-cylinder motor, is clearly shown at Fig. 65. This chassis is more on the light-car order and can be compared to the true cyclecar form at Fig. 64, to enable the reader to make comparisons between the two methods of construction. It will be observed that the chassis construction outlined at Fig. 66 is a four-wheel motor vehicle reduced to its simplest form. The engine, which is an air-cooled motorcycle type having two cylinders set at an angle, is secured at the front end, where it will get ample cooling, and is located immediately under the torpedo-shaped gasoline tank. The wire wheels are carried by miniature steering knuckles attached to a light tubular front axle. The spring suspension at the front end is by quarter elliptic leaf springs which combine the duties of a resilient support for the frame as well as distance or radius rods for the axle. The wood frame is extended to the rear, where it tapers to a point, and in most cyclecars it is made of ash. The drive from the sprocket on the engine crankshaft is by a motorcycle roller chain to a larger sprocket on the countershaft. At each side of the countershaft V belt pulleys

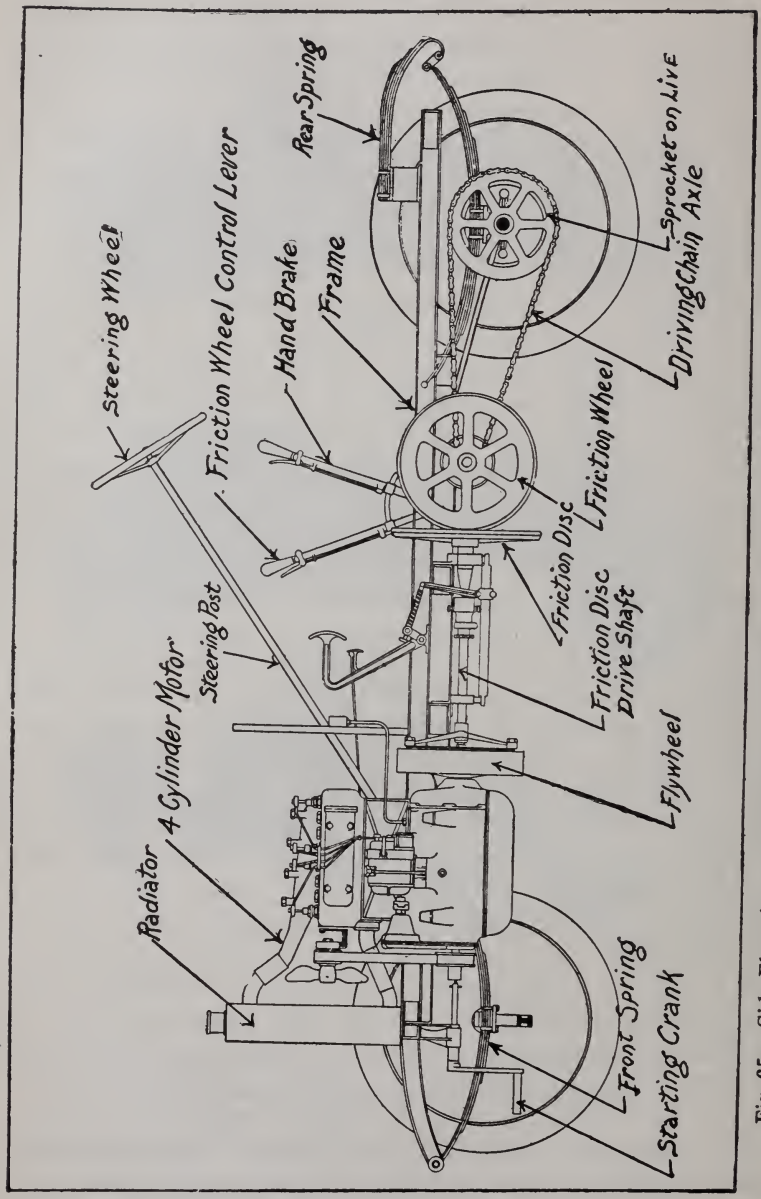


Fig. 65.—Side Elevation of Pilot Light Car Chassis. An English Design Employing Friction Disc Drive.

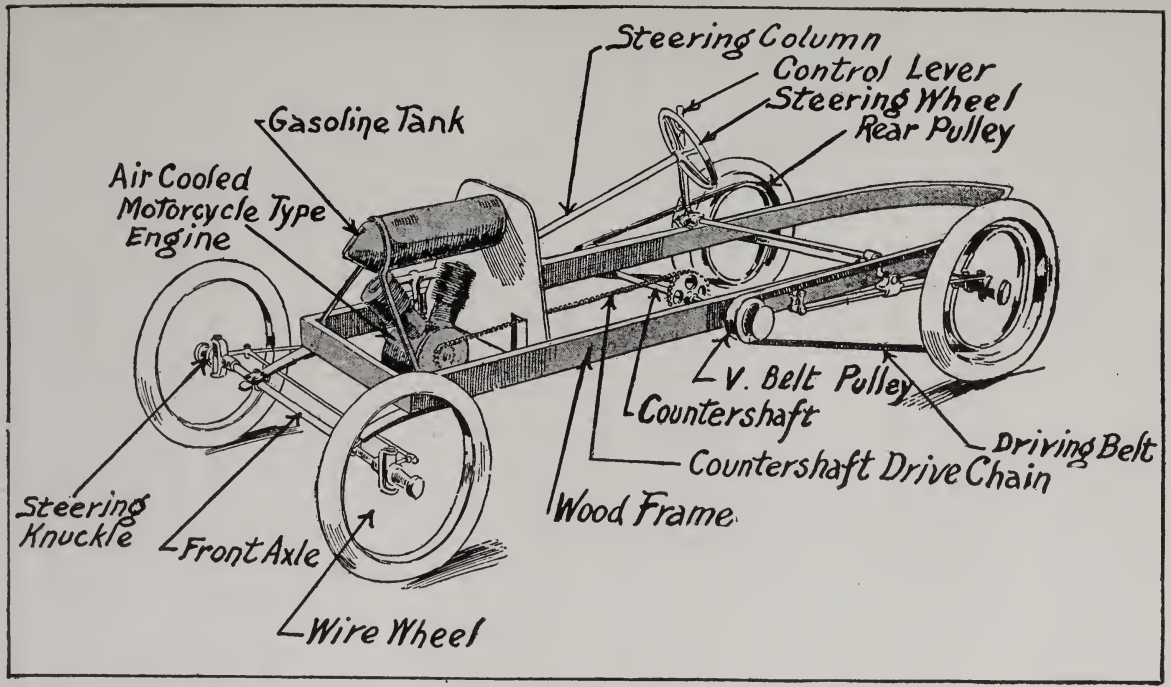


Fig. 66.—Chassis of Extremely Simple Cyclecar Type, Showing Location of Parts and Relation to Each Other.

are mounted which drive the rear wheels through leather belts. In the simple form shown the clutching action is obtained by sliding the axle back to tighten the driving belt and produce forward motion, while it is pushed forward to loosen the belt and obtain a free engine action by the belt slipping over the pulleys. The simple arrangement shown is varied in other constructions by placing the power plants crosswise of the frame and utilizing a friction-disc transmission, to obtain the varying speed ratios. In such a case the movable friction wheel will be moved back and forth on the countershaft to obtain different speed ratios, while the friction disc will be pulled out of contact with the friction wheel when it is desired to interrupt the drive to the rear wheels.

Agricultural Automobiles or Gas Tractors.—During the past decade there have been important advances made in the application of gas power to agricultural purposes, and now practically all farms of any size in the United States or Canada are tilled by plows drawn by mechanical power and the crops threshed by the same means. These large machines are really automobiles and in many respects follow automobile designs, especially as relates to power generation and transmission, though on a much larger scale. A few paragraphs outlining the requirements of the ideal tractor and a consideration of several types that follow automobile practice will enable one to form an intelligent idea of the main features of a well-developed modification of the commercial type of automobile.

The requirements of the ideal tractor can be summed up as follows: First, it should have universal adaptability, in order to be able to accomplish all kinds of belt or drawbar work, as it is only by having a machine that is applicable to a large variety of tasks that one can justify the investment needed to purchase a practical machine. It should be capable of operating every machine on the farm that requires power.

Second, it should have correct weight for the work it is to do and the proper arrangement of components. A logical distribution of weight is necessary to insure proper traction. If the machine is too heavy it will pack the soil and much power will be consumed in moving the huge mass over the ground. The factor of weight is especially noticeable when climbing grades. If the tractor is too light, it will not have adequate adhesion with the ground and much power will be lost in slipping between the driving wheels and the ground. The weight should be distributed so the greater part of it will come over the rear wheels, as in most constructions these are called upon to do the driving.

Third, there should be a large contact area between the traction members and the ground in order to avoid loss of power, packing of soil, and slipping. It should be provided with change speed gearing that will provide at least two forward speeds and a reverse motion. The drive from the power plant to the rear wheels should be positive and designed so that there will be minimum loss of energy through friction in gearing.

Fourth, it should be of consistent design for the work it is to do, built of the best materials that can be obtained within reasonable limits and incorporate in the construction strength without excessive weight. The entire mechanism, including the power plant, should be simple, because lack of complication is practical insurance against mechanical trouble.

Fifth, it should be easy to start and the control elements should be designed so the tractor can be directed without undue expenditure of energy. The simpler the control members, the easier the average farmhand will find it to handle the machine. The construction should be such that an automatic steering attachment can be used in certain classes of work, such as plowing, so the engineer may devote part of his time to manipulating the plowshares.

Sixth, it is desirable that the engine be capable of operating on any liquid fuel, especially the cheaper and more plentiful distillates of petroleum.

There are a number of tractors offered at the present day that meet all of the above requirements. The construction is good, both from an engineering and practical point of view. The machines are economical to maintain and operate, and in many cases, especially in power plant and driving mechanism design, useful lessons have been drawn from current automobile practice. It is safe to say that the tractors which more nearly incorporate the good features and ideal requirements are those which follow, in a modified form, some of the rules of practice established by automobile designers. In essential elements the automobile and tractor are similar. It is merely in detail arrangement of parts that they vary.

A tractor that has been well received by many farmers is built on the order of the motor truck used in cities for hauling merchandise. It will carry a load of three tons in the wagon bed with which it is provided and has a pulley for driving stationary machines. A drawbar is provided for pulling plows and other machines requiring draft. The weight of this truck is carried on four wheels, therefore when used for plowing, ballast must be put over the driving wheels in order to provide proper traction. As the machine is spring

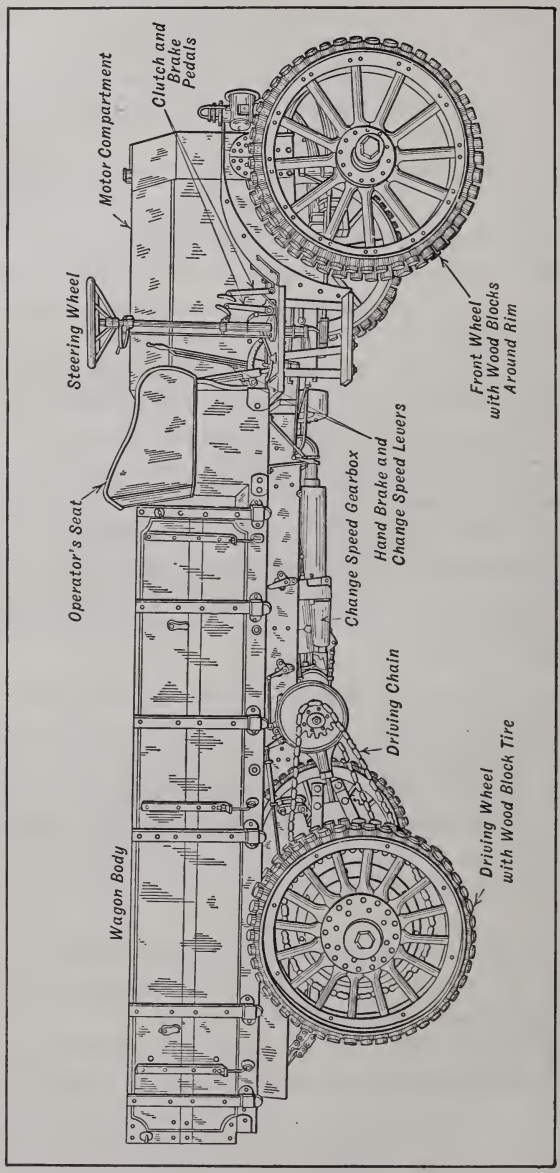


Fig. 67.—The Avery Farm Truck, Designed for carrying Loads or for Use as a Tractor in Hauling Farm Machinery.

mounted and adapted to speeds from two to fifteen miles per hour, it can be used for a wide variety of work. Instead of using rubber tires as the ordinary motor truck does, the wheels are provided with wooden plugs to adapt the tractor to hard roads. Traction on soft ground is provided by an extension rim with a number of mud lugs attached, which is so fastened to the wheel that these automatically grip the soil when the wheels sink to a certain depth. It is also possible to move a hand lever on each driving wheel which causes a series of sharp spikes to project beyond the periphery of the wheel to increase traction when desired.

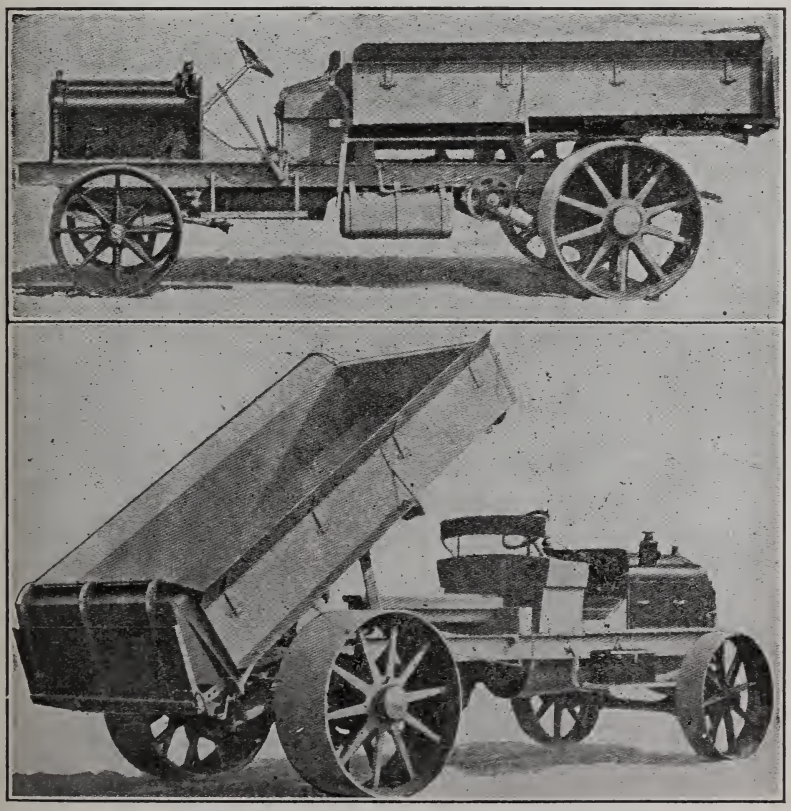


Fig. 68.—The White Truck-Tractor, which Has Many Possible Applications on the Road and in the Field.

Machines of this nature are shown at Figs. 67 and 68, which clearly outline the general construction. As will be seen, in general form it does not differ radically from the usual type of motor truck. As

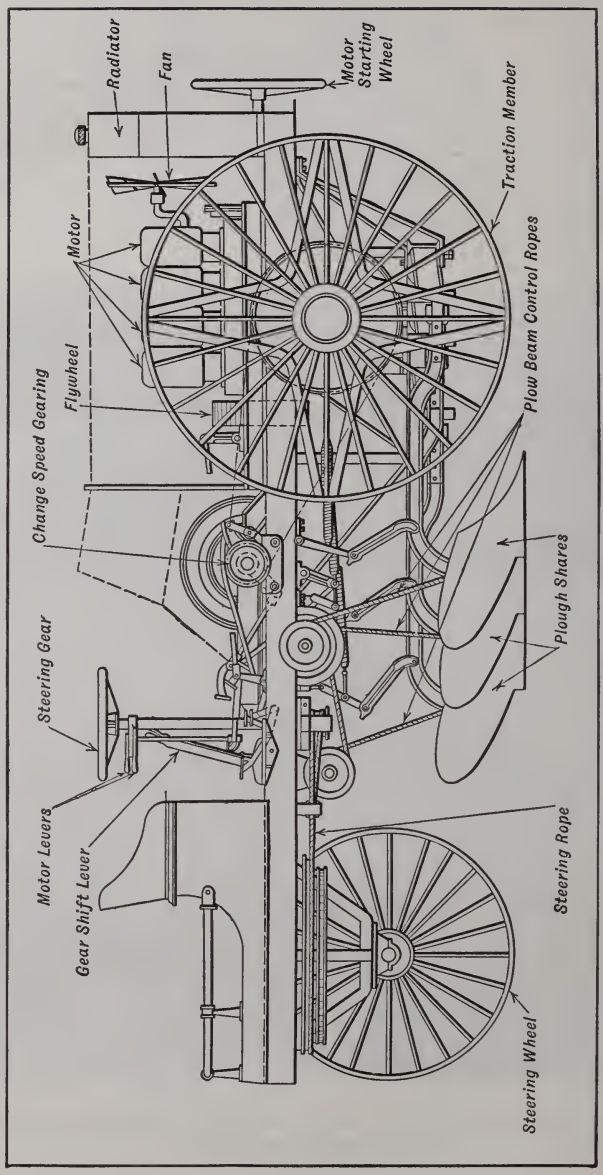


Fig. 69.—Side Elevation of the Hackney Auto-Plough.

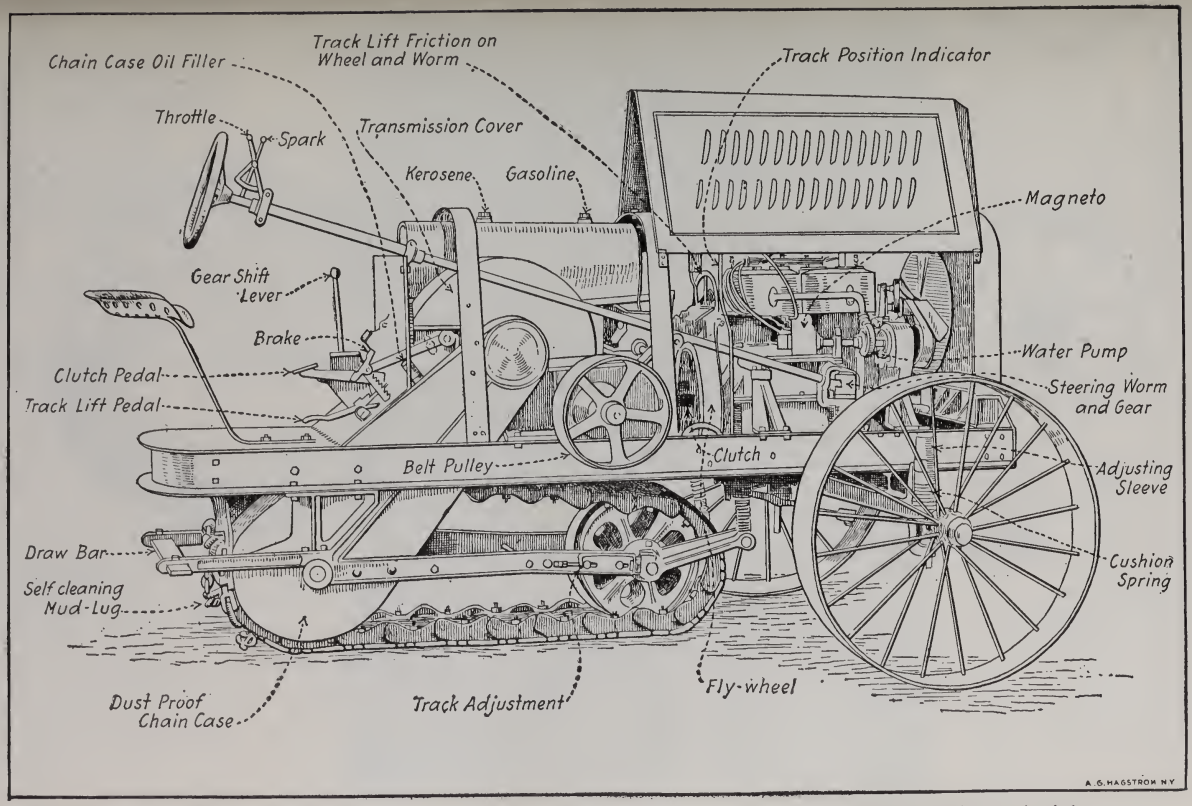


Fig. 70.—Farm Tractor Having Traction Member Operating on Track Laying Drive Principle.

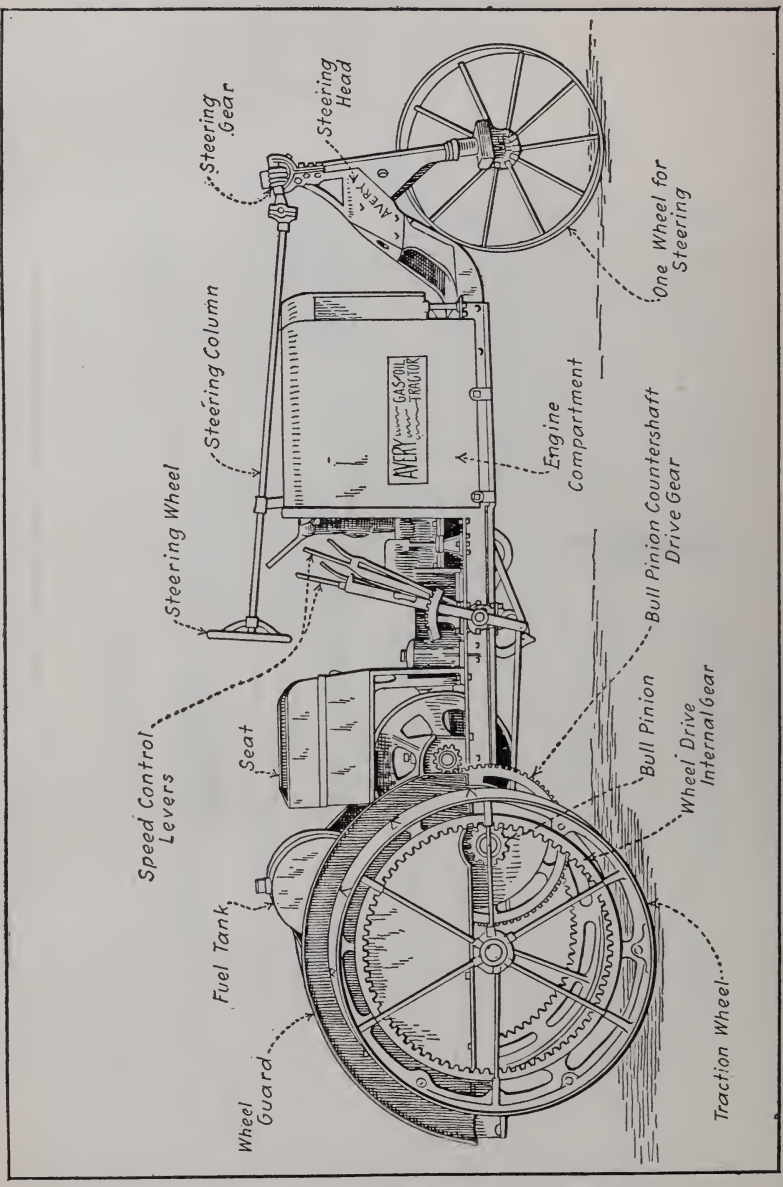


Fig. 71.—Light Three-Wheel Agricultural Tractor Following Automobile Construction in its Main Essentials.

it is provided with a wagon bed, it will haul grain, hay, stock, coal, lumber, milk, fruit, vegetables and other kinds of merchandise. It has sufficient tractive power to pull three 14-inch plows and a harrow in ordinary stubble plowing and will complete an acre an hour. It will pull two disks, two spike harrows, two seeders, two binders, corn planters, a road grader, a train of loaded wagons, or any other machinery. It has a draft equal to ten horses. This general purpose machine, therefore, is ideal for the small or medium-sized farm, as it will not only haul loads of all kinds on its own body,

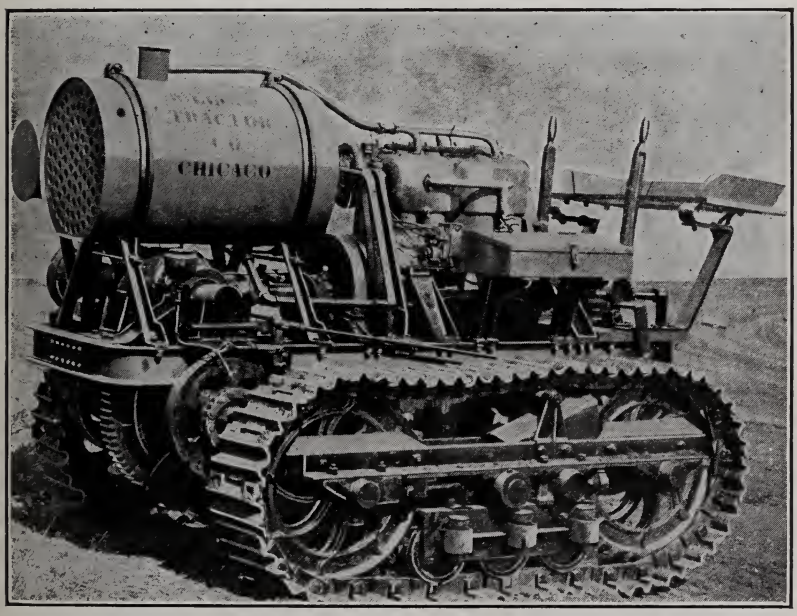


Fig. 71A.—The Bullock Agricultural Tractor Uses Track-Laying Principle of Propulsion and Support.

but will do field work and serve as a portable belt-power plant when desired.

Automobile Plow.—A form of automobile which has been designed especially for agricultural use is depicted at Fig. 69. This is a self-contained automobile plow having three shares carried underneath the frame. The front wheels are employed for traction and are driven from sprockets on the countershaft by means of roller chains. The motor is carried at the front of the machine and is mounted directly over the front axle. It drives a transmission gear carried on the countershaft and is controlled just the same as

the regular form of automobile motors by control levers attached to the steering wheel, which regulate the motor speed by varying the time of ignition and amount of gas supplied the cylinders. A single rear wheel is carried at the back end of the frame and is adapted to be moved by steering ropes controlled by the hand wheel. This rear wheel is depended on for steering, whereas the front members are employed only for traction. It is claimed that when the plowshares dig into the ground the traction members have sufficient adhesion to draw them through the most resisting soils.

Farm Tractors.—Other forms of tractors have received very wide application in our middle West that follow automobile construction to some extent, as far as power plant location, method of power transmission, speed changing, etc., are concerned, though the large size of the driving wheels and the massive construction of the frame, power plant, etc., resemble more the design of the steam road rollers we are all familiar with, rather than having the appearance usually associated with the conventional automobile. A tractor of this type is clearly outlined in Fig. 70. Modified designs of lighter weight are also well developed, such as shown in Fig. 71. The reader who is interested in tractor design will find much to interest him in the writer's treatise on this subject, "The Modern Gas Tractor."

Armored Automobiles.—The European war has produced the development of special types of automobiles, designed for quick transit of rapid fire guns and their crews. All portions of the cars are protected by alloy steel armor plates. The design shown at Fig. 72 is a patented construction in which a revolving turret capable of mounting two machine guns or rapid fire guns of light calibre is used. The illustration gives the side elevation, plan and rear views of the truck, as well as a plan of the turret showing the various constructional features. Under modern conditions of warfare the cavalry forces that were formerly depended on for reconnoitering are useless for present day work, as they are unable to withstand the effects of modern high power artillery or rifles. On the other hand, armored motor cars can pass practically unharmed through a withering rain of rifle or machine gun bullets. The revolving turret permits the fire of the guns to be directed against the enemy irrespective of the direction in which the truck is travelling. All vulnerable machine parts are protected by substantial plates of armor steel. The radiator is protected by swinging doors of steel, which may be operated with a rod from the driver's seat and which can be closed when the automobile is subjected to gun fire. The sides of the body are brought down low enough to protect the engine base, transmission case and other parts

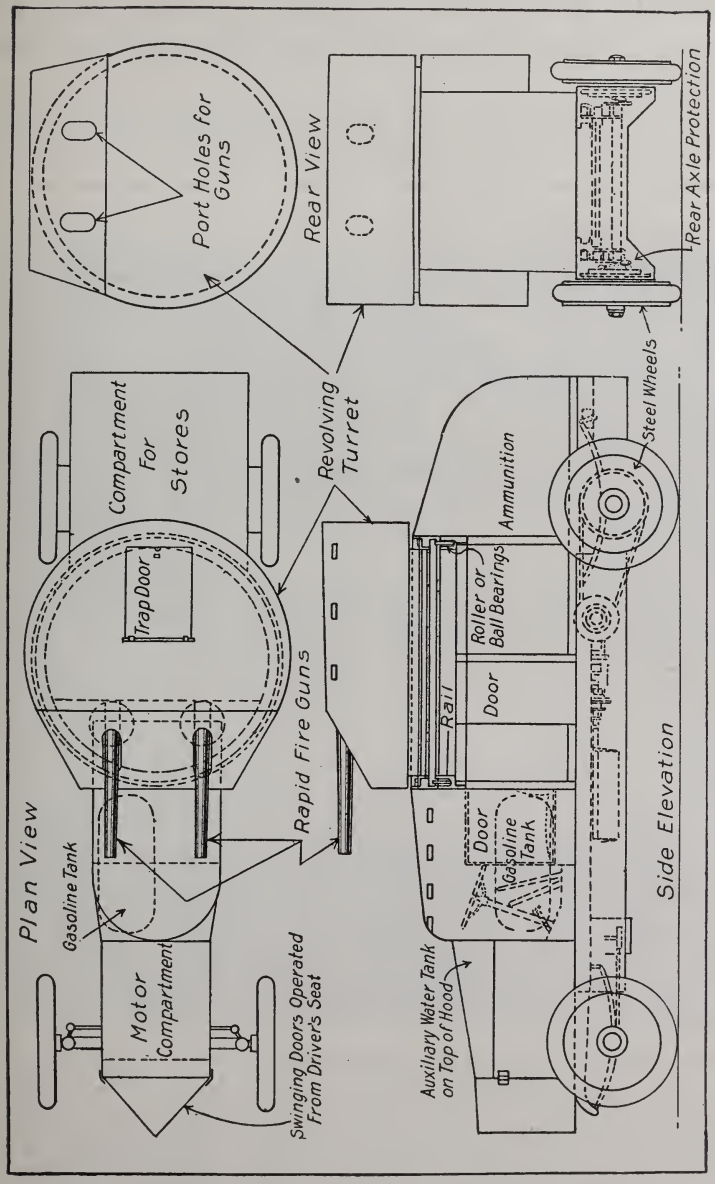


Fig. 72.—Armored Automobile Design Having Revolving Gun Turret.

that are exposed in the conventional chassis. Steel wheels and solid tires are used in preference to wooden wheels and pneumatic tires, which would be more subject to destruction by bullets. These war machines are usually geared for high speed and provided with high powered motors.

The plans outlined at Fig. 73 show the conversion of a 2-ton Mack A. C. type chassis to an armored car of great offensive and defensive

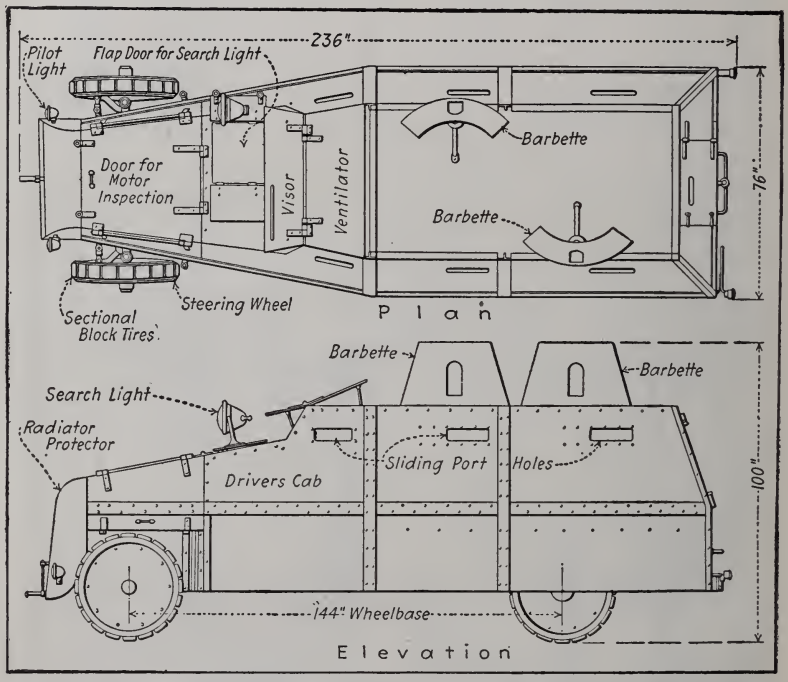


Fig. 73.—Plan and Side Elevation of Two-Ton Mack A. C. Armored Truck.

capacity. It weighs but 9,000 pounds complete with body and equipment, a remarkable figure when one considers the amount of armor plate carried.

The radiator is of specially large size to insure cooling under difficult operating conditions and to compensate for the somewhat restricted air circulation. The fuel tank is located below the floor, completely protected by the armor and feeding by the Stewart vacuum system. For towing purposes, a special spring-cushioned drawbar is provided at the rear, anchored to the rear frame cross-member and extending in a ring back of the rear armor plate. As most of the armor slopes toward the top, the joining of the plates has been difficult.

For this reason and also to prevent chipping the edges of the plates by bullets, butt straps are provided at all joints, thus making these doubly strong and preventing opening of seams.

To illustrate the painstaking care with which this armor has been constructed, the armor itself is cut and drilled at the steel mill and then the plates straightened to conform exactly with the drawings. They are then heat-treated and cannot be drilled or machined again without re-annealing. All bolts and nuts used in the construction of

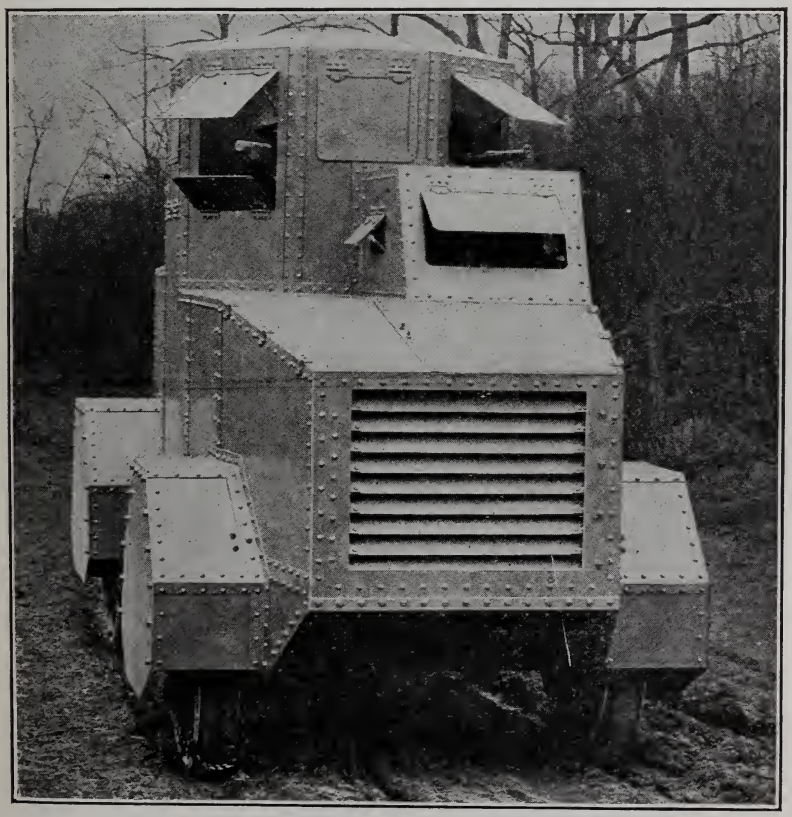


Fig. 74.—Jeffery Four-Wheel Drive Chassis with Armored Gun-Carrying Body.

the armor are of special steel, heat-treated and hardened, to prevent their being shot away. There are 600 of these bolts.

Barbettes are mounted on cast bronze frames and are arranged to pivot fore and aft and to swing from side to side. Their backward slope not only provides for bullet deflection, but permits of considerable elevation of the aim, useful in case of use in anti-aircraft work.

Detail weights of the different components follow:

Part	Lb.	Part	Lb.
Chassis	5000	Extra wt. radiator	15
Armor	2400	Fuel tank, etc	50
Frame for armor	600	Battery	67
Platform	200	Butt straps	250
Drawbar	40	Special bolts	60
Radiator guard	120	Barbettes	250
Total			9052

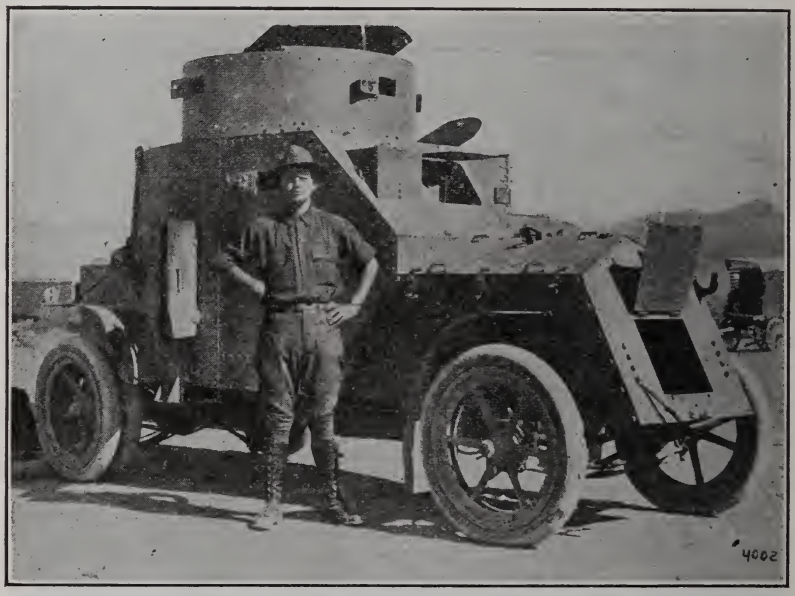


Fig. 75.—United States Army Armored Truck Body Fitted on White Chassis.

Mobile Repair Shops.—The wide use of trucks in the great war now raging in Europe has made it essential to develop special form of repair trucks that are intended to accompany motor truck convoys and keep them in proper running order. These trucks may be of two types, the emergency wagon, as shown at Fig. 76, or the field repair shop, illustrated at Fig. 77, A and B. The former is a Jeffery four-wheel drive and steer chassis equipped with a special steel body. It carries a work-bench, vise and full set of the small tools ordinarily used in making road repairs. An oxy-acetylene welding and cutting outfit and a small but very powerful derrick are carried for wrecking purposes. Coils of heavy rope, axes, shovels, picks, block and tackle, and sledges are attached to the body sides to assist in extricating mired automobiles, repair roads, bridges, etc., and for general engineering

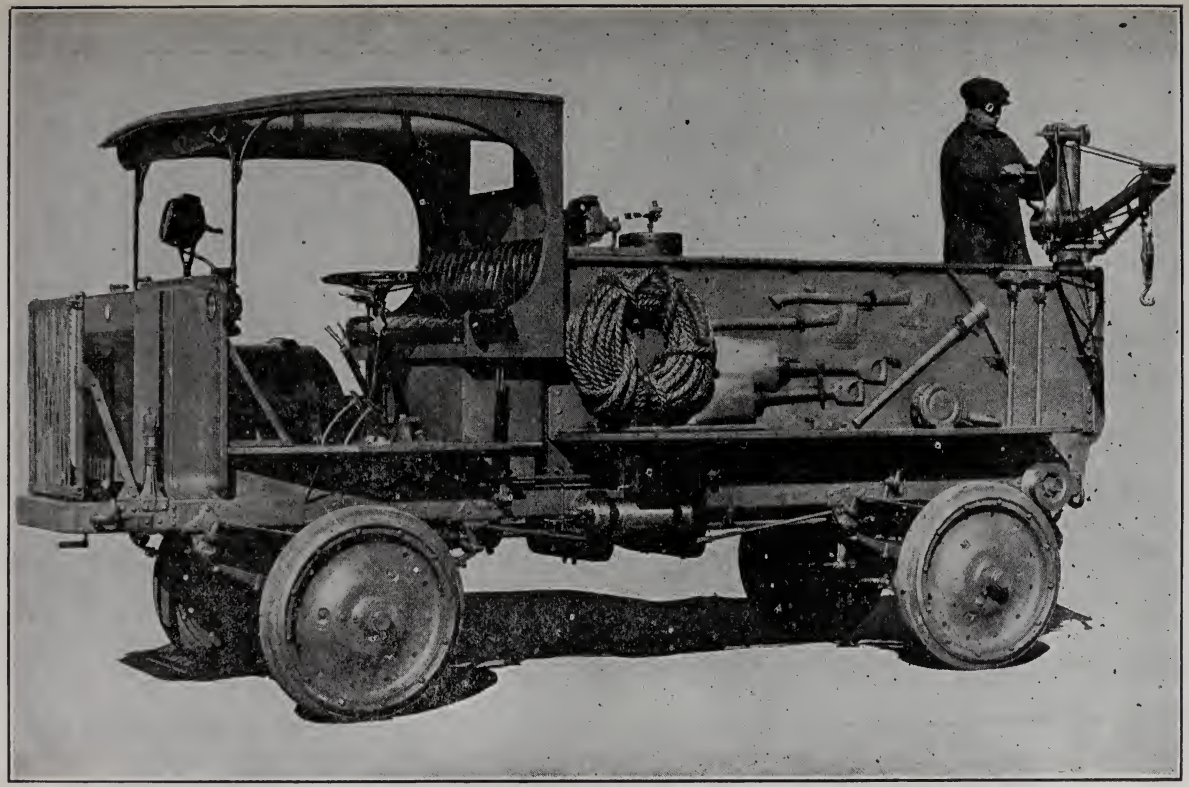


Fig. 76.—Emergency Repair Equipment for Army Use Mounted on Jeffery Four-Wheel Drive Chassis.

construction or destruction work. Winch drums or "nigger heads" are carried at the rear of the frame, these being arranged so they can be driven by the engine power, and towing hooks are attached to both front and rear of frame.

The Packard repair truck shown at Fig. 77, A and B, is intended more as a tender for a convoy of trucks of the same kind. It carries

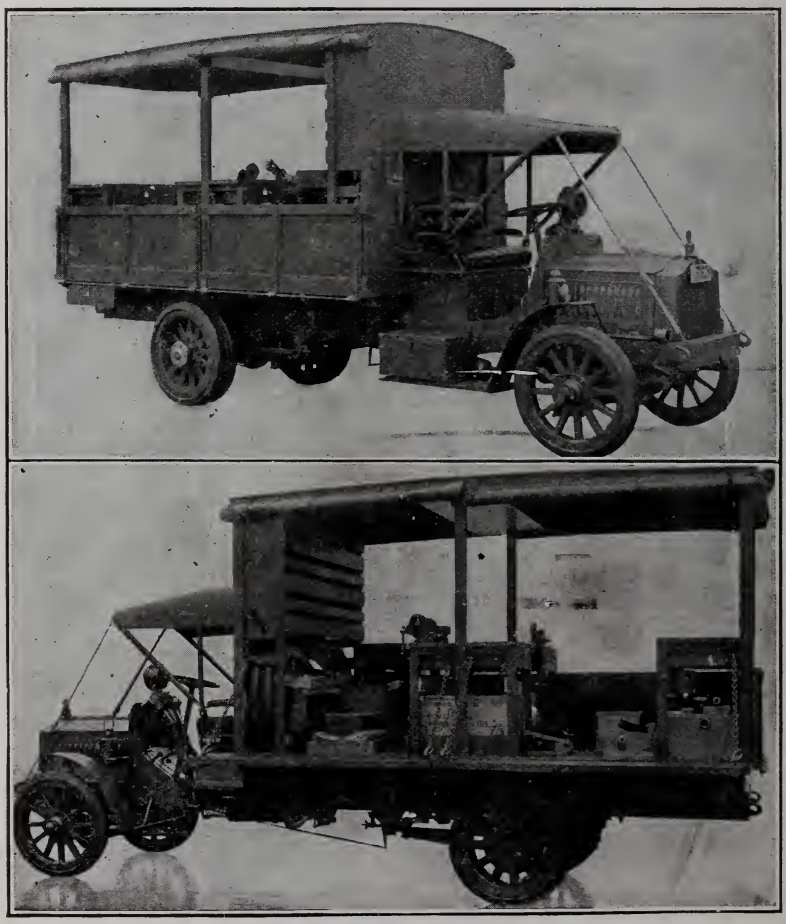


Fig. 77.—Views of the Packard Repair Truck, with Full Equipment of Spare Parts that Acts as a Tender for Packard Truck Trains, Used by the United States Army.

a complete set of spare parts, even to extra wheels and springs. The equipment includes a forge, anvil and necessary smithing tools as well as a complete assortment of machinist's tools. Such items as a

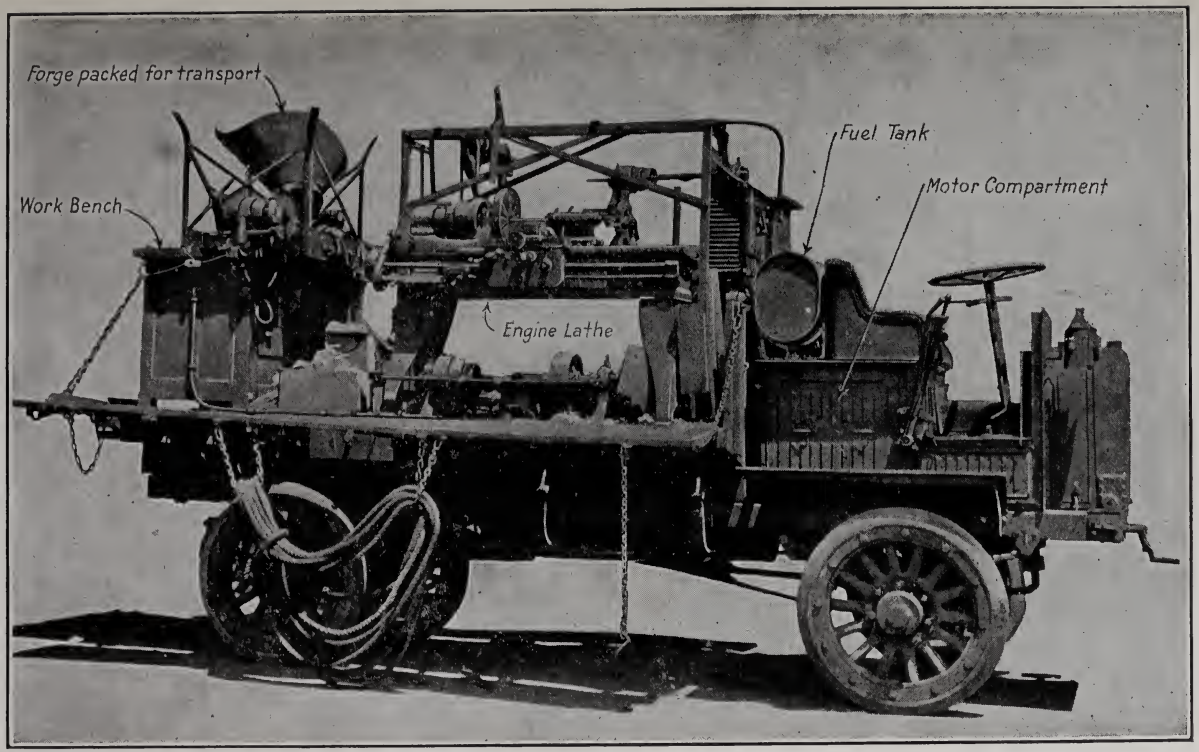


Fig. 78.—Complete Mobile Repair Shop Mounted on Four-Wheel Drive Truck Chassis.

small emery grinder and hand drill are provided. Other forms of repair trucks which have lathes, drill presses and other machine shop tools are also available, but these are generally used at the field base as a mobile repair shop rather than as tenders for convoys. A repair shop truck of this kind is shown at Fig. 78, the machinery being clearly shown.

Another striking application of the automobile to military use is shown at Fig. 79. This depicts a special body type of great utility.

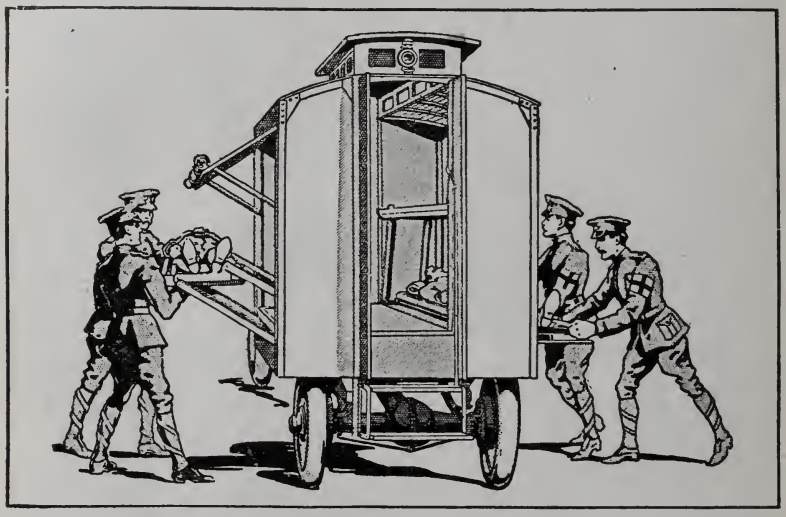


Fig. 79.—Blackmore Convertible Ambulance Type Body.

This convertible ambulance body, with side loading feature, is adaptable to any chassis. The sides of the body swing out on pivots and cause trays that are built in combination with the sides to project beyond the body, and upon them stretchers are placed, after which the trays and stretchers are lifted in a horizontal position inside the ambulance. One stretcher may be placed slightly higher than the floor and another above it on the same side, while opposite them another tray may be utilized as a bench or other stretchers may be loaded, as the first two stretchers. These bodies are suitable for military use, hospitals and police departments.

Ford Truck Conversion Sets.—Another development worthy of mention is the large sale of adapters, special rear axles, auxiliary frames, etc., devised to transform a popular light-weight pleasure car into one-ton capacity truck. These have not been used under varying conditions long enough yet to determine their real value and influence

on the depreciation of the power-producing elements of the original chassis which have not been strengthened proportionately as the load-carrying members have. These devices, which are outlined in Fig. 80, can be divided into five general classes. In the types outlined, that at A retains the Ford rear axle and spring, but the wheel base is increased by the introduction of a section in the frame at either of the two points shown, and the drive shaft is also increased in length to correspond to the increase in wheel base. The type shown at B

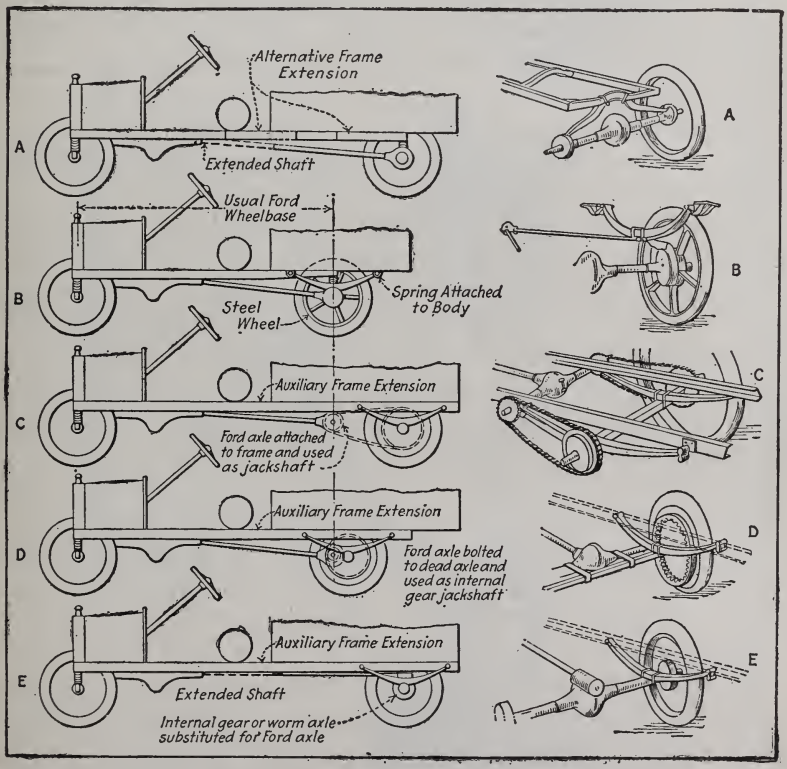


Fig. 80.—Diagrams Showing Classification of the Various Conversion Sets Marketed to Convert Ford Standard Chassis to Truck Service.

provides for additional load capacity by the use of supplementary springs attached directly to the housings of the drive gearing actuating the steel wheel. These wheels are carried on special bearings independent of the Ford rear axle, so this member is used merely to transmit power and is not subjected to the strain of carrying the vehicle load. In class C the rear axle is used for a jackshaft for a chain driven rear-end truck assembly, which is a unit with a supple-

mentary frame extension adapted to be easily attached to the regular chassis. The design shown at D is similar except that the rear axle is changed into a jackshaft for an internal gear-driven unit. Instead of sprockets on the axle shaft ends as at C, spur pinions which mesh with large internal spur gears driving the wheels are employed. In the type shown at E, an auxiliary frame extension is used, but this carries a worm or internal gear drive axle and special wheels and springs. The Ford rear axle is not used at all, nor are the Ford rear wheels. Those types in which the load is carried on special springs and axle members, as at B, C, D and E, are much stronger than that outlined at A. The regular rear end construction was never intended to carry heavy loads.

Combination Gasoline-Electric Car.—An interesting automobile recently announced shows that all automobile engineers are not entirely satisfied with the features of the accepted motor vehicle types. An apparently successful effort to combine the advantages of the electric automobile with those usually associated only with the gasoline propelled type is represented by a radical new design known as the "dual-power" car. In this vehicle, which is illustrated at Fig. 81, the general body lines and ease of control are those commonly attributed to the luxurious electric automobiles, while the speed and increased radius of action of a gasoline car are also incorporated in the design. The power plant is a combination consisting of a 14 horse power, four-cylinder engine mounted at the front of the frame in the usual position and a motor generator placed immediately back of the engine. A magnetic clutch is interposed between them. A 24-cell storage battery is used, carried at the rear of the frame, but owing to the combination with the gasoline engine only one-half of the usual number of cells is provided.

The control levers on the top of the steering column are practically the same as those of the gasoline automobile. The shorter of these is the engine-throttle control, which actuates the magnetic clutch when moved from neutral, connecting the electrical motor generator with the gasoline engine and then regulates engine speed by altering the gas supply. The longer of the levers is the electric controller, which changes the electric motor speed. The usual form of foot actuated brake is provided, but this is not needed in ordinary driving, as the car may be brought to a stop without difficulty through a braking action obtained by utilizing the electric generator function of the motor-dynamo. It will be evident that the machine can be started, operated through its entire range of speed, and stopped with the simple motion of a thumb and forefinger. There are no sliding gears

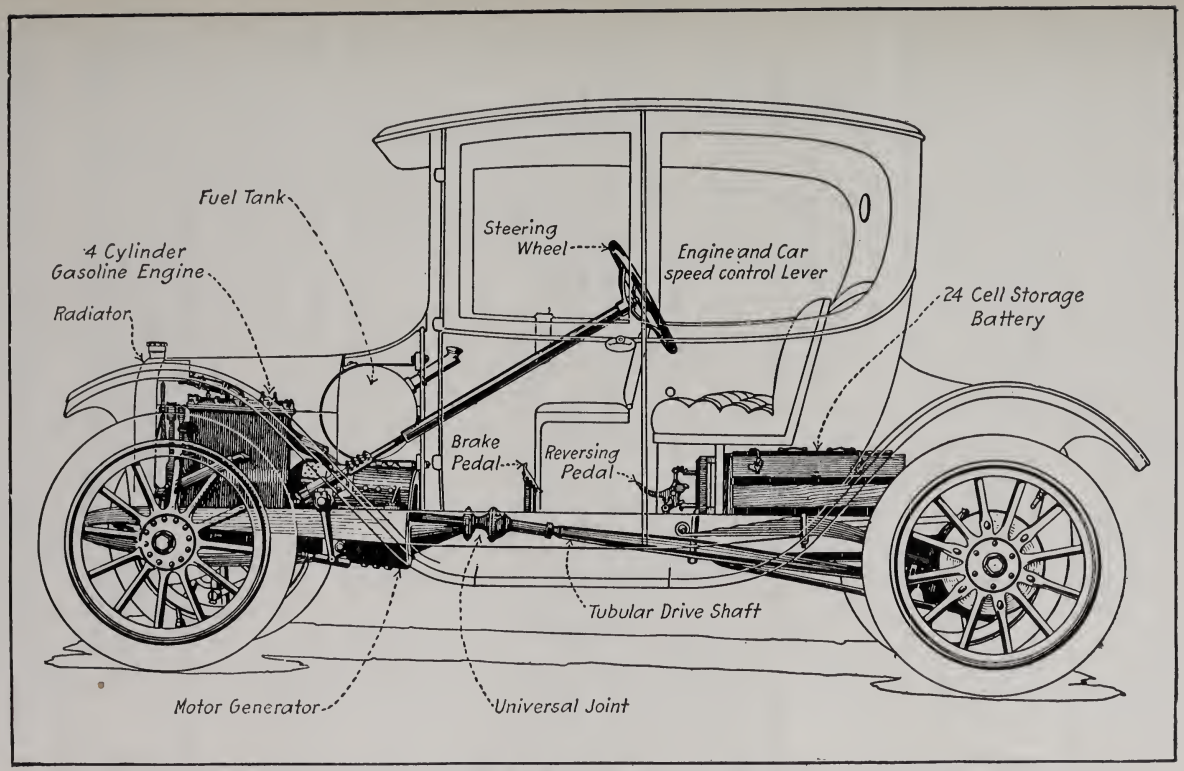


Fig. 81.—The Woods Dual Power Car May Be Driven Either by Electricity or by Gasoline, Independently or in Conjunction.

to shift as in a gas car and consequently no hand lever corresponding to the speed selecting lever of a sliding gear transmission.

The arrangement of the various units is such that the car can be driven entirely by electricity, solely by the gasoline engine or by both simultaneously. The maximum speed of 35 miles per hour is a reasonable speed for a vehicle of this character. A good feature is that when driving with the internal combustion engine as power all of the energy that is produced that is not needed to drive the machine at a certain speed is conserved, because the electric machine automatically becomes a generator and charges the batteries. If for any reason the fuel supply should become depleted, the current available from the battery will propel the car 30 miles over average roads on the full charge. If a steep gradient is encountered, the two forms of motive power may be used, as a boosting action can be obtained by utilizing the electric machine as a motor. There is no danger of stalling the engine, because should the engine cease to function the electric machine would crank it over at several hundred revolutions a minute and of course immediately start it again.

The electric devices are very similar to those formerly used in the single unit starting and lighting systems which were very popular for a time, except that the combined motor-generator is of sufficient power to turn over the engine and propel the car at the same time. Even the very small starting motors used on so many gasoline automobiles at the present time will drive the car a short distance on the charge contained in the ordinary small storage battery of 6 volts, 100 ampere hours' capacity. There is no reason, therefore, why the combination should not work equally well as far as reliability is concerned as the thoroughly tried out one-unit starting and lighting system. The combination of the two sources of power has made it possible to get 45 miles travel from one gallon of gasoline. Considering the size and weight of the car and the maximum speed obtainable, this figure is apt to be given doubtful consideration by the technically informed. As the engine is of low power it is possible to drive the car 30 miles on a gallon of gasoline. When it is explained that in doing this sufficient surplus current is generated to charge the batteries for an additional 15 miles it will be apparent that the figure is not overstated.

A marked feature that will be appreciated is the elimination of the charging methods ordinarily followed in all electric cars where the current is taken from a power or lighting circuit. With this construction the battery charging source is an integral part of the car and very little trouble and expense are entailed by battery

charging and maintenance. The weight of the machine is slightly more than 3,000 pounds, whereas that of the standard electric of the same type would be over 1,000 pounds more. Owing to the small size of the 24-cell storage battery considerable space is available in the rear compartment to carry an extra tire and supplies. Reversing is easily accomplished by means of a heel pedal carried at the front of the driver's seat. The general arrangement of the gasoline power plant is the same as would be followed in a light gasoline car. The drive from the end of the motor generator shaft to the rear axle is through two universal joints and a tubular drive shaft. The arrangement is such that when the car is descending a hill, by using the electric machine as a generator, the speed of the car is reduced and at the same time considerable electricity is being generated which is stored in the battery until needed.

Drawbar Pull of Motor Trucks.—While the advent of the trailer several years ago was frowned upon by engineers of motor truck companies, special tractors have been sold intended to furnish the power for a road train of trailers, and these have worked out so well that they are finding ready sale. Many truck users have disregarded the cautions of the truck maker and have used four-wheel trailers, thus practically doubling the carrying ability of the truck and as experience shows, with no appreciable injury to the truck mechanism unless the combination is unreasonably worked. So much interest now prevails in trailers that some of the truck makers have provided towing hooks and have strengthened their frame construction so trailers may be used without injuring the towing vehicle chassis. Of course, the special road tractors previously described are built especially for this work, and as some are provided with winches driven by the engine, they can pull their loads over poor roads and up grades where the tractor would not have sufficient traction to haul them in the conventional manner.

The amount a truck will pull when used as a tractor or in connection with trailers depends entirely upon the power available and the character of the highway over which it is operated. The Troy Wagon Works Company have made up a special chart, to permit determining the drawbar pull of any truck in order to estimate the load it will draw in the form of loaded trailers. The explanation of the chart which is shown at Fig. 82 is reproduced from the *Commercial Vehicle:* "To get the answer you must know the bore and stroke and number of cylinders of the motor, the gear ratio and the rear wheel diameter. By using the tractive force chart you can obtain directly the tractive force of the truck. This is the total number of

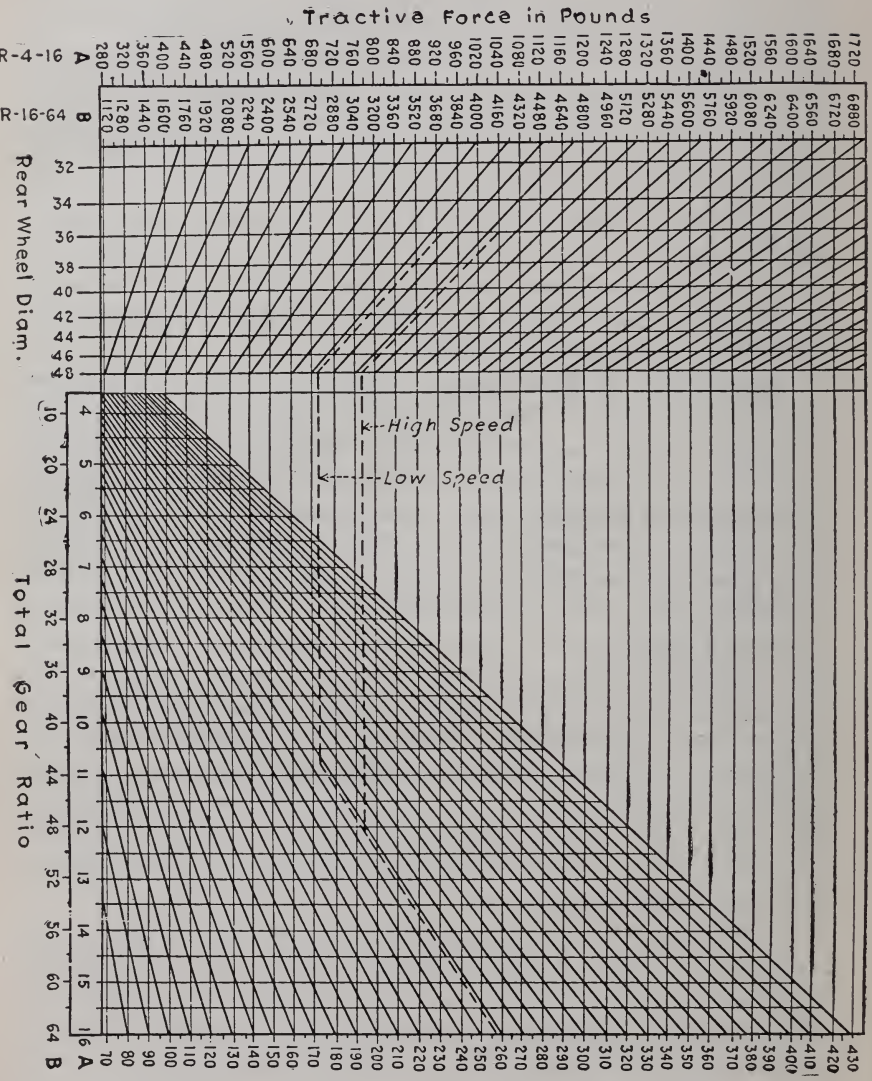


Fig. 82—Chart to Determine Drawbar Pull of Motor Trucks.

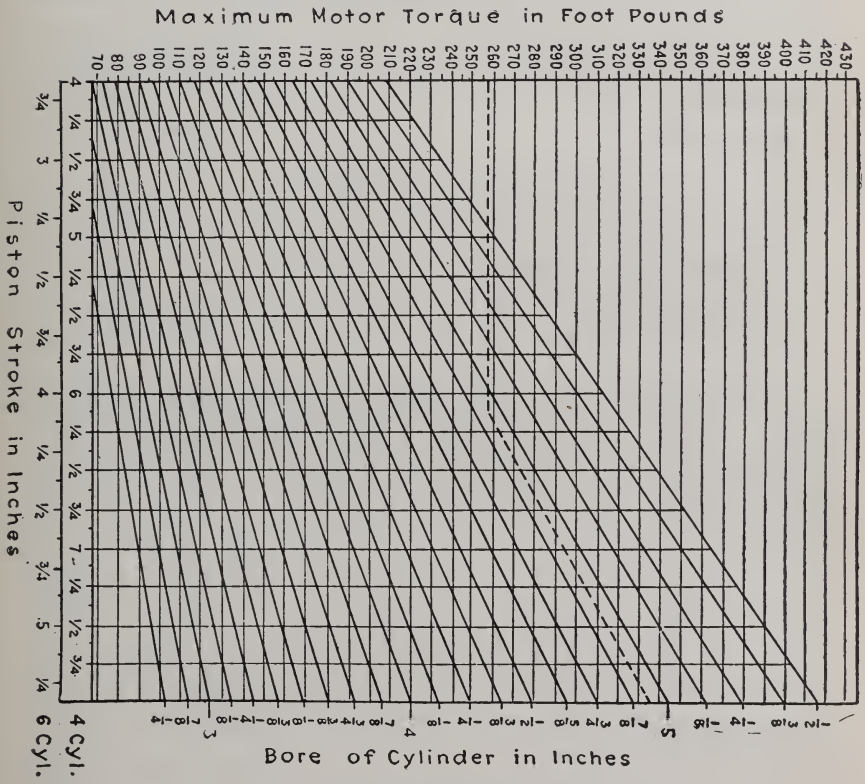


Fig. 82—Continued.

pounds push which the rear wheels of the truck can be expected to exert on the road surface. But how many tons will this force move? Select from the following table the value of road resistance, which applies in the case, then add 20 pounds for each per cent. of grade which the truck must climb, and the total tractive resistance in pounds per ton results.

TABLE OF ROAD RESISTANCE OF RUBBER TIRED TRUCKS AND TRAILERS.

Type of Road	Road Resistance in Lbs. per Ton
Asphalt	20
Smooth brick	25 to 35
Poor brick, ordinary cobbles or macadam	35 to 60
Hard, dry clay road or hard gravel road	50
Soft macadam	75
Ordinary country clay road	100
Ordinary country sand road	150
Sand 3 inches deep	275 to 300

"*Tractive force* is the total number of pounds push available; *tractive resistance* is the number of pounds required to move 1 ton. By division the total number of tons which may be moved under the given circumstances is ascertained. If the weight of the truck plus the weight of a trailer plus the weight of the loads on both comes out less than the number of tons which the calculation shows can be handled, then the use of a trailer is advisable. On good roads, with moderate grades, it will often be found that two, three or more trailers may be used with proportionate advantage. Example: A 5-ton truck has a 4 15/16 by 6⅛-inch four-cylinder motor and 36-inch driving wheels. The total reduction on direct drive is 12 to 1 and on first gear is 43 to 1.

"From the chart it will be seen that the available tractive force for the high or direct drive gear reduction, 12 to 1, is 1,040 pounds, and for the low gear reduction, 43 to 1, is 3,730 pounds. In reading this chart it should be noted that two scales have been provided for the total gear reduction, one marked A and the other B, and that there are also two scales of tractive force marked A and B. When the gear ratio is between 4 and 16 the scale marked A should be used, and when the gear ratio is between 16 and 64 the scale B should be used. The truck, say, for example, is to be operated over a good crushed-stone road, most of which is fairly level, but with one grade of 7 per cent. The road resistance, as we can see from the table, will

be between 35 and 60 pounds per ton, and the total tractive force required on the 7 per cent. grade will be, using the higher value of road resistance, $7 \times 20 + 60 = 200$ pounds per ton. As 3,730 pounds are available on first gear, then $3{,}730 \div 200 = 18.65$ tons, which may be moved without overloading the motor. If the weight of the 5-ton truck is 4½ tons and the weight of a 5-ton trailer 2 tons, then using one trailer behind the truck with capacity loads on both, the weight of the train will come to 16½ tons.

"As this comes out less than the calculated allowance the use of one trailer under these circumstances is advisable.

"On level stretches of the road the tractive force required to tow the train would be

$$16\tfrac{1}{2} \times 60 = 990 \text{ pounds}$$

or 50 pounds less than the available force on direct drive of 1,040 pounds. It must be remembered that the chart values are not based on the performance of a new truck in perfect condition, but on the performance of a truck that has seen a year or so of hard service, but which has been kept in good condition. The chart values include all the margin of safety which is necessary under average conditions. Sometimes it will be found that the motor truck is geared too high to permit the use of trailers even though conditions are such that a considerable economy could be effected by their use. In such cases a lower ratio should be installed in the truck. As a general thing, where the truck manufacturers offer optional ratios, lower than their standard ratios, then these lower ratios should be specified when ordering a new truck with which trailers are to be used, so that a greater tonnage may be handled on the trailers. This applies, of course, only in cases where total tonnage per day, rather than speed of delivery, is the chief object."

How to Use Chart.—This tractive force chart for motor trucks is based on the formula:

$$T = 0.55 \times D; F = \frac{T \times R \times 12}{W},$$

when R is the total gear ratio, F is the tractive force in pounds, W is the driving wheel diameter in inches, T is the foot pounds of torque and D is the cubic inches of piston displacement.

This chart gives the working value of the tractive force which may be expected from a truck used in hard commercial service. A new truck should develop a maximum tractive force 50 per cent. greater than the value given in the chart. This chart is intended

for chain, bevel, double-reduction, or internal-gear-driven trucks, but not for worm drives.

Example—The dash line traces the solution of the following problem: To find the tractive force of a truck having a 4 15/16-inch bore, a 6⅛-inch stroke and four cylinders; a 12 to 1 total gear-ratio in high and a 43 to 1 total reduction in low:

Solution—Starting with 4 15/16 on the vertical scale to the right of the chart, the line traces diagonally to the left, parallel with the nearest diagonal line to the intersection with the vertical line calibrated for 6⅛ on the horizontal scale nearest the right. From this the line follows parallel with the nearest horizontal line to the left reading 257 feet-pounds of torque on the vertical scale. Starting with the same 257 on the torque scale opposite, the line traces diagonally to the left, parallel with the diagonal, to the vertical line calibrated on the high-gear scale for 12, representing a reduction of 12 to 1. From here the nearest horizontal is followed to the left until it strikes the third section of the chart, where it continues diagonally to the left, parallel with the nearest diagonal line, to its intersection with the vertical line calibrated 36, for 36-inch rear wheels. From thence it follows the nearest horizontal line to the vertical scale at the extreme left. The answer is read on the A scale, to correspond with the gear-ratio scale used for high gear. The low-gear tractive force is found on the B scale in both instances.

Answer—The answer is read directly: 1,040 pounds for high gear and 3,730 pounds for low gear.

Grade Determination.—A writer in the *Automobile* explains the various methods of grade determination so clearly that any motorist, even if not familiar with geometry, can follow the discussion which refers to the diagram shown in Fig. 83. The matter of grade determination is an important one and many loose and incorrect statements are made that are based on incorrect information. The line A — F is approximately the steepest grade that an automobile is expected to ascend. Very few can do better and many will not reach it. An engineer would describe it as 60 in 100. It is also properly to be described as a 50 per cent. grade, because the perpendicular drop from the point K is exactly half the length of the line A — K, and it can also properly be described as a grade which makes with the horizontal an angle of 30 deg. of arc. The 45 deg. line from A to I is drawn as a matter of interest, because, from an engineer's standpoint, the horizontal distance and the rise being equal, it is properly described as 1 in 1 or 100 in 100 and it is very improperly described as a 100 per cent. grade, which it is not. It is, in fact, approximately

a 71 per cent. grade. It should be here said that the degrees are only approximately correct, and this is true also of all the figures relating to the grades of 5, 10 and 15 per cent., the errors being too slight to be noted. The absurdity of calling the 45 deg. grade a 100 per cent. grade is brought out by considering that it is perfectly possible to have steeper grades, as for example railroad embankments, so that one would proceed to 150 and 200 per cent. grades, and at the

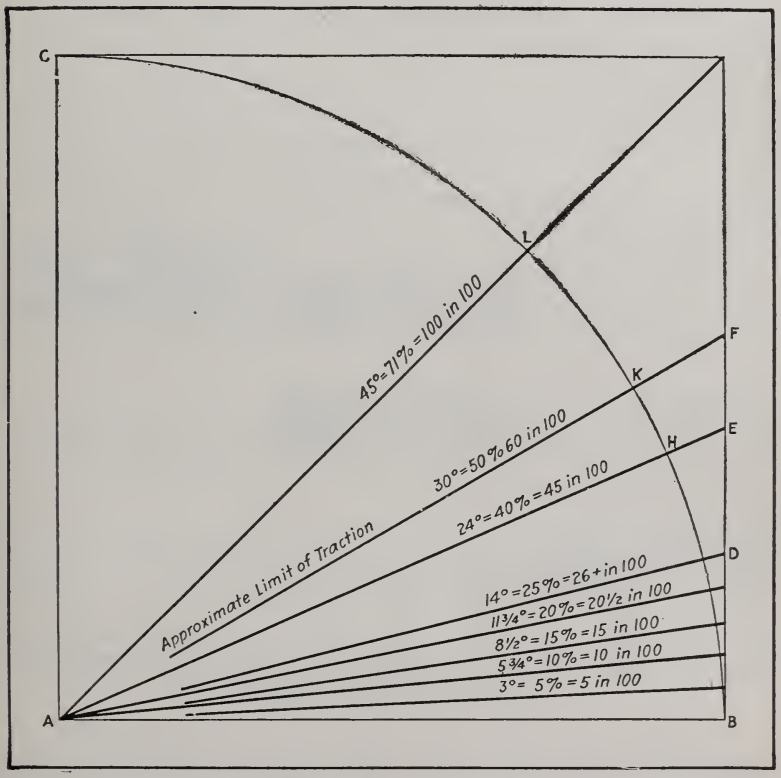


Fig. 83.—Diagram Showing Three Methods of Describing Grades so the Relation Between Angles, Percent and Rise Per Hundred Feet Can Be Readily Understood.

point where the slope merges into the perpendicular, under this system of nomenclature, the grade becomes infinite.

On the other hand, there are very strong reasons for applying the per cent. term to the grades that are designated by measuring along the slope and comparing that with the perpendicular. The horizontal is, of course, a zero grade. As the perpendicular is ap-

proached, the grade per cent. increases to 90 per cent. and above, but at the point where the perpendicular is reached, the grade is 100 per cent. In other words, it is all grade and no horizontal advance. There is also the additional reason for using the per cent. term, that where the weight of a vehicle is expressed in tons of 2,000 pounds, each rise of 1 per cent. of grade requires an addition of 20 pounds of engine torque per ton to overcome it. That is to say, if a car is proceeding on the level and comes to a 10 per cent. grade, its reserve torque must be at least 200 pounds per ton to carry it up the grade. If the grade increases to 15 per cent. an additional 100 pounds is needed, and so on.

Fortunately for the average owner the practical difference between 15 per cent. and 15 in a hundred and any lesser grade is too slight

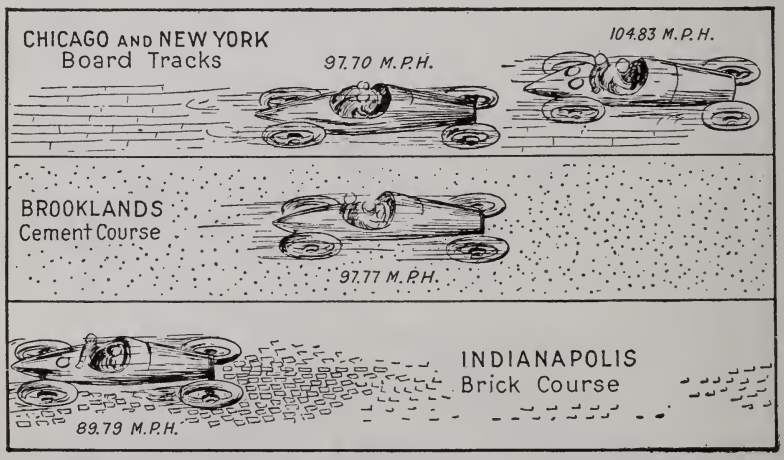


Fig. 84.—Illustrations Showing Speed Records and the Character of the Course Over which They Were Made.

to take into account, and on the main highways a grade exceeding 15 per cent. is scarcely ever met with. It is said that the grade up Pike's Peak does not exceed 10 per cent. at any point. Occasionally on back roads 20 per cent. or 25 per cent. grades may be encountered, but in those cases it is frequently the bad character of the road bed that troubles the driver quite as much as the steepness, or degree of incline, of the road. The average automobile, if in good condition, should be able to surmount a 7 or 8 per cent. grade on high gear. The effect of reduction to low gear and the enormous increase in reserve torque applicable to the surmounting of hills are illustrated when one multiples 40 or 50 per cent. of grade by the 20 pounds for

each per cent. of rise and finds that for the weight of his car in tons the engine must furnish on account of grade alone 800 to 1,000 pounds respectively of energy, a very considerable expenditure.

Comparison of Design Practice.—The trend of average American pleasure car practice during eight years past will be of considerable interest to the student of automobile construction and an interesting story of the progress made in design from the early experimental period of 1910 and 1911, when there were almost as many different designs as there were makers of cars, to the present time, when the main features may be considered standardized, may be obtained from the following tabulation, which is reproduced from the *Automobile*. This is one of the best of the American motoring prints, and the information given is authoritative, because based on a summation of figures compiled by that publication for some time past. It will be noted that many of the devices and parts described in this book are presented merely because of their historical value and not because they are a feature of modern cars. It is considered desirable to outline some of these, however, to keep the embryo automobile engineer from reinventing devices which have been discarded in time past.

General Averages	1917	1916	1915	1914	1913	1912	1911	1910
Horsepower, S. A. E. rating.	24.3	28.66	29.97	33.2	33.60	33.60	32.7	31.5
Bore	3.37	3.57	3.82	4.12	4.19	4.34	4.42	4.85
Stroke	4.66	4.97	5.10	5.28	5.15	4.97	4.46	4.68
Stroke bore ratio	1.38	1.39	1.33	1.28	1.23	1.09	1.01	1.03
Piston displacement	222.5	278.87	307.38	349	345	316.2	313.2	281.5
Wheelbase	113.25	119.56	122.19	121	122	121	114	112
Gear ratio	4.15–1	4.08–1	3.88–1	3.6–1	3.57–1	3.62–1	.....	.....
Tires	31x4	23x4½	34x4	35x4½	35x4½	35x4	34x4	34x4
Number cars	.....	519	535	607	.....	.....	.....	.....
Number chassis	188	176	200	236	339	381	393	364
Number makes	131	108	119	133	156	193	270	239
Price	$1687	$1600	$2005	$2635	$2585	$2508	$2560	$2214
PERCENTAGE								
Number of Cylinders								
One cylinder	0	0	0	0	0	1	1	5
Two cylinders	0	0	.5	1	1	1	2	3
Four cylinders	37	39.2	51.0	54	62	78	80	82
Five cylinders	0	0	0	0	1	1	0	0
Six cylinders	47	45.8	47.5	45	36	19	17	10
Eight cylinders	12	12.6	1.0	0	0	0	0	0
Twelve cylinders	4	2.4	0	0	0	0	0	0
Shape of Cylinders								
I cylinder type	20	13.7	16.5	30	31	30	22	20
L cylinder type (V motors)	73	73.3	70.0	59	56	55	60	56
T cylinder type	5	13.0	8.5	6	9	9	14	18
Knight type	2	3.6	3.0	3	3	2	1	0
Two cycle	0	0	1.0	1	1	4	3	6
Mondex Magic type	0	0	0	1	0	0	0	0

PERCENTAGE	1917	1916	1915	1914	1913	1912	1911	1910
Cylinder Arrangement								
Cylinders cast separate	.....	4.8	4.0	6	15	22	28	39
Cylinders cast in pairs	.....	10.2	27.0	42	48	58	60	53
Cylinders cast in block	.....	78.4	67.5	39	29	18	12	8
Cylinders cast in threes	.....	6.6	10.5	13	8	2	0	0
Cooling								
Air cooled	1	.6	.5	2	4	5	6	7
Thermo syphon	38	38.2	27	19	17	19	28	23
Pump circulating	61	61.2	72.5	79	79	76	66	70
Ignition Systems								
Single ignition	84	76.0	56	23	15	14	18	25
Dual ignition	9	19.2	36	59	68	63	53	40
Two spark ignition	1	1.2	1.45	4	2	0	0	0
Double ignition	3	1.8	4.55	11	15	23	29	35
Duplex ignition	3	1.8	2.0	3	0	0	0	0
Engine Lubrication								
Splash oiling	35	52.7	46.5	42	53	68	81	0
Splash pressure oiling	35	23.35	16	39	32	20	0	0
Oil in fuel	0	0	0	1	1	2	3	6
Pressure oiling	30	23.35	37.5	18	14	10	19	0
Splash gravity	0	.6	0	0	0	0	0	0
Engine Starting								
Electric starter	99	98.8	94.5	87	37	2	0	0
Acetylene starter	0	0	0	1	14	0	0	0
Air starter	0	0	0	4	9	2	1	1
Optional starter	0	0	1.5	2	5	0	0	0
Mechanical starter	0	0	.5	1	4	0	0	0
No starter as stock	1	1.2	3.5	5	31	98	99	99
Fuel Feed								
Gravity fuel feed	18	31.8	57	58	65	75	81	82
Gravity pressure fuel feed	1	2.4	.5	1	0	0	0	0
Pressure fuel feed	7	12.0	22	41	35	25	19	18
Vacuum feed	74	53.8	20.5	0	0	0	0	0
Gas Tank Location								
In cowl	.....	No 1916	7.2	13	.....	.....	.....	.....
At rear	.....	figures	51.1	41	.....	.....	.....	.....
Under seat	.....	avail.	21.2	46	.....	.....	.....	.....
Type of Clutch								
Disk clutch	68	53.4	51	48	52	44	51	49
Cone clutch	30	45.6	44	41	45	52	47	39
Expanding band clutch	0	0	.5	3	1	3	2	6
Contracting band clutch	0	0	4.5	5	2	1	1	3
None	1	0	.....	3	.....	.....	.....	.....
Electric	1	1.0	.....	.....	.....	.....	.....	.....
Type of Gearset								
Selective	98	96.5	91.5	95	94	92	90	85
Progressive	0	1.7	3.5	1	2	5	1	8
Planetary	0.5	.6	1.0	1	1	2	4	4
Friction	1.5	1.2	2.5	3	3	1	5	3
Location of Gearset								
Amidship	14	20.6	32.5	39	46	55	67	75
Unit with axle	9	15.3	18.2	15	20	20	17	15
Unit with motor	77	63.5	49.3	43	34	25	16	10
None	.....	0	.....	3	.....	.....	.....	.....
Steering and Control								
Right steer. right control	.....	6.8	9.5	24	58	70	81	93
Right steer. center control	.....	2.2	3	10	13	15	11	4
Left steer. center control	.....	87.1	79.5	57	25	13	6	2
Left steer. left control	.....	1.1	3.5	2	4	2	2	1

PERCENTAGE	1917	1916	1915	1914	1913	1912	1911	1010
Steering and Control								
Optional steering	.....	2.8	4.0	4	0	0	0	0
Elec. gearshift (left steer.)	.....	0	0	3	0	0	0	0
Final Drive								
Shaft and bevel	28	41.0	84.5	93	94	92	91	89
Chain	1.5	1.7	4.5	4	4	6	8	11
Shaft and worm	0.5	.5	1.5	1	1	1	0	0
Roller	0	0	0	1	1	1	1	0
Shaft and spiral bevel	70	56.8	9.5	1	.....	.....	.....	.....
Type of Axle								
Floating	43.5	51.8	56.5	65	67	50	0	0
Semi-floating	25.5	23.6	23.0	17	26	49	0	0
Three-quarter floating	29.5	22.8	18.5	14	4	0	0	0
Seven-eighths floating	0	0	0	1	0	0	0	0
Dead rear axle	1.5	.6	2.0	3	3	1	0	0
Timing Gear Drive								
Spur gear	4	8.4	16.1	13	83	.....	.....	.....
Helical or spiral gear	74	73.0	73.7	77	10	.....	.....	.....
Silent chain	21	18.1	9.1	10	7	.....	.....	.....
Worm	1	.5	1.1	0	0	0	0	0

COMPETITIVE RECORDS—1909 TO DATE

Courtesy of Motor Age, Chicago

and American Automobile Association

DIVISION ONE
SPEEDWAY RECORDS, CLASS "B" STOCK CAR
SPEEDWAY RECORDS, CLASS "B" STOCK CHASSIS
(Piston Displacement)

161 TO 230 CUBIC INCHES

Distance Miles	Time	Driver	Car	Place	Date
4	3:49.00	Witt	E. M. F.	Atlanta	Nov. 3, 1910
5	4:35.47	L. Chevrolet	Buick	Indianapolis	July 2, 1910
10	8:55.40	L. Chevrolet	Buick	Indianapolis	July 2, 1910
20	19:51.00	Knipper	Chalmers	Atlanta	Nov. 12, 1909
50	50:36.00	Nelson	Buick	Atlanta	Nov. 9, 1909
100	1:40:46.81	Knipper	Chalmers	Atlanta	Nov. 10, 1909

231 TO 300 CUBIC INCHES

5	4:16.00	Dawson	Marmon	Indianapolis	July 2, 1910
10	8:16.08	Harroun	Marmon	Indianapolis	May 27, 1910
20	17:10.70	Chevrolet	Buick	Atlanta	Nov. 11, 1909
25	21:48.92	Harroun	Marmon	Indianapolis	May 30, 1910
50	42:41.33	Harroun	Marmon	Indianapolis	May 30, 1910
75	67:31.07	Harroun	Marmon	Atlanta	Nov. 11, 1909
100	1:30:08.31	Harroun	Marmon	Atlanta	Nov. 11, 1909

301 TO 450 CUBIC INCHES

5	4:05.76	Kincaid	National	Indianapolis	May 27, 1910
10	7:55.12	Aitken	National	Indianapolis	July 2, 1910
15	11:48.78	Aitken	National	Indianapolis	July 1, 1910
20	15:57.63	Dawson	Marmon	Indianapolis	May 27, 1910
50	39:47.35	Dawson	Marmon	Atlanta	Nov. 3, 1910
75	1:00:16.34	Dawson	Marmon	Indianapolis	May 27, 1910
100	1:23:43.11	Kincaid	National	Indianapolis	May 27, 1910
150	2:05:02.17	Chevrolet	Buick	Atlanta	Nov. 9, 1909
200	2:46:48.47	Chevrolet	Buick	Atlanta	Nov. 9, 1909
250	4:38:57.40	Burman	Buick	Indianapolis	Aug. 19, 1909

451 TO 600 CUBIC INCHES

5	4:01.36	Oldfield	Knox	Indianapolis	May 30, 1910
10	7:47.71	Robertson	Fiat	Atlanta	Nov. 11, 1909
20	15:57.41	De Palma	Fiat	Atlanta	May 5, 1910
50	42:02.98	Robertson	Fiat	Atlanta	Nov. 13, 1909
100	1:22:35.35	Robertson	Fiat	Atlanta	Nov. 13, 1909
150	2:05:00.63	Robertson	Fiat	Atlanta	Nov. 13, 1909
200	2:53:48.32	Disbrow	Rainier	Atlanta	Nov. 13, 1909

SPEEDWAY RECORDS, CLASS "C" NON-STOCK
(Piston Displacement)

161 TO 230 CUBIC INCHES

Distance Miles	Time	Driver	Car	Place	Date
5	4:20.20	J. Nikrent	Buick	Los Angeles	April 15, 1910
10	8:40.17	J. Nikrent	Buick	Los Angeles	April 15, 1910
15	13:14.52	J. Nikrent	Buick	Los Angeles	April 9, 1910
20	17:37.36	J. Nikrent	Buick	Los Angeles	April 9, 1910
25	21:12.42	Tower	Flanders	Los Angeles	May 5, 1912
50	43:49.69	Endicott	Cole	Los Angeles	April 9, 1910

231 TO 300 CUBIC INCHES

1	0:45.60	De Palma	Mercer	Los Angeles	May 5, 1912
2	1:31.53	De Palma	Mercer	Los Angeles	May 5, 1912
3	2:17.17	De Palma	Mercer	Los Angeles	May 5, 1912
4	3:02.70	De Palma	Mercer	Los Angeles	May 5, 1912
5	3:47.34	De Palma	Mercer	Los Angeles	May 5, 1912
10	7:27.33	De Palma	Mercer	Los Angeles	May 5, 1912
15	11:11.17	De Palma	Mercer	Los Angeles	May 5, 1912
20	14:56.05	De Palma	Mercer	Los Angeles	May 5, 1912
25	18:53.20	J. Nikrent	Case	Los Angeles	May 5, 1912
50	42:30.08	Siefert	Dorris	Los Angeles	April 8, 1910
75	1:03:54.28	Harroun	Marmon	Los Angeles	April 8, 1910
100	1:25:22.07	Harroun	Marmon	Los Angeles	April 8, 1910

301 TO 450 CUBIC INCHES

5	3:49.36	J. Nikrent	Buick	Los Angeles	April 17, 1910
10	7:36.61	J. Nikrent	Buick	Los Angeles	April 17, 1910
15	12:04.99	Dawson	Marmon	Los Angeles	April 15, 1910
20	16:04.40	Harroun	Marmon	Los Angeles	April 15, 1910
25	20:08.69	Harroun	Marmon	Los Angeles	April 15, 1910
50	39:53.55	Harroun	Marmon	Los Angeles	April 15, 1910

451 TO 600 CUBIC INCHES

5	3:38.61	Oldfield	Knox	Los Angeles	April 16, 1910
10	7:20.66	Oldfield	Knox	Los Angeles	April 16, 1910
15	11:32.34	Marquis	Isotta	Los Angeles	April 10, 1910
20	15:29.18	Marquis	Isotta	Los Angeles	April 10, 1910
25	19:24.92	Marquis	Isotta	Los Angeles	April 10, 1910
50	39:20.69	Marquis	Isotta	Los Angeles	April 10, 1910

DIVISION TWO
NON-COMPETITIVE RECORDS

SPEEDWAY RECORDS, CLASS "B" STOCK CAR
(Piston Displacement)

231 TO 300 CUBIC INCHES

10	7:54.40	Mulford	Hudson	Sheepshead Bay	Nov. 25, 1915
20	15:45.80	Mulford	Hudson	Sheepshead Bay	Nov. 25, 1915
50	39:30.80	Mulford	Hudson	Sheepshead Bay	Nov. 25, 1915
100	1:20:21.40	Mulford	Hudson	Sheepshead Bay	Nov. 29, 1915

SPEEDWAY RECORDS, CLASS "B" STOCK CHASSIS
(Piston Displacement)

160 CUBIC INCHES AND UNDER

1	0:56.80	Witt	Flanders	Indianapolis	Nov. 13, 1911
5	4:22.98	Witt	Flanders	Indianapolis	Nov. 13, 1911
10	9:27.49	Witt	Flanders	Indianapolis	Nov. 13, 1911
15	14:13.26	Witt	Flanders	Indianapolis	Nov. 13, 1911
20	19:00.87	Witt	Flanders	Indianapolis	Nov. 13, 1911

SPEEDWAY RECORDS, CLASS "C" NON-STOCK
(Piston Displacement)

160 CUBIC INCHES AND UNDER

5	4:26.08	Evans	Flanders	Indianapolis	Nov. 13, 1911
10	8:53.97	Evans	Flanders	Indianapolis	Nov. 13, 1911
15	13:24.00	Evans	Flanders	Indianapolis	Nov. 13, 1911
20	17:54.82	Evans	Flanders	Indianapolis	Nov. 13, 1911

SPEEDWAY RECORDS, REGARDLESS OF CLASS, STOCK
SPEEDWAY RECORDS, REGARDLESS OF CLASS, NON-STOCK

¼	8.16	Burman	Blitzen-Benz	Indianapolis	May 29, 1911
½	16.60	Oldfield	Christie	Tacoma	July 5, 1915
1	21.40	Burman	Blitzen-Benz	Indianapolis	May 29, 1911
1	31.60	Oldfield	Christie	Tacoma	July 5, 1915
2	1:10.00	Oldfield	Christie	Tacoma	July 5, 1915
3	1:54.83	Bragg	Fiat	Los Angeles	May 5, 1912
4	2:33.37	Bragg	Fiat	Los Angeles	May 5, 1912
5	3:00.00	Orr	Maxwell	Omaha	July 5, 1915

ONE MILE CIRCULAR DIRT TRACK RECORDS, STOCK
ONE MILE CIRCULAR DIRT TRACK RECORDS, NON-STOCK

Distance Miles	Time	Driver	Car	Place	Date
1	46.20	Disbrow	Simplex	St. Louis, Mo.	Aug. 8, 1914
2	1:32.60	Disbrow	Simplex	St. Louis, Mo.	Aug. 8, 1914
3	2:27.81	Disbrow	Simplex	Cleveland, O.	Sept. 14, 1912
4	3:17.02	Disbrow	Simplex	Cleveland, O.	Sept. 14, 1912
5	4:06.58	Disbrow	Simplex	Cleveland, O.	Sept. 14, 1912

STRAIGHTAWAY RECORDS, CLASS "B" STOCK CHASSIS
(Piston Displacement)

231 TO 300 CUBIC INCHES

1	35.11	Mulford	Hudson	Daytona	April 10, 1916

301 TO 450 CUBIC INCHES

1	26.75	Merz	National	Jacksonville	Mar. 29, 1911
1	40.32	Wilcox	National	Jacksonville	Mar. 30, 1911

STRAIGHTAWAY RECORDS, REGARDLESS OF CLASS, STOCK
STRAIGHTAWAY RECORDS, REGARDLESS OF CLASS, NON-STOCK

1	15.88	Burman	Blitzen-Benz	Daytona	April 23, 1911
1	25.40	Burman	Blitzen-Benz	Daytona	April 23, 1911
2	51.28	Burman	Blitzen-Benz	Daytona	April 23, 1911
5	2:34.00	Hemery	Darracq	Daytona	Jan. 24, 1906
15	10:00.00	Lancia	Fiat	Daytona	Jan. 29, 1906

(Standing Start)

1	40.53	Oldfield	Benz	Daytona	March 16, 1910

HOUR RECORDS
SPEEDWAY, CLASS "B" STOCK CHASSIS
(Piston Displacement)

231 TO 300 CUBIC INCHES

12	924	Mulford	Hudson	Sheepshead Bay	May 1-2, 1916
24	1,819	Mulford	Hudson	Sheepshead Bay	May 1-2, 1916

SPEEDWAY RECORDS REGARDLESS OF CLASS, STOCK
SPEEDWAY RECORDS REGARDLESS OF CLASS, NON-STOCK

1	:40.23	De Palma	Mercedes	Des Moines, Ia.	June 24, 1916
2	1:12.85	Resta	Peugeot	Sheepshead Bay, N. Y.	Sept. 30, 1916
3	1:54.81	De Palma	Mercedes	Des Moines, Ia.	June 24, 1916
4	2:20.08	Resta	Peugeot	Sheepshead Bay, N. Y.	Oct. 9, 1915
5	2:56.35	Resta	Peugeot	Omaha, Neb.	July 15, 1916
10	5:45.03	Aitken	Peugeot	Sheepshead Bay, N. Y.	Sept. 30, 1916
15	8:54.72	Mulford	Peugeot	Omaha, Neb.	July 15, 1916
20	11:15.79	Aitken	Peugeot	Sheepshead Bay, N. Y.	May 13, 1916
25	15:00.38	Mulford	Peugeot	Omaha, Neb.	July 15, 1916
50	28:04.63	Resta	Peugeot	Sheepshead Bay, N. Y.	Oct. 9, 1915
75	45:05.31	Rickenbacher	Maxwell	Omaha, Neb.	July 15, 1916
100	56:57.72	Resta	Peugeot	Sheepshead Bay, N. Y.	Nov. 2, 1915
150	1:26:58.65	Aitken	Peugeot	Sheepshead Bay, N. Y.	Sept. 30, 1916
200	1:55:23.53	Aitken	Peugeot	Sheepshead Bay, N. Y.	Sept. 30, 1916
250	2:23:04.03	Aitken	Peugeot	Sheepshead Bay, N. Y.	Sept. 30, 1916
300	2:55:32.23	Anderson	Stutz	Sheepshead Bay, N. Y.	Oct. 9, 1915
350	3:24:42.99	Anderson	Stutz	Sheepshead Bay, N. Y.	Oct. 9, 1915
400	4:04:48.98	Resta	Peugeot	Chicago	June 26, 1915
450	4:35:05.78	Resta	Peugeot	Chicago	June 26, 1915
500	5:07:26.00	Resta	Peugeot	Chicago	June 26, 1915

ONE MILE CIRCULAR DIRT TRACK RECORDS, STOCK
ONE MILE CIRCULAR DIRT TRACK RECORDS, NON-STOCK

10	8:16.40	Burman	Peugeot	Bakersfield, Cal.	Jan. 3, 1915
15	12:23.20	Burman	Peugeot	Bakersfield, Cal.	Jan. 3, 1915
20	16:25.60	Burman	Peugeot	Bakersfield, Cal.	Jan. 3, 1915
25	20:28.80	Burman	Peugeot	Bakersfield, Cal.	Jan. 3, 1915
50	40:57.80	Burman	Peugeot	Bakersfield, Cal.	Jan. 3, 1915
75	1:08:56.00	Burman	Peugeot	Galesburg, Ill.	Oct. 22, 1914
100	1:31:30.00	Alley	Duesenberg	Hamline, Minn.	Oct. 24, 1914
150	2:30:51.00	Wishart	Mercer	Columbus, O.	Aug. 25, 1912
200	3:21:48.00	Mulford	Mason Special	Columbus, O.	July 4, 1913

STRAIGHTAWAY RECORDS, CLASS "B" STOCK CHASSIS
(Piston Displacement)

161 TO 230 CUBIC INCHES

5	4:24.13	Towers	Warren-Detroit	Jacksonville	Mar. 29, 1911
10	9:10.52	Towers	Warren-Detroit	Jacksonville	Mar. 30, 1911

231 TO 300 CUBIC INCHES

10	8:16.35	Wilson	Cole	Jacksonville	Mar. 29, 1911

301 TO 450 CUBIC INCHES

5	3:56.82	Wilcox	National	Jacksonville	Mar. 30, 1911
10	8:03.67	Merz	National	Jacksonville	Mar. 29, 1911

STRAIGHTAWAY RECORDS, CLASS "C" NON-STOCK
(Piston Displacement)
STRAIGHTAWAY RECORDS, REGARDLESS OF CLASS, STOCK
STRAIGHTAWAY RECORDS, REGARDLESS OF CLASS, NON-STOCK

Distance Miles	Time	Driver	Car	Place	Date
10	5:14.40	Bruce-Brown	Benz	Daytona	Mar. 24, 1909
20	13:11.92	Burman	Buick Bug	Jacksonville	Mar. 30, 1911
50	35:52.31	Burman	Buick Bug	Jacksonville	Mar. 28, 1911
100	1:12:45.20	Bernin	Renault	Daytona	Mar. 6, 1908
150	1:55:18.00	Disbrow	Special	Jacksonville	Mar. 31, 1911
200	2:34:12.00	Disbrow	Special	Jacksonville	Mar. 31, 1911
250	3:14:55.00	Disbrow	Special	Jacksonville	Mar. 31, 1911
300	3:53:33.50	Disbrow	Special	Jacksonville	Mar. 31, 1916

HOUR RECORDS
SPEEDWAY, REGARDLESS OF CLASS, NON-STOCK

Hrs.	Miles	Driver	Car	Place	Date
1	74	Harroun	Marmon	Los Angeles	April 16, 1910
2	148	Harroun	Marmon	Los Angeles	April 16, 1910
24	1,491	Verbeck & Hirsh	Fiat	Los Angeles	April 8, 1910

ONE MILE CIRCULAR DIRT TRACK, REGARDLESS OF CLASS, STOCK CHASSIS

24	1,196	Patsche & Mulford	Lozier	Brighton Beach	Oct. 15, 1909

ONE MILE CIRCULAR DIRT TRACK, REGARDLESS OF CLASS, NON-STOCK

24	1,253	Poole & Patschke	Stearns	Brighton Beach	Aug. 19, 1910

STRAIGHTAWAY, REGARDLESS OF CLASS, NON-STOCK

1	81.65	Disbrow	Special	Jacksonville	Mar. 28, 1911

CHAPTER II

MODERN ENGINE TYPES AND THEIR OPERATING PRINCIPLES

Forms of Power Plants Commonly Used—How Power is Generated—How Gasoline Engine Works—Comparing Cannon and Gas Engine—Four-Cycle Engine Action—Internal Combustion Motor Parts and Functions—Low Speed Single Cylinder Auto Engine—High Speed Single Cylinder Engine—Sequence of Cycles in One- and Two-Cylinder Engines—Sequence of Cycles in Multiple Cylinder Engines—Actual Duration of Different Strokes—Typical Engine Types Described—Two-Cylinder Opposed Motor—Four-Cylinder Engines—Features of Knight Slide Valve Motor—How Knight Motor Works—Sleeve Valve Action—Eight-Cylinder V Engine—Torque of Various Engine Types—Eight-Cylinder Advantages—Twelve-Cylinder Engines—Operating Principles of Two-Cycle Engines—Two-Port Two-Cycle Engine Action—Three-Port Two-Cycle Engines—Differential Piston Two-Cycle Engines—Why Two-Cycle Engine is Not Used in Modern Automobiles—Amplex Two-Cycle Engine—Legros Two-Cycle Engine—Cote Two-Cycle Engine—Rayner Two-Cycle Engine—Power Plant Installation—Three- and Four-Point Support—Unit Power Plants—Motor Location—1917 Automobile Engine Practice—Typical Modern Engines—Power Plant Equipment of Various Cars—Horsepower Table—Cyclecar Engines—Diesel Engines for Automobile Work—Constant Pressure Cycle Possibilities.

It has been previously stated that the gasoline automobile may be divided into groups and that these various assemblies all have their important work to do and that each depend, to some extent, upon the correct action of the others to insure a smooth working motor car. The most important, and the least understood, element is the power plant, and it is important that the prospective motorist familiarize himself with the principles of gasoline engine operation in order to easily locate troubles and derangements which interfere with correct action. If the operator is familiar with the basic principles of internal combustion engine action it will not be difficult to apply this knowledge to all forms of gasoline motors used as automobile power plants.

Forms of Engines Commonly Used.—If one raises the hood at the front of a motor car, one will find a complete engine assembly very

much the same as that depicted at Fig. 85, which outlines a conventional engine with the various auxiliary parts lettered so that one can obtain an idea of their location relative to each other.

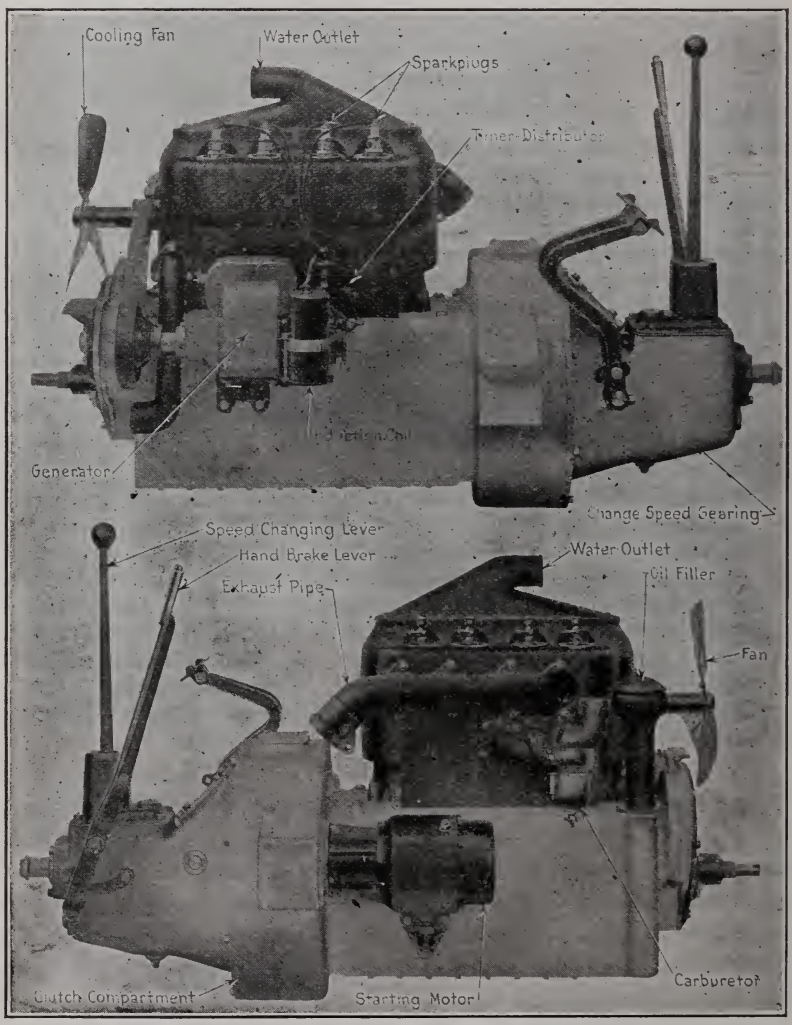


Fig. 85.—Views of the Empire Four-Cylinder Power Plant, Showing Important Auxiliaries.

Of the external parts shown the carburetor is employed to mix the gasoline used as fuel with a certain amount of air in order to form a gas that can be ignited in the engine cylinders. This explosive mixture is supplied to the cylinders by a conductor known as the

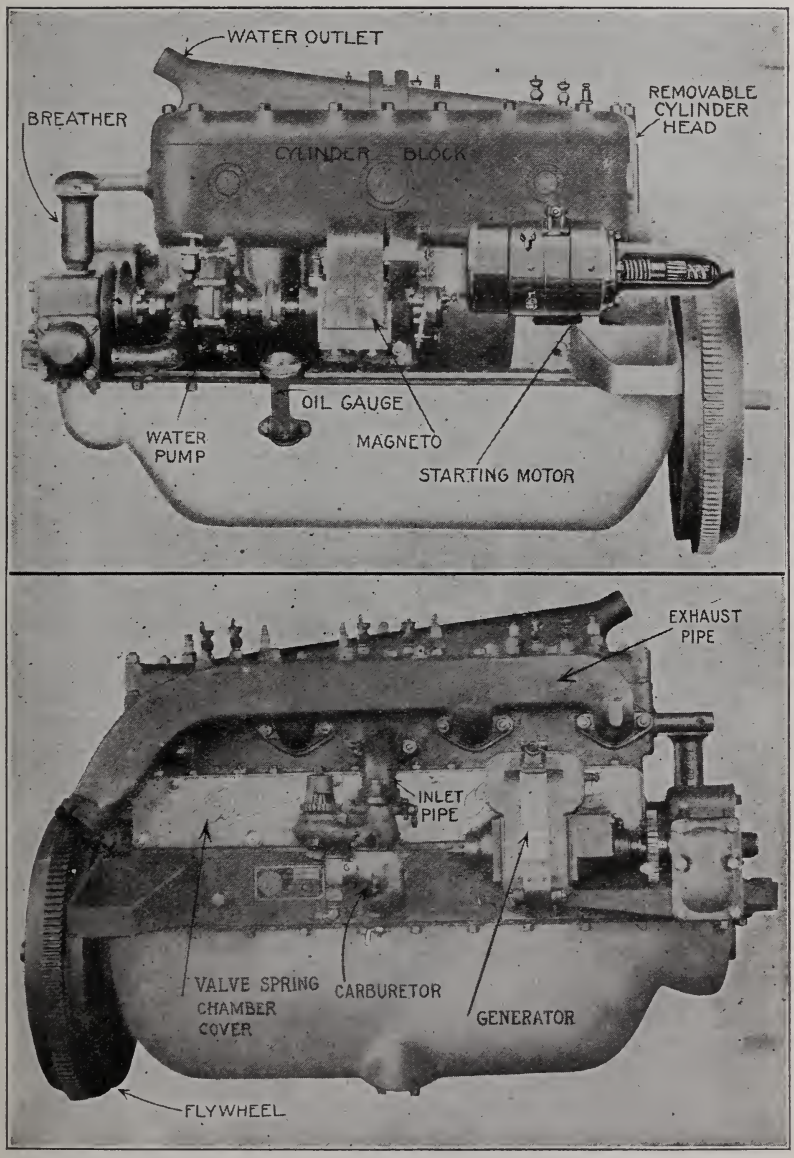


Fig. 86.—Views of Overland Model 82 Six-Cylinder Motor, Showing Typical Block Motor Design.

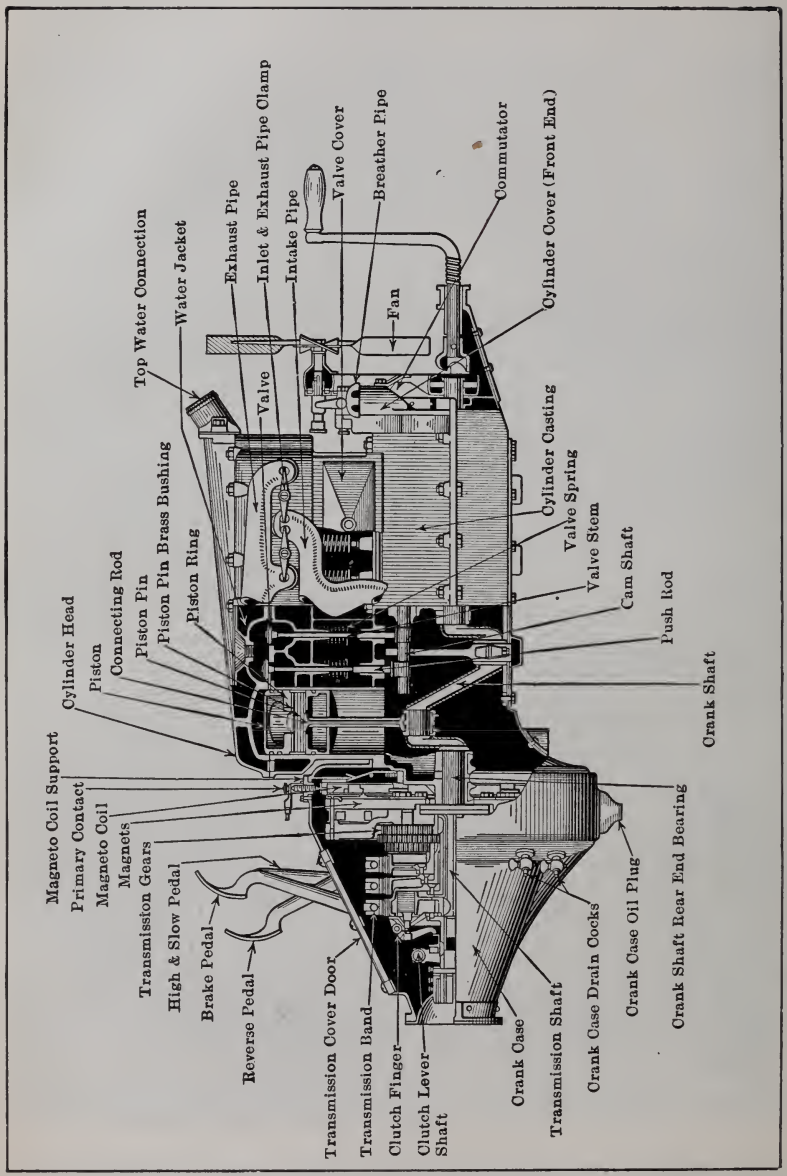


Fig. 87.—Part Sectional View of the Ford Four-Cylinder Unit Power Plant.

inlet pipe. The spark plug and timer-distributor form part of the ignition outfit. The engine shown at Fig. 85 is a four-cylinder form and operates on the four-cycle principle. That depicted at Fig. 86 is a six-cylinder of modern design. Various forms of engines have been applied to automobile propulsion, and of the large number of different types, the majority operate on the four-stroke principle, though the two-stroke types are simpler. In the latter there is an explosion in each cylinder every turn of the crank shaft, while the other method provides but one power impulse per cylinder every two turns of the revolving elements. Though the four-stroke motor is more complicated in construction than the other it is the easiest to understand. All internal combustion motors, usually termed "gasoline engines" because of the use of this liquid fuel, are forms of heat motors owing to the energy being produced by the rapid burning, or combustion, of a gas which expands after it is exploded and produces pressure that is transformed into mechanical power by simple mechanism. In defining the principles of four-cycle motor action, one can explain the matter very clearly by comparing the effect produced by exploding gasoline gas to that which obtains when one explodes gunpowder in a gun.

How the Gasoline Engine Works.—At Fig. 88, A, the upper view shows a section through a simple one-cylinder gasoline engine, while the lower one illustrates an old pattern muzzle loading cannon. Considering first the phenomena which obtains when gunpowder is burned, one can obtain some idea of how exploded gasoline vapor may be transformed into power. In fact, the preliminary operations which have been necessary before the gun was fired, are very similar to those which preceded an explosion in the cylinder of the gasoline engine of the four-cycle type. Following first the cycle of operations necessary to fire the cannon, graphically shown at the lower portion of Fig. 88, it will be seen that a certain sequence is necessary. At A we have the loading, or charging of the mortar. The powder which is carried in bags for convenience is introduced in the muzzle and pushed back into the breech with the ramrod. After the powder has been compressed the ball is placed and tightly rammed in place on top of the powder in the explosion chamber, as shown at B. After the powder is properly compacted it is exploded by means of a lighted fuse, or percussion cap, and the cannon ball is forced out through the open end because of the pressure of gas on its underside, this having been produced by the rapid burning of the powder.

The next operation is clearing the mortar of the burned gases in order to introduce a fresh charge of powder and shot. The clear-

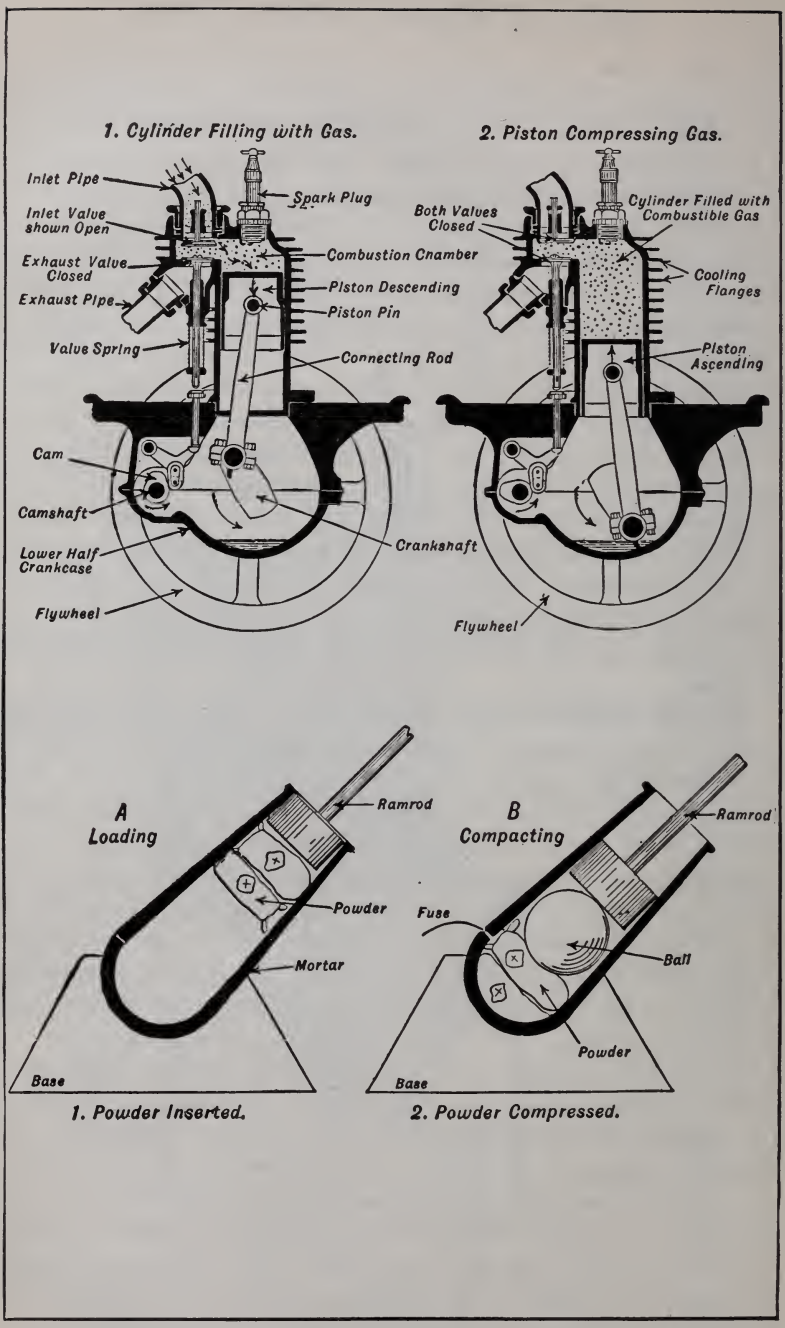


Fig. 88—Diagram Comparing Action of Four-Cycle Engine with That of Muzzle-Loading Cannon, in Order to Simplify Explanation of Cycle of Operations, Thus Enabling the Reader to Comprehend This Fundamental Principle Clearly.

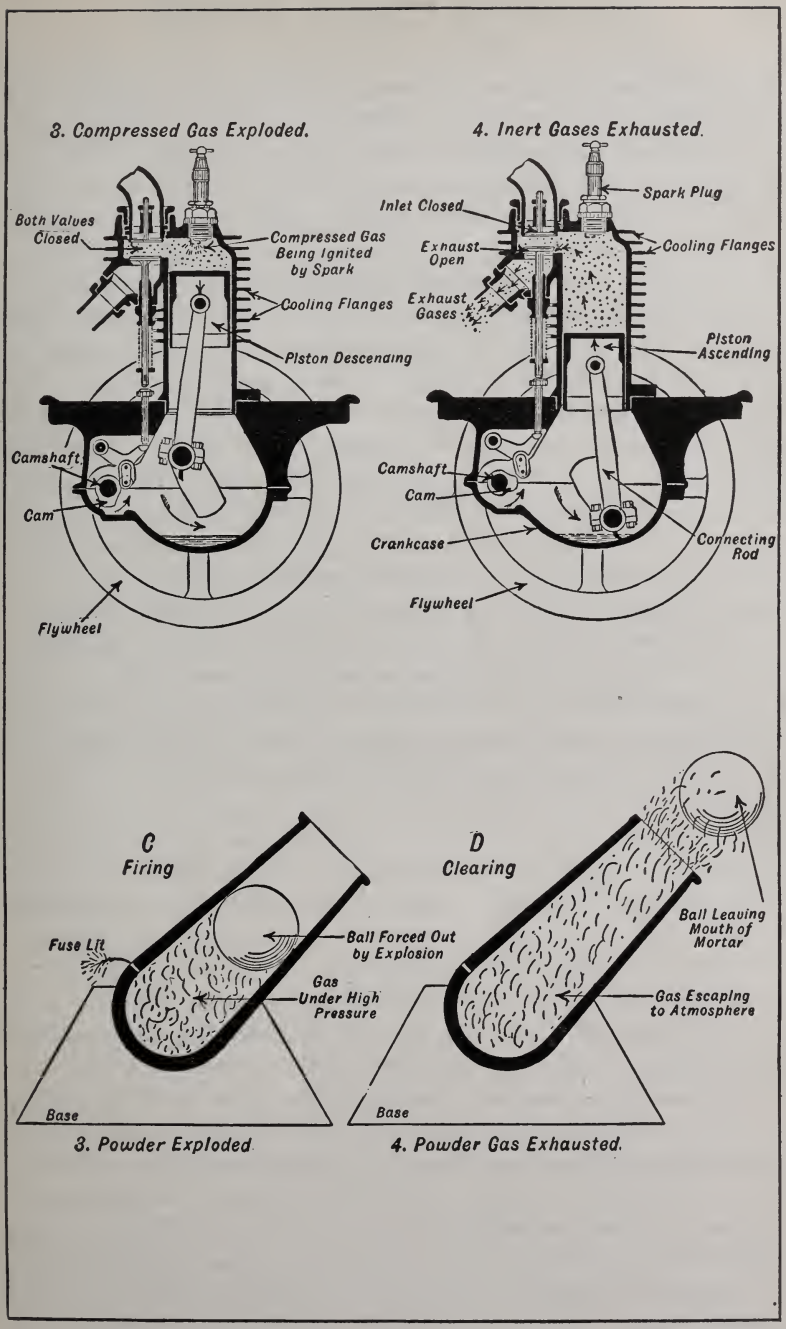


Fig. 88—Continued.

ing is automatically performed, as shown at D. As soon as the ball leaves the mouth of the mortar the gas which is still under high pressure escapes to the atmosphere. After the barrel is swabbed out, one can introduce another charge and fire the cannon again. The power to propel the shot through the air has been obtained by burning a substance which before ignition had no power to produce motion of the ball. If an equal charge of gunpowder had been placed in the open air and the shot placed upon it, one would find that if the combustible material were ignited, there would be very little energy produced. There would be a flash of flame, but it is doubtful that this would have sufficient energy to cause the cannon ball to leave its position. Powder compacted in the cannon barrel produced useful energy because pressure was confined in a chamber having rigid walls at all sides, except one, this being the side of the cannon ball nearest the explosive. The metal surrounding the explosion chamber had sufficient strength to resist the high gas pressure, but the ball which was movable was driven out because its weight was not sufficient to resist the force applied to it by the exploded powder.

It is evident that burning powder in the air will produce a certain amount of energy, but as the explosion takes place in the open there will be nothing to restrain the pressure, and just as soon as the powder is lighted any energy evolved is dissipated into the atmosphere instead of the force being directed against yielding members. The ball is forced out of the gun barrel, not only by the gas pressure which results as soon as the powder is exploded, but also by the expansion of the gases generated by combustion which tends to accelerate its motion toward the end of the barrel. As the shot moves toward the end and the gas occupies more space its pressure becomes less, and when the ball leaves the mouth of the motor there is very little power remaining in the moving gas. There is sufficient pressure, however, so that the gas rushes out of the interior and the barrel is thus cleared of inert products which have no useful force.

The action of a modern repeating rifle is somewhat different than that of a muzzle loader, because the powder is already compressed in metal shells which are introduced at the breech of the gun instead of at the muzzle. The number of shells are carried in a magazine, and after one of these explodes the recoil due to the explosion of the gas supplies another charged shell to the breech and the operation of firing the gun may be repeated as long as the supply of ammunition in the magazine lasts.

The modern gasoline engine follows the action of both the old type muzzle loader and the more modern form in which the shell is

introduced at the breech. Referring again to sketches at top of Fig. 88 and at Fig. 89, we can compare the action of a simple four-stroke engine with that of a cannon which is illustrated below them. The principal elements of a gas engine are not difficult to understand and their functions are easily defined. In place of the barrel of the gun one has a smoothly machined cylinder in which a small cylindrical or barrel-shaped element fitting the bore closely may be likened to a bullet or cannon ball. It differs in this important respect, however, as while the shot is discharged from the mouth of the cannon the piston member sliding inside of the main cylinder cannot leave it, as its movements back and forth from the open to the closed end and back again are limited by simple mechanical connection or linkage which comprises crank and connection rod. It is by this means that the reciprocating movement of the piston is transformed into a rotary motion of the crank shaft.

The fly wheel is a heavy member attached to the crank shaft which has energy stored in its rim as the member revolves, and the momentum of this revolving mass tends to equalize the intermittent pushes on the piston head produced by the explosion of the gas in the cylinder. If some explosive is placed in the chamber formed by the piston and closed end of the cylinder and exploded, the piston would be the only part that would yield to the pressure which would produce a downward movement. As this is forced down the crank shaft is turned by the connecting rod, and as this part is hinged at both ends it is free to oscillate as the crank turns, and thus the piston may slide back and forth while the crank shaft is rotating or describing a curvilinear path.

In addition to the simple elements described it is evident that a gasoline engine must have other parts. The most important of these are the valves, of which there are two to each cylinder. One closes the passage connecting to the gas supply and opens during one stroke of the piston in order to let the explosive gas into the combustion chamber. The other member, or exhaust valve, serves as a cover for the opening through which the burned gases can leave the cylinder after their work is done. The spark plug is a simple device which may be compared to the fuse or percussion cap of the cannon. It permits one to produce an electric spark in the cylinder when the piston is at the best point to utilize the pressure which obtains when the compressed gas is fired. The valves are open one at a time, the inlet valve being lifted from its seat while the cylinder is filling and the exhaust valve is opened when the cylinder is being cleared. They are normally kept seated by means of compression springs. In the

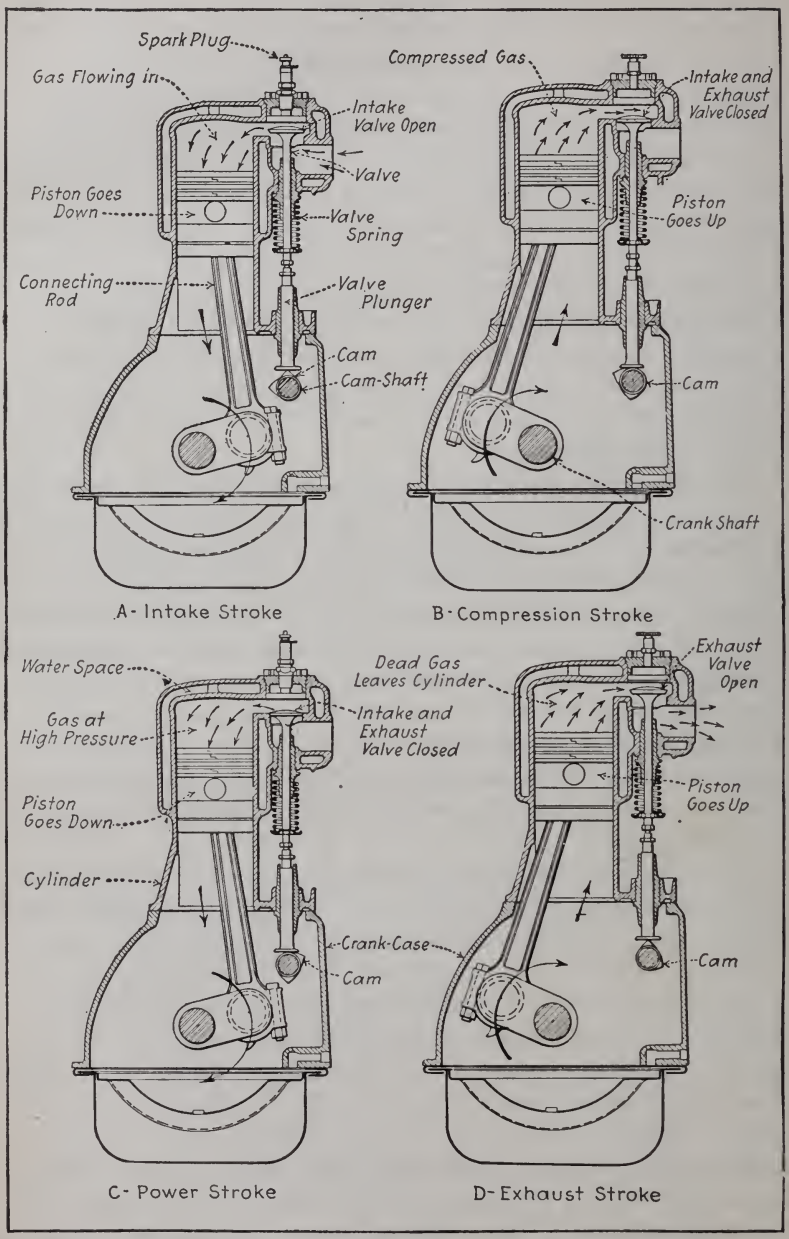


Fig. 89.—Diagrams Showing Piston Movements on the Various Strokes in a Four-Cycle Engine.

simple motor shown at Fig. 88, the exhaust valve is operated by means of a pivoted bell crank rocked by a cam which turns at half the speed of the crank shaft. The inlet valve operates automatically, as will be explained in proper sequence.

Considering the view shown at Fig. 89, A, the first necessary operation is charging the cylinder with explosive material. The piston is at the top of its stroke and it moves toward the open end of the cylinder. The engine works as a pump, and the piston draws in a charge of combustible gas through the open intake valve, which is in connection with the vaporizer which furnishes the gas. An automatic valve opens because of a light vacuum or suction existing when the piston has traveled down a certain portion of its stroke, and then the outside air pressure is greater than that in the cylinder. The external air pressure is greater than the tension of the spring which tends to keep the valve closed and the member is therefore drawn from its seat by the piston. At the end of the intake stroke and after the cylinder has filled with gas the pressure inside and outside is the same and the valve spring closes the intake valve. As the exhaust valve spring is very strong this member has not been lifted from its seat by the difference in pressure. The exhaust valve is opened by mechanical means solely and lifts only when operated by the cam and push-rod mechanism.

The condition in the cylinder and the gas engine after the piston has reached the bottom of its stroke is very much the same as that which obtains in a gun of the muzzle-loading type after the explosive charge has been introduced. We have learned that, to obtain power from gunpowder, it was necessary to compact it firmly in the combustion chamber of the gun. The gasoline gas which has been taken into the engine cylinder must also be compressed before it is ignited, in order to obtain power. It is compacted into one-third or one-quarter of its former volume, and whereas its pressure is about fifteen pounds per square inch before it is compacted at the end of the compression stroke of the piston the pressure will be increased to forty-five, sixty, and even seventy-five pounds per square inch. At the end of this compression stroke, which is shown at B, the conditions in the engine cylinder are the same as those which prevail in the barrel of the cannon after the powder has been tightly rammed in the closed end of the gun barrel and the ball is forced in on top of it. At C we have seen that the powder was fired by means of a fuse. The compressed gas in the engine cylinder is exploded electrically by a spark occurring between the points of the spark plug. The explosion in the cannon drives out the ball, while that in the

engine cylinder forces the piston out and causes the crank shaft and fly wheel attached to it to revolve.

In order to obtain a perfectly tight combustion chamber, both intake and exhaust valves are closed before the gas is ignited, because all of the pressure produced by the exploding gas is to be directed against the top of the movable piston. When the piston reaches the bottom of its power stroke, as indicated at D, the exhaust valve is lifted by means of the bell crank which is rocked because of the point or lift on the cam. The cam shaft is driven by positive gearing and revolves at half the engine speed. The exhaust valve remains open during the whole of the return stroke of the piston, and as this member moves toward the closed end of the cylinder it forces out burned gases ahead of it, through the passage controlled by the exhaust valve. The cam shaft is revolved at half the engine speed because the exhaust valve is raised from its seat during only one stroke out of four, or only once every two revolutions. Obviously, if the cam was turned at the same speed as the crank shaft it would remain open once every revolution, whereas the burned gases are expelled only once in two turns of the crank shaft.

It will be evident that three strokes of the piston are necessary to secure one useful explosion, just as practically three operations are needed to fire the cannon. The first downward movement of the piston fills the cylinder with gas and is known as the "intake stroke." This is accomplished during the first half revolution of the crank shaft. The return movement of the piston is accomplished during the second half of the first revolution and compacts the gas previously inspired. This is called the "compression stroke." The expansive force back of the piston produced by the explosion forces the piston down again, this turning the crank shaft through the first half of the second revolution, which is known as the "power stroke." The last half of the second revolution produces a return movement of the piston toward the closed end, and as the burned gases are expelled and the cylinder is cleared to receive the fresh charge, this movement of the piston is known as the "exhaust stroke." The cycle of operations described is continued and repeats as long as the cylinder is supplied with fuel, the spark takes place to fire the gas and the engine prevented from overheating by means of lubrication between all moving parts and cooling those portions liable to become excessively hot by suitable extraneous means.

Typical Single-Cylinder Engines Described.—The gasoline engine may have any number of cylinders, though the conventional types used in automobile propulsion seldom use any but an even number,

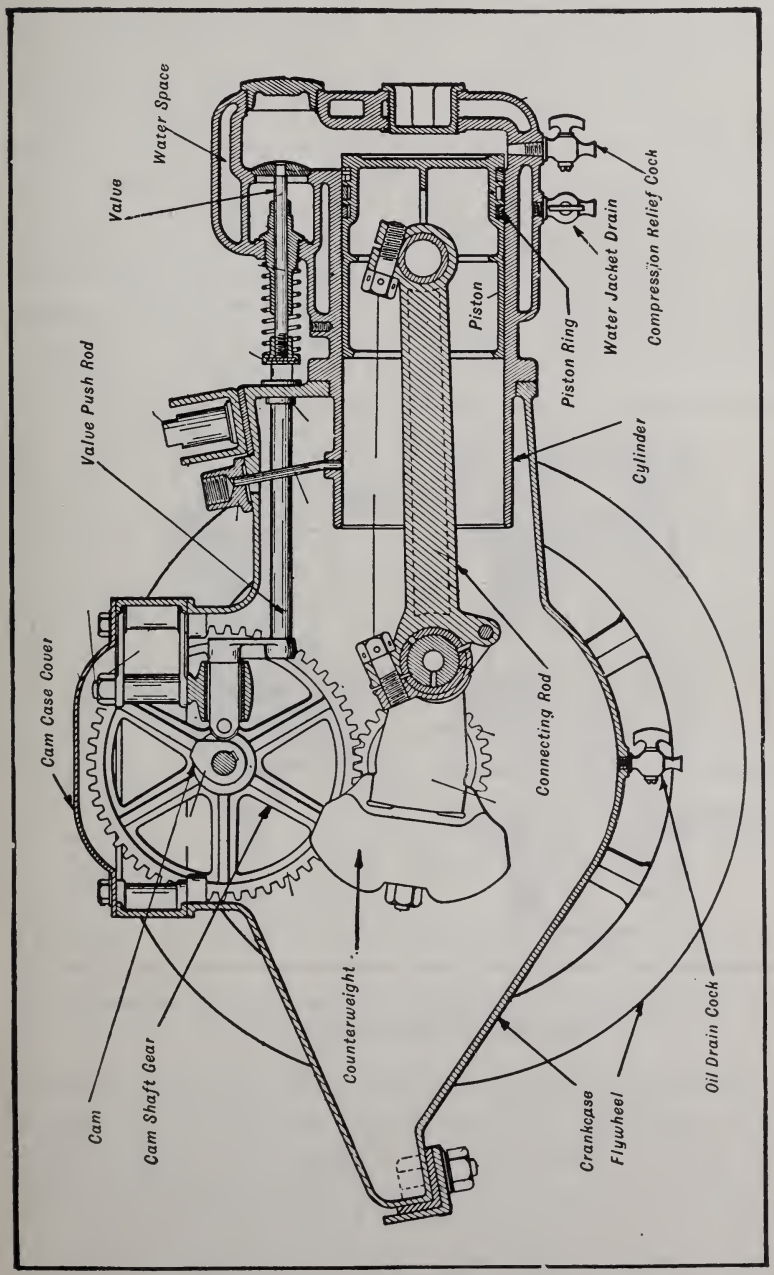


Fig. 90.—Sectional View of One-Cylinder Horizontal Engine Used on Early Reo Models, a Type that is Now Obsolete for Automobile Work and Used Only in Stationary Service.

usually four or six, and rarely more than twelve. At one time single-cylinder motors were very popular. These were used in both the horizontal and vertical types. A typical form of horizontal motor is shown at Fig. 90. Power plants of this type were, for the most part, of low power and were patterned largely after stationary gasoline engine practice as far as proportion of parts was concerned. They were heavy and operated at low speed. Such engines are never employed as automobile power plants at the present time, except in cars of ancient construction, some of which are still in use. Though this type of motor was comparatively slow acting and considerable vibration existed while it was in operation, they were strongly constructed and capable of giving very satisfactory service. Engines of this type are usually installed under the body, the engine cylinder

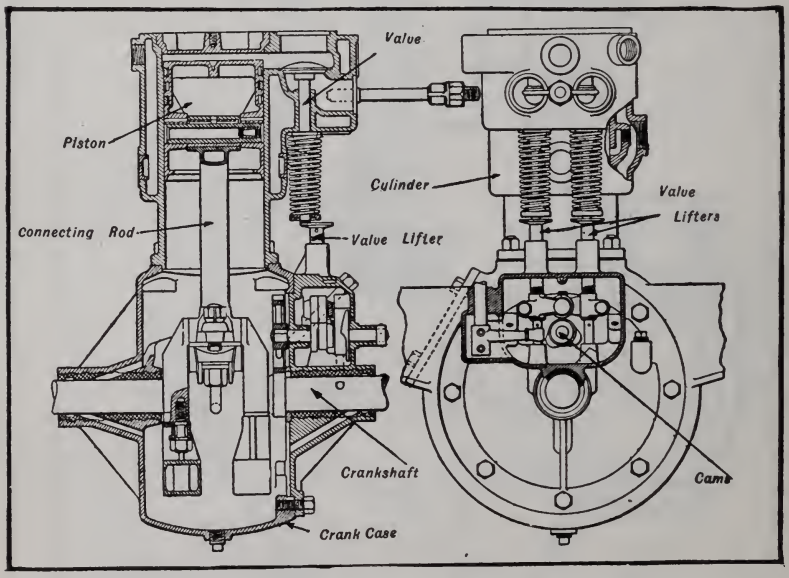


Fig. 91.—Sectional View of Brush Runabout Motor, an Early, Single-Cylinder, High-Speed, Vertical Power Plant.

being parallel with the frame side member, while the crank shaft was at right angles to it. This permitted a very simple and efficient method of power transmission as the change speed gearing which was usually carried on the crank shaft extension could be easily coupled to the rear axle by means of a single chain and a pair of sprockets.

Owing to the vibration which obtains from the heavy explosion in the large single-cylinder engine other forms were evolved in which

the cylinder was smaller and power obtained by running the engine faster. The single-cylinder motor of the vertical type is shown at Fig. 91. The pattern shown at Fig. 90 is distinctively of American derivation and was designed to avoid the rapid wearing and noisy acting single-cylinder motors of the foreign vertical type.

When a single-cylinder engine is employed a very heavy fly wheel is needed to carry the moving parts through idle strokes necessary to obtain a power impulse. For this reason modern designers prefer to use more than one cylinder, and the tendency is to produce power by frequently occurring light impulses rather than by a smaller number of explosions having greater force. When a single-cylinder motor is employed the construction is heavier than is needed with a multiple-cylinder form. Using four or more cylinders conduces to steady power generation and a lessening of vibration. Most modern motor cars employ four-cylinder engines because a power impulse may be secured twice every revolution of the crank shaft, or a total of four-power strokes during two revolutions. The parts are so arranged that while the charge of gas in one cylinder is exploding, those which come next in firing order are compressing, discharging the inert gases and drawing in a fresh charge respectively. When the power stroke is completed in one cylinder, the piston in that member in which a charge of gas has just been compressed has reached the top of its stroke and when the gas is exploded the piston is reciprocated and keeps the crank shaft turning. When a four-cylinder engine is used the fly wheel is much lighter than that of the single-cylinder form. In fact, many modern four-cylinder engines developing thirty horse power weigh less than the early single-cylinder forms which developed but one-third or one-fourth that amount of energy. A very popular four-cylinder engine, that used in Ford automobiles, is shown at Fig. 87, with all parts clearly indicated.

Describing Sequence of Operations.—Referring to Fig. 92, A, the sequence of operation in a single-cylinder motor can be easily understood. Assuming that the crank shaft is turning in the direction of the arrow, it will be seen that the intake stroke comes first, then the compression, which is followed by the power impulse, and lastly the exhaust stroke. If two cylinders are used, it is possible to balance the explosions in such a way that one will occur each revolution. This is true with either one of two forms of four-cycle motors. At B, a two-cylinder vertical engine using a crank shaft in which the crank pins are on the same plane is shown. The two pistons move up and down simultaneously. Referring to the diagram describing the strokes, and assuming that the outer circle represents the cycle of operations in one

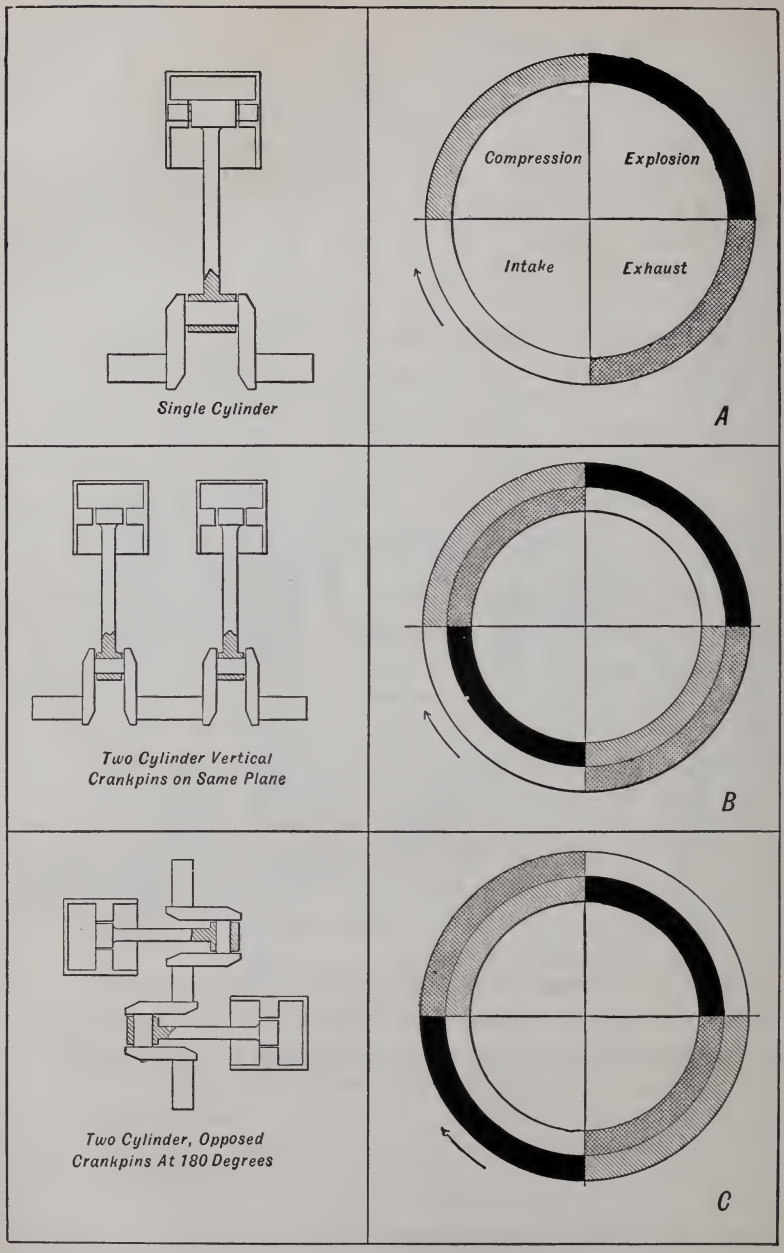


Fig. 92.—Diagrams Illustrating Sequence of Cycles in One- and Two-Cylinder Engines Show More Uniform Turning Effort on the Crank Shaft of Two-Cylinder Motors.

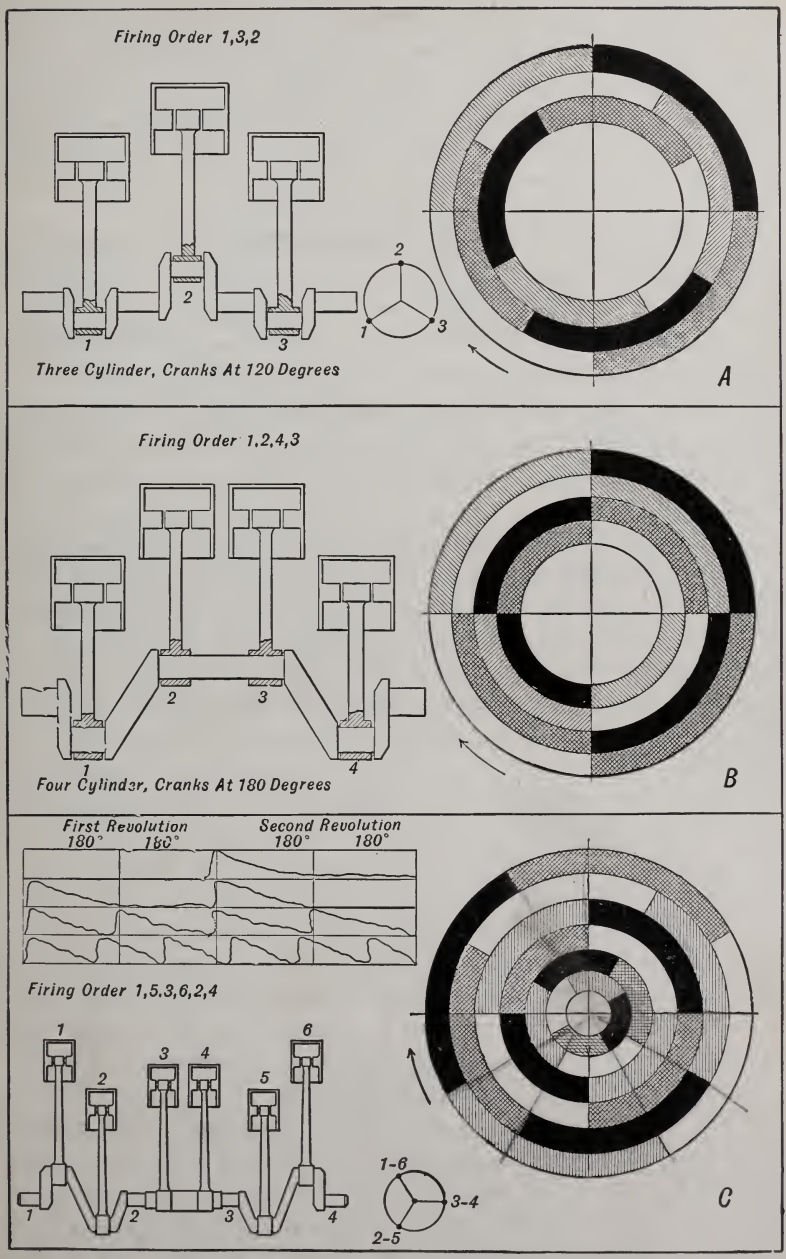


Fig. 93.—Diagrams Demonstrating Clearly Advantages which Obtain when Multiple Cylinder Motors are Used as Power Plants.

cylinder while the inner circle represents the sequence of events in the other cylinder, while cylinder No. 1 is taking in a fresh charge of gas, cylinder No. 2 is exploding. When cylinder No. 1 is compressing, cylinder No. 2 is exhausting. During the time that the charge in cylinder No. 1 is exploded, cylinder No. 2 is being filled with fresh gas. While the exhaust gases are being discharged from cylinder No. 1, cylinder No. 2 is compressing the gas previously taken in.

The same condition obtains when the crank pins are arranged at one hundred and eighty degrees and the cylinders are opposed, as shown at C. The reason that the two-cylinder opposed motor is more popular than that having two vertical cylinders is that it is difficult to balance the construction shown at B, so that the vibration will not be excessive. The two-cylinder opposed motor has much less vibration than the other form, and as the explosions occur evenly and the motor is a simple one to construct, it has been very popular in the past on light cars.

To demonstrate very clearly the advantages of multiple-cylinder engines the diagrams at Fig. 93 have been prepared. At A, a three-cylinder motor, having crank pins at one hundred and twenty degrees, which means that they are spaced at thirds of the circle, we have a form of construction that gives a more even turning than that possible with a two-cylinder engine. Instead of one explosion per revolution of the crank shaft, one will obtain three explosions in two revolutions. The manner in which the explosion strokes occur and the manner they overlap strokes in the other cylinder are shown at A. Assuming that the cylinders fire in the following order, first No. 1, then No. 3, and last No. 2, we will see that while cylinder No. 1, represented by the outer circle, is on the power stroke, cylinder No. 3 has completed the last two-thirds of its exhaust stroke and has started on its intake stroke. Cylinder No. 2, represented by the middle circle, during this same period has completed its intake stroke and two-thirds of its exhaust stroke. A study of the diagram will show that there is an appreciable lapse of time between each explosion.

In the four-cylinder engine operation which is shown at Fig. 36, B, it will be seen that the power strokes follow each other without loss of time, and one cylinder begins to fire and the piston moves down just as soon as the member ahead of it has completed its power stroke. In a four-cylinder motor, the crank pins are placed at one hundred and eighty degrees, or on the halves of the crank circle. The crank pins for cylinders No. 1 and No. 4 are on the same plane, while those for cylinders No. 2 and No. 3 also move in unison. The diagram describing sequence of operations in each cylinder is based on a firing

order of one, two, four, three. The outer circle, as in previous instances, represents the cycle of operations in cylinder one. The next one toward the center, cylinder No. 2, the third circle represents the sequence of events in cylinder No. 3, while the inner circle outlines the strokes in cylinder four. The various cylinders are working as follows:

1.	2.	3.	4.
Explosion	Compression	Exhaust	Intake
Exhaust	Explosion	Intake	Compression
Intake	Exhaust	Compression	Explosion
Compression	Intake	Explosion	Exhaust

It will be obvious that regardless of the method of construction, or the number of cylinders employed, exactly the same number of parts must be used in each cylinder assembly and one can conveniently compare any multiple-cylinder power plant as a series of single-cylinder engines joined one behind the other and so coupled that one will deliver power and produce useful energy at the crank shaft where the other leaves off. The same fundamental laws governing the action of a single cylinder obtain when a number are employed, and the sequence of operation is the same in all members, except that the necessary functions take place at different times. If, for instance, all the cylinders of a four-cylinder motor were fired at the same time, one would obtain the same effect as though a one-piston engine was used, which had a piston displacement equal to that of the four smaller members. As is the case with a single-cylinder engine the motor would be out of correct mechanical balance because all the connecting rods would be placed on crank pins that lie in the same plane. A very large fly wheel would be necessary to carry the piston through the idle strokes, and large balance weights would be fitted to the crank shaft in an effort to compensate for the weight of the four pistons, and thus reduce vibratory stresses which obtain when parts are not in correct balance.

There would be no advantage gained by using four cylinders in this manner, and there would be more loss of heat and more power consumed in friction than in a one-piston motor of the same capacity. This is the reason that when four cylinders are used the arrangement of crank pins is always as shown at Fig. 93, B—i. e., two pistons are up, while the other two are at the bottom of the stroke. With this construction, we have seen that it is possible to string out the explosions so that there will always be one cylinder applying power to the crank shaft. The explosions are spaced equally. The parts are in

correct mechanical balance because two pistons are on the upstroke while the other two are descending. Care is taken to have one set of moving members weigh exactly the same as the other. With a four-cylinder engine one has correct balance and nearly continuous application of energy. This insures a smoother running motor which has greater efficiency than the simpler one-, two-, and three-cylinder forms previously described. Eliminating the stresses which would obtain if we had an unbalanced mechanism and irregular power application makes for longer life. Obviously a large number of relatively light explosions will produce less wear and strain than would a lesser number of powerful ones. As the parts can be built lighter if the explosions are not heavy, the engine can be operated at higher rotative speeds than when large and cumbersome members are utilized.

The six-cylinder type of motor, the action of which is shown at Fig. 93, C, is superior to the four-cylinder inasmuch as the power strokes overlap, and instead of having two explosions each revolution we have three explosions. The conventional crank-shaft arrangement in a six-cylinder engine is just the same as though one used two three-cylinder shafts fastened together so pistons 1 and 6 are on the same plane, as are pistons 2 and 5. Pistons 3 and 4 also travel together. With the cranks arranged as outlined at Fig. 93, C, the firing order is one, five, three, six, two, four. The manner in which the power strokes overlap is clearly shown in the diagram. An interesting comparison is also made in the small diagram in the upper left-hand corner of this view.

A rectangle is divided into four columns; each of thesse corresponds to one hundred and eighty degrees, or half a revolution. Thus the first revolution of the crank shaft is represented by the first two columns, while the second revolution is represented by the last two. Taking the portion of the diagram which shows the power impulse in a one-cylinder engine, we see that during the first revolution there has been no power impulse. During the first half of the second revolution, however, an explosion takes place and a power impulse is obtained. The last portion of the second revolution is devoted to exhausting the burned gases, so that there are three idle strokes and but one power stroke. The effect when two cylinders are employed is shown immediately below.

Here we have one explosion during the first half of the first revolution in one cylinder and another during the first half of the second revolution in the other cylinder. With a four-cylinder engine there is an explosion each half revolution, while in a six-cylinder engine there is one and one-half explosions during each half revolution. When

six cylinders are used there is no lapse of time between power impulses, as these overlap and a continuous and smooth-turning movement is imparted to the crank shaft.

Actual Duration of Different Strokes.—In the diagrams presented at Figs. 92 and 93, the writer has assumed, for the sake of simplicity, that each stroke takes place during half of one revolution of the crank shaft, which corresponds to a crank-pin travel of one hundred

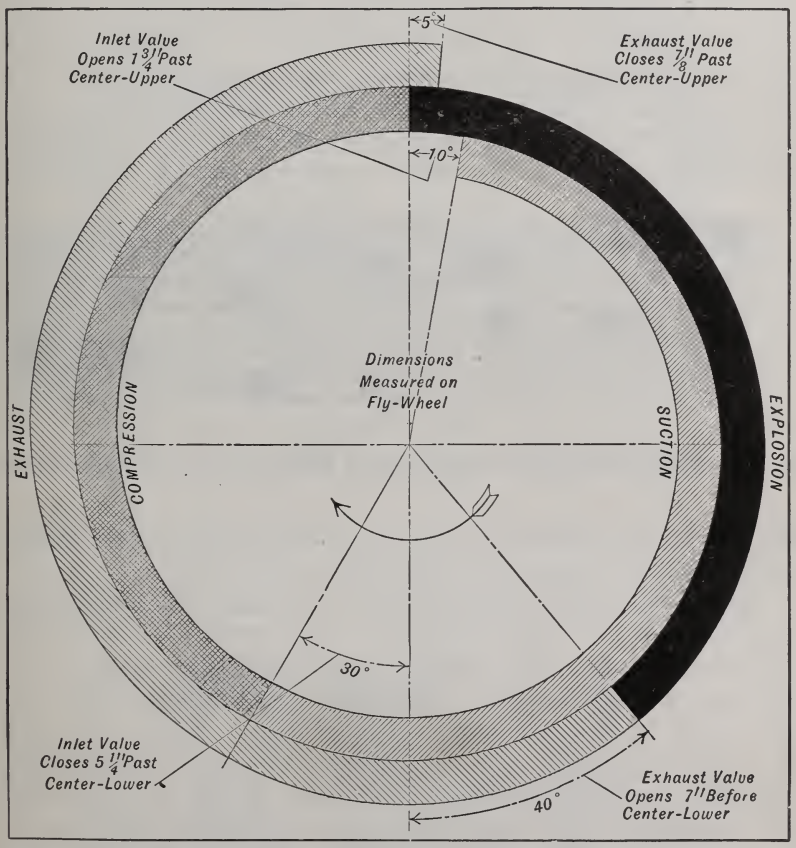


Fig. 94.—Diagram Showing Actual Duration of Different Cycle Functions in Degrees.

and eighty degrees. The actual duration of these strokes is somewhat different. For example, the inlet stroke is usually a trifle more than a half revolution, and the exhaust is always considerably more. The diagram showing the comparative duration of the strokes is shown at Fig. 94. The inlet valve opens ten degrees after the piston starts to go down and remains open thirty degrees after the piston has

reached the bottom of its stroke. This means that the engine stroke corresponds to a crank-pin travel of two hundred degrees, while the compression stroke is measured by a movement of but one hundred and fifty degrees. It is common practice to open the exhaust valve before the piston reaches the end of the power stroke so that the actual duration of the power stroke is about one hundred and forty degrees, while the exhaust stroke corresponds to a crank-pin travel of two hundred and twenty-five degrees. In this diagram, which represents proper time for the valves to open and close, the dimensions in inches given are measured on the fly wheel and apply only to the "Model M" Thomas motor. If the fly wheel were smaller ten degrees would take up less than the dimensions given, while if the fly wheel was larger a greater space on its circumference would represent the same crank-

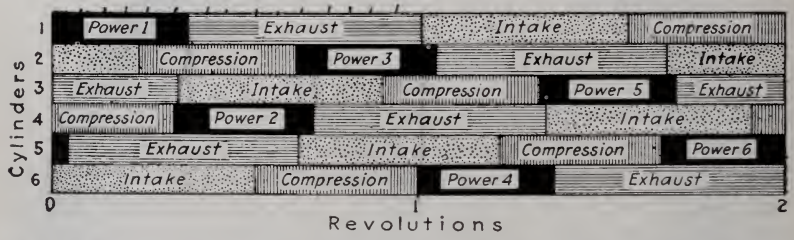


Fig. 95.—Diagram Showing Overlap of Power Strokes in a Six-Cylinder Engine.

pin travel. The diagram at Fig. 95 shows how the various strokes overlap on a six-cylinder motor that fires 1, 4, 2, 6, 3, 5.

Typical Engine Types Described.—A very simple and efficient type of power plant is shown at Fig. 96. In this motor the cylinders are horizontally disposed and opposed to each other. The valves are carried in a pocket, or chamber, on top of the cylinder and they are operated by direct push-rod movement from a cam shaft carried just above the crank shaft. The general arrangement of parts is clearly outlined, and as each component is indicated there should be no difficulty in grasping the details of this form of power plant. The engines illustrated at Fig. 96-A and Fig. 97 are simple four-cylinder types of modern construction and may be considered representative of standard practice. In these it will be seen that the four cylinders are arranged on a crank case common to them all. The crank case also acts as a supporting member for the crank shaft and cam shaft. A section of the crank case is broken away to show the crank-shaft design, and also to illustrate the method employed of raising the valves from their seats by means of cams. The front cylinder in Fig. 96-A is not sectioned. The second cylinder, which is immediately back of it, is sec-

tioned through the valve chest in order to show the gas passages and the method of closing them by mushroom valves. Cylinder No. 3 is

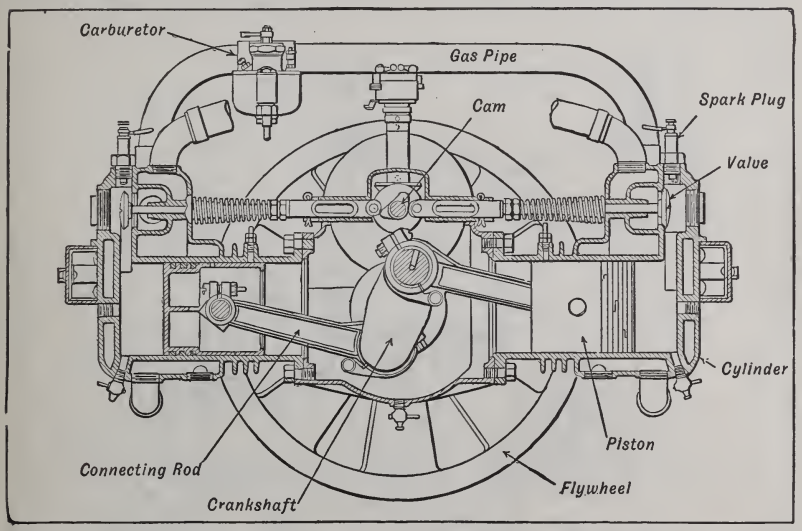


Fig. 96.—Simple Form of Two-Cylinder Motor Having Opposed Cylinders; Formerly a Very Popular Form of Power Plant for Light Cars.

divided on its center line to show the piston and connecting rod assembly, while the last cylinder is sectioned in such a way that the construction of the piston, connecting rod, and wrist pin is clearly shown.

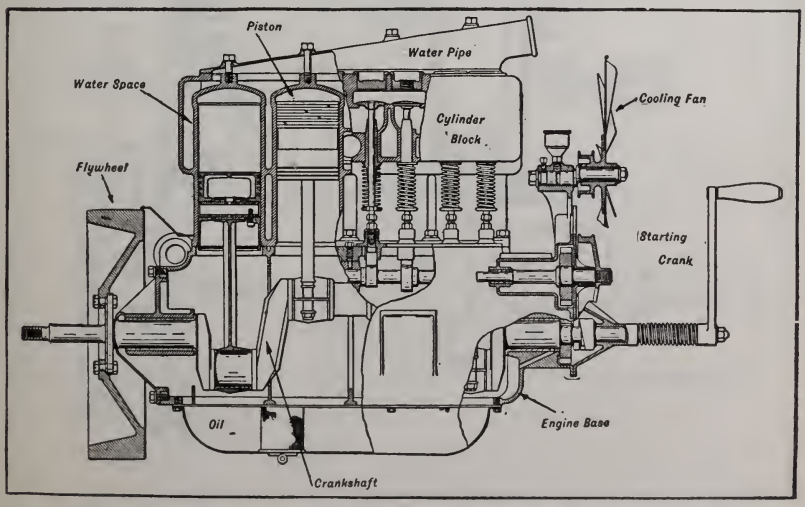


Fig. 96-A.—Sectional View of Four-Cylinder Motor, the Most Widely Used Type of Multiple Cylinder Engines.

Another type of four-cylinder engine sectioned in a somewhat similar manner with all parts indicated is shown at Fig. 98. A careful study of this illustration should familiarize one with the gen-

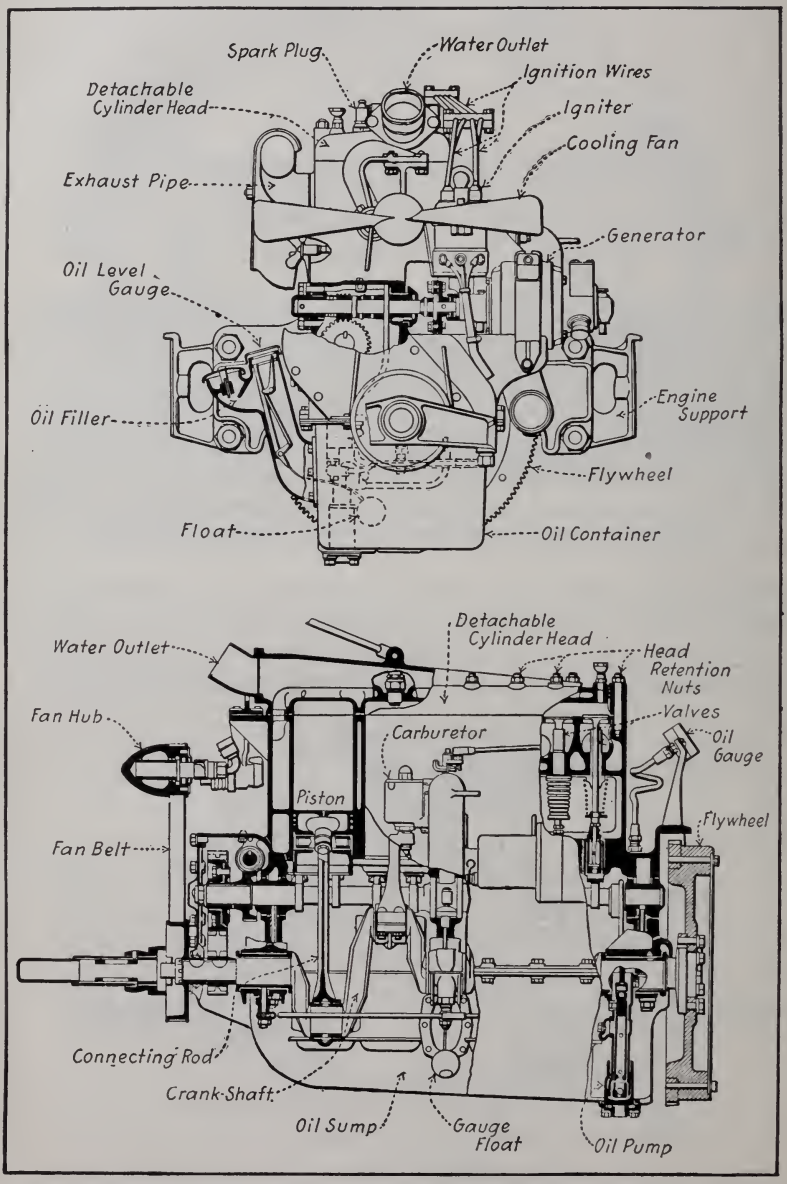


Fig. 97.—Sectional View Showing Construction of the Case Four-Cylinder Motor, a Modern Design.

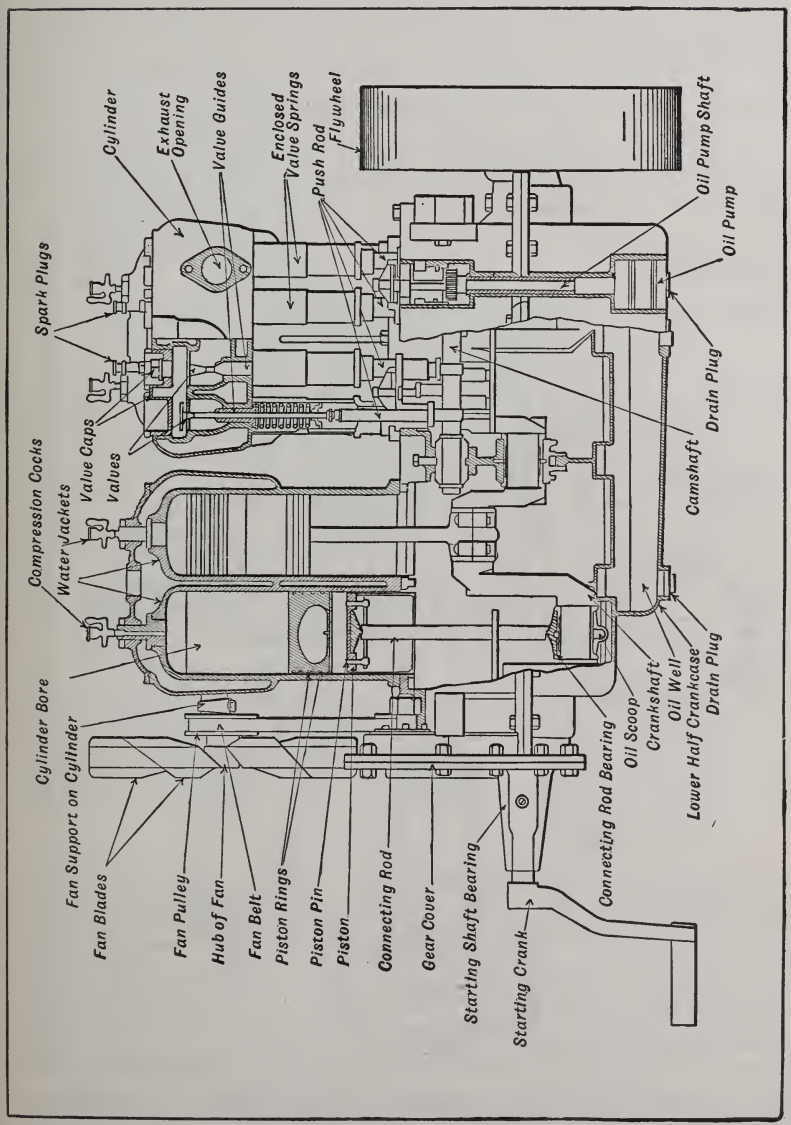


Fig. 98.—Sectional View of Typical Four-Stroke Cycle, Four-Cylinder Motor Truck Engine, Showing Important Internal Parts and Their Relation to Each Other.

eral arrangement of the parts of conventional motor truck power plants. The views shown at Figs. 96 and 98 are longitudinal sections. In order to show the appearance of the parts of an engine when one of the cylinders is cut in such a manner that it is viewed from the end rather than from the side, such a section is given at Fig. 99. As is the case in other illustrations all parts are clearly indicated. This view is also valuable in showing the arrangement of some of the auxiliary components, such as the water pump, which is used to circulate the cooling liquid; the carburetor, which is employed to furnish the

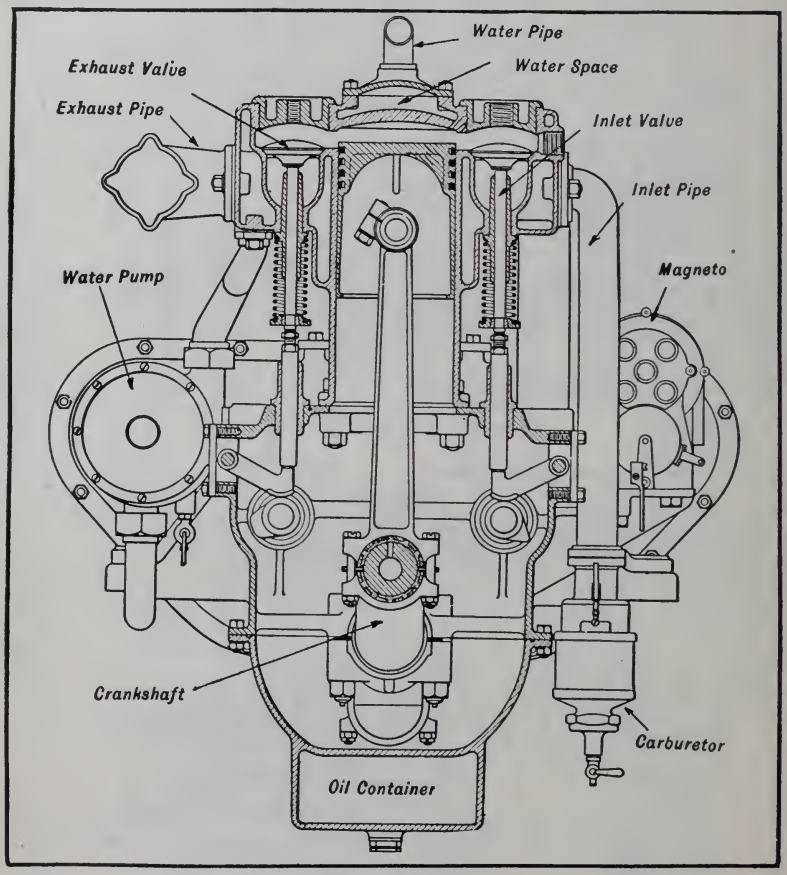


Fig. 99.—Sectional View of Rear Cylinder of Gasoline Engine of the T-Head Type, with Important Parts Indicated.

explosive mixture; and the magneto, which is supplied to ignite the compressed gas. The exhaust pipe, which is attached to the side of the cylinder to carry away the burned gases, and the sump, or oil con-

tainer, which carries a supply of the lubricant to keep the working surfaces free, are also outlined. The section at Fig. 100 shows an early eight-cylinder design.

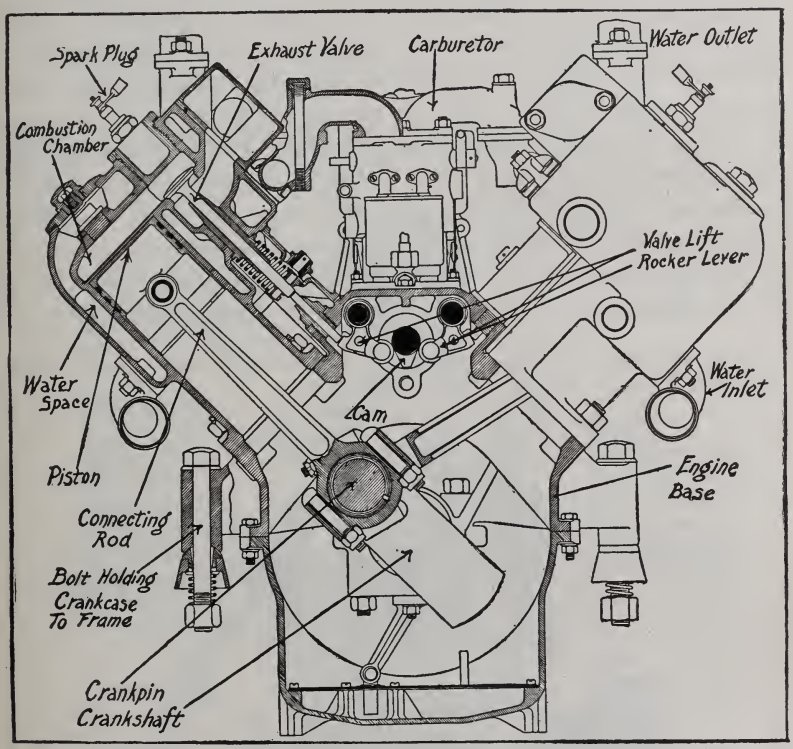


Fig. 100.—Part Sectional View of the De Dion Eight-Cylinder "V" Type Automobile Motor.

Features of the Knight Slide Valve Motor.—One of the latest tendencies of engineers responsible for the design of motor-car power plants is toward the elimination of all noises incidental to their operation. Much of this has been attributed to operation of the valves and in order to reduce the clatter, types of engines in which the poppet, or mushroom, valves are replaced by sliding or revolving elements are being extensively experimented with.

The earliest types of explosion motors, as evolved by Lenoir, Brayton, and Otto, employed simple slide valves which were patterned after those used in steam engines. Owing to faulty construction these early forms were not successful, as considerable difficulty was experienced from warping and in keeping the cylinder tight enough to retain gas pressure. In several engines of recent development the

mushroom valves are being replaced by sleeves which have a more gradual motion and which slide by ports in the cylinder instead of being brought forcibly in contact with the seats by a strong spring. An advantage of the slide valve motor, which is perhaps even more important than that of silence, is the increased flexibility and augmented power developed, because the large gas passages permit the entering stream of fresh vapor, or the departing current of inert gas to leave the cylinder without being impeded. The disadvantage often cited against poppet valves is that at high speeds they fail to follow the contour of their actuating cams accurately and there is considerable loss of power because of the irregular gas flow.

The most practical and satisfactory of the valveless motors now in use was invented by Charles Y. Knight, an American engineer, sev-

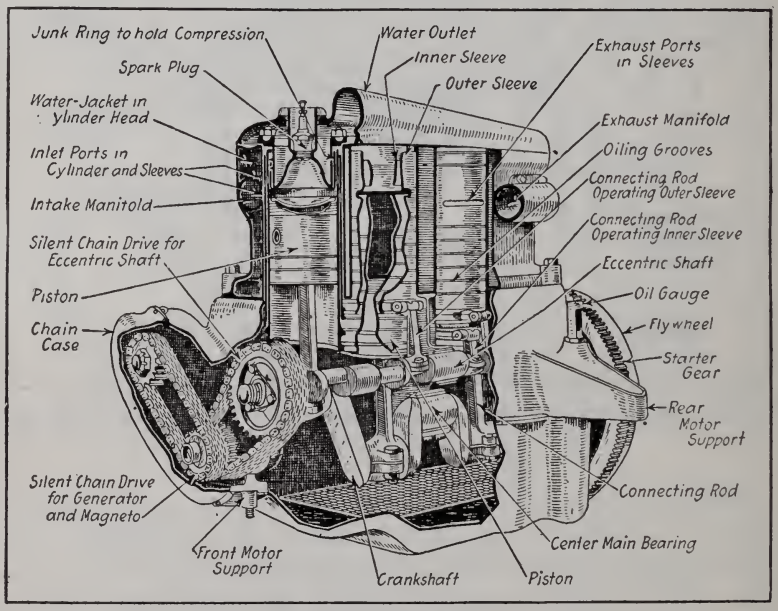


Fig. 101.—Part Sectional View of the Willis-Knight Four-Cylinder, Sleeve-Valve Motor.

eral years ago. When first introduced in this country it was met with considerable ridicule, and the inventor was forced to take his invention to Europe, where its advantages met with prompt recognition. The Knight valveless motor is now made and used by such celebrated automobile manufacturers as, Daimler, in England; Panhard-Levassor, in France; Minerva, in Belgium; and Mercedes, in Germany. In

this country it will be found on models of the Willys, Stearns, and Moline cars.

The operating principles in this engine do not differ materially from other four-cycle types, the only difference being in the method of admitting and expelling gases from the cylinder. The illustrations at Figs. 101 and 102 show very clearly the difference which exists

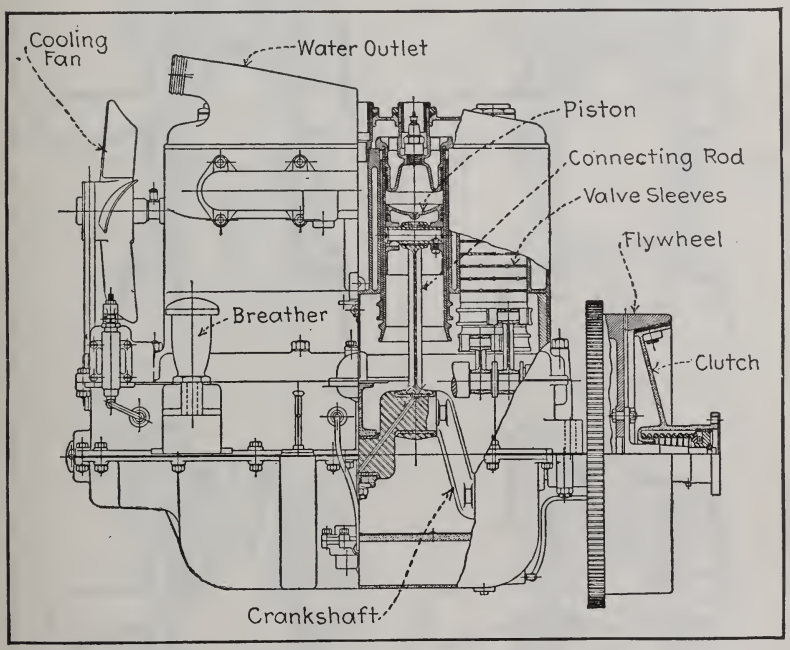


Fig. 102.—Part Sectional View of the Moline-Knight Four-Cylinder Motor.

between the slide valve and the conventional poppet valve motor. Both of these are the same in general design, except that changes have been made in the power plant to permit the use of reciprocating sleeves.

The Knight motor has four cylinders cast en bloc. The top of each cylinder has two lateral slots which communicate respectively with the inlet and exhaust pipes. The cylinder is water-jacketed, and inside of this member and interposed between it and the piston are two thin, hollow cast-iron cylinders, or sleeves, adapted to be moved up and down by a suitable crank shaft and connecting rod mechanism or eccentrics, as outlined in Fig. 103. These sleeves have large ports which communicate with the orifices in the cylinder wall. They are moved in such a manner that the slots in the cylinder are

opened and closed by the reciprocating movement of the sleeves. They are operated by small connecting rods which work from a smaller crank shaft mounted to one side of, and above the main crank shaft,

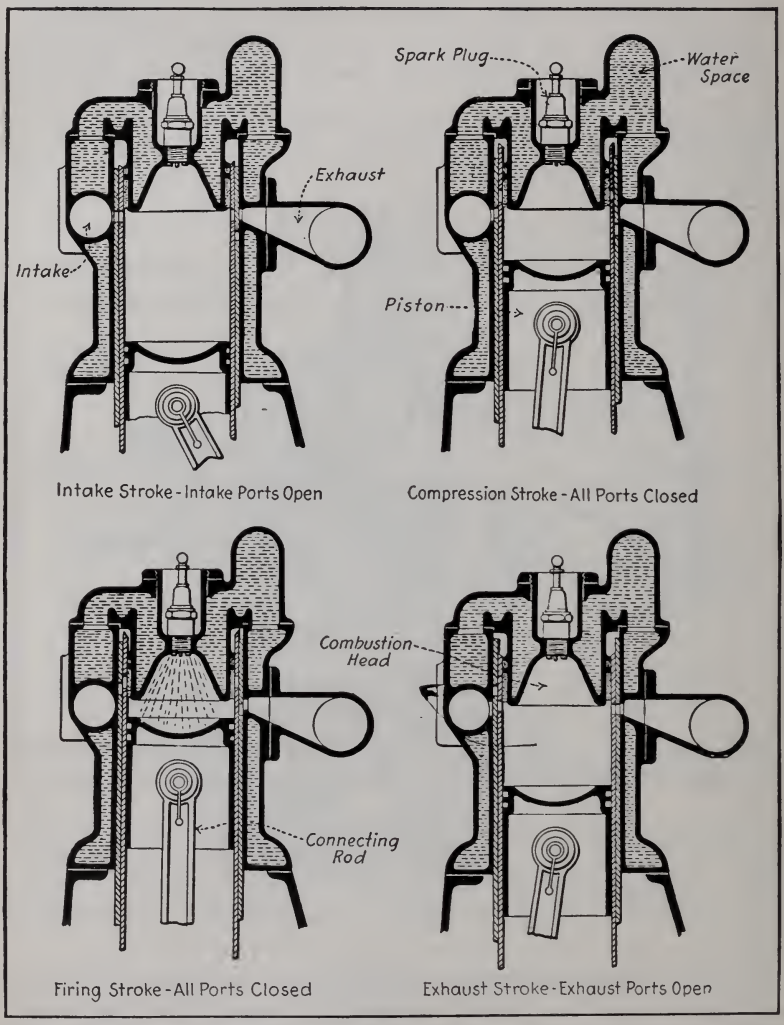


Fig. 103.—Diagrams Showing Action of Knight Sleeve Valves During the Different Strokes of the Engine Cycle.

and driven by silent chain gearing. The travel of the sleeves is comparatively small, as their velocity is but one-tenth that of the piston. The openings in the sleeves are so wide that the gases enter and leave the combustion chamber much more easily than they could through ports closed by valves of the conventional type.

The movement of the sleeves is such that the ports in the cylinder are closed by one or both sleeves during three-quarters of the cycle of operation, and are kept open during the remaining quarter by a simultaneous lining up of the openings in both sleeves with that in the cylinder. As is the case with a four-cycle motor of the conventional pattern during the first downstroke of the piston the inlet port is opened and the exhaust orifice closed. During the next two piston strokes, one up and the other down, corresponding to the compression and explosion of the gas, both ports are kept closed. Then during the last upstroke, which corresponds to the scavenging period, the exhaust port is opened and the inlet port closed.

It is claimed that this motor is very silent at high speeds, and it is more flexible in operation than other forms. It is also said that this type of motor will retain its compression longer than the poppet valve type, because there can be no escape of gas through the ports when they are closed by the sleeves. The moving members are lubricated in the usual manner, the only precaution taken being to insure an even distribution of oil by cutting a spiral groove and boring a number of holes in each sleeve. The great advantage of this type over the poppet valve motor can be very well shown by comparing the illustrations at Figs. 104 and 105, which show action of the valves used on the ordinary motor, with the views at Fig. 103. At Fig. 104, A, the position of the piston, crank shaft, cam, and intake valve are shown at the beginning of the charging stroke. It will be noticed that the intake valve has just barely left its seat and that there will be little space for the gases to flow into the cylinder until the piston has reached the position shown at Fig. 104, B, at which point the inlet valve is fully opened. From this point to that outlined at C the inlet valve closes and the gas passage becomes more and more restricted as the piston travels down. The same condition obtains when the exhaust valve is operated. It lifts gradually, and the full opening is not attained until the parts have assumed the position shown at Fig. 105, B. From this point to that outlined at C the valve is closing. It will be evident that with mushroom valves one attains the maximum port opening only during the time that the cam follower rides on the point of the cam, which is but an instant. The cam roller follows the cam profile only at low and moderate speeds. When the velocity increases the cam will throw the push rod instead of lifting it and the action will be erratic. Incidentally, these views show very clearly the method of valve operation and will prove valuable in assisting the reader to gain an idea of valve timing which will be discussed at length in proper sequence.

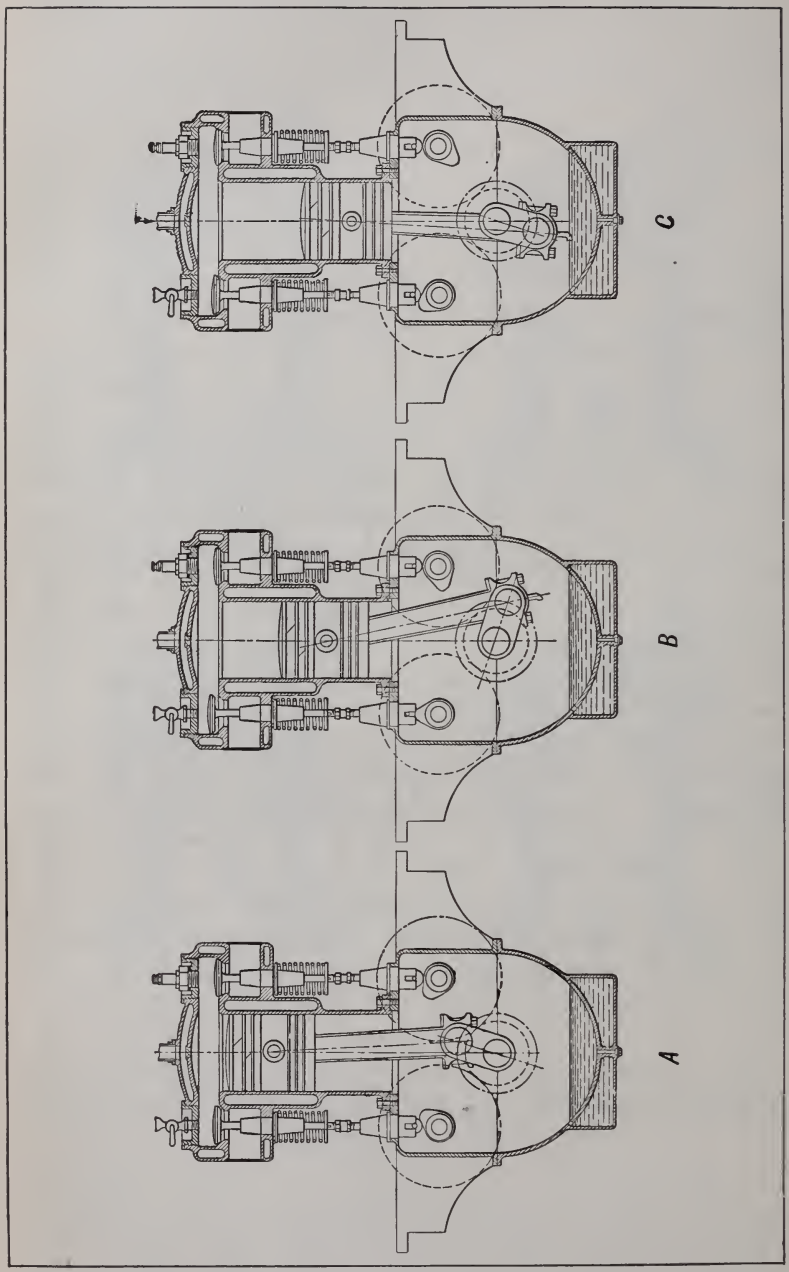


Fig. 104.—Showing Action of Inlet Valve and Cam of Conventional Engine Type. Note Gradual Valve Opening, which Does Not Attain Its Full Value for Some Time

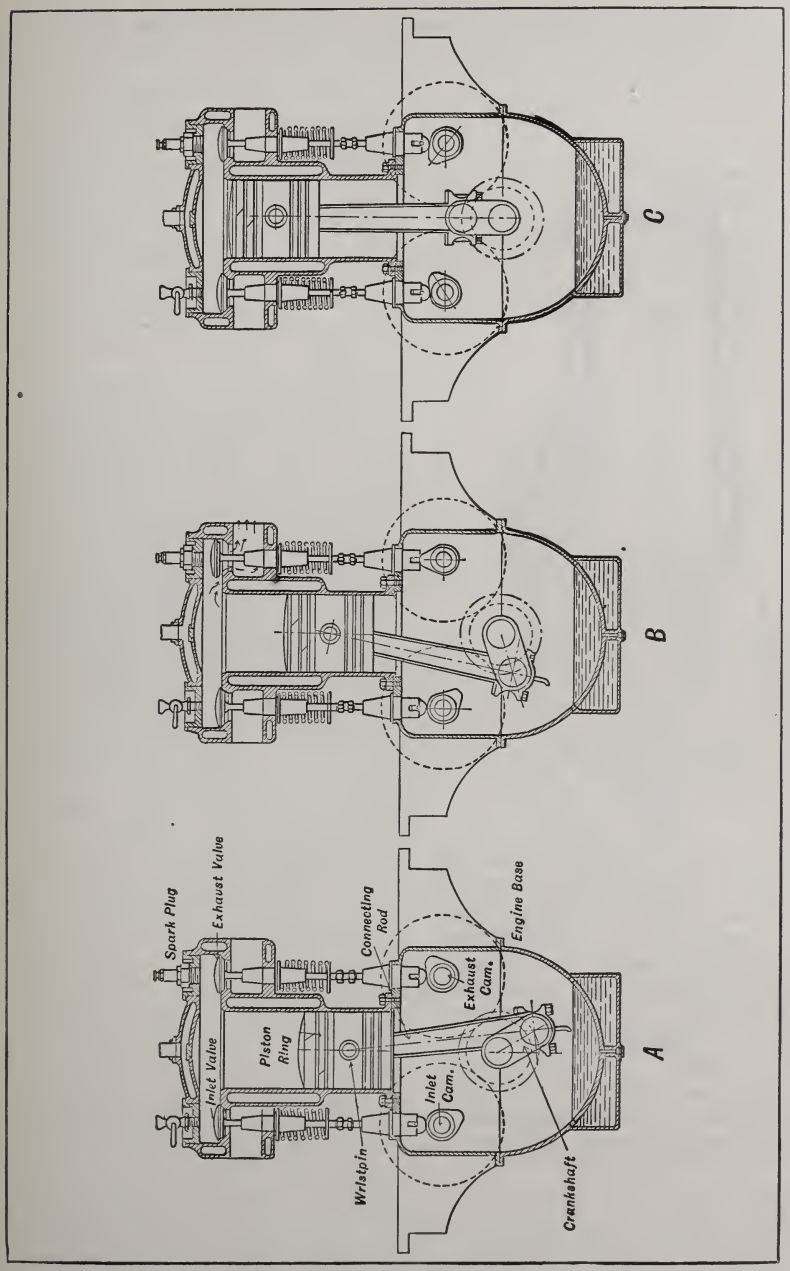


Fig. 105.—Showing Action of Exhaust Valve of Conventional Motor Type.

The view at Fig. 106 is a simplified section which shows the parts of the Knight type motor to advantage. In order to obtain uniform power application and a smooth running engine it is essential that the gases in each cylinder be compressed to the same value before ignition takes place. If the compression is less in one cylinder then that member will be doing less work than the others and the power output will not be constant. The crank shaft will slow up when it comes to the weak cylinder, and will accelerate when the three strong ones are acting on it. It is claimed that in the Knight motor the absolute constancy of compression makes for uniformity of action because the intervals between the successive explosions are always equal and all of the power strokes have the same strength. It is also advanced that the construction of the Knight motor makes it possible to obtain combustion chambers which are equal in volume, which condition is difficult to attain with the ordinary construction, because of the difficulty met in securing perfect equality of castings. As the cylinders and cylinder heads of the Knight motor are machined to the required dimensions and polished, all combustion chambers will have the same volume. Another advantage is that there will be no projecting particles of metal such as would be present in castings that might remain hot and cause premature explosions. It is also difficult for carbon to adhere to the absolutely smooth walls of the combustion chamber or piston head.

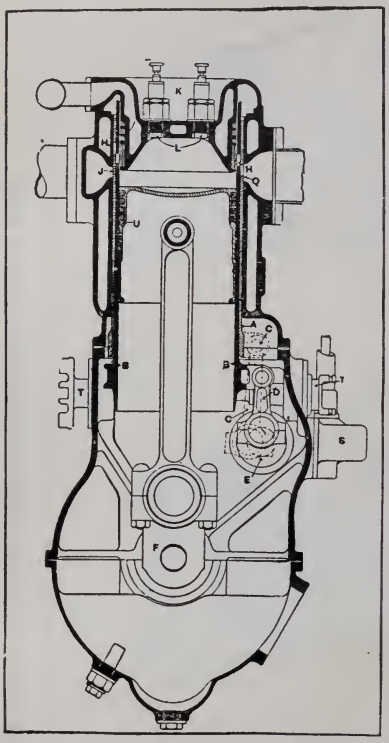


Fig. 106.—End Sectional View of Knight Sliding-Sleeve Type Motor, Showing Sleeves which Take Place of Poppet Valves of Conventional Motors. A—Outer Valve Sleeve. B—Inner Valve Sleeve. C—Operating Rod for A. D—Operating Lever for B. E—Eccentric Shaft. F—Crank Shaft. H—Valve Opening. K—Cylinder Head. L—Sparking Plug Holes. O—Cross-Shaft Driving Pump and Magneto. U—Piston.

There is very little strain on the parts, and as the wear of the

sleeves is negligible the motor action improves with service, because the sleeves become polished and work easier the more they are used. As the sleeves are driven by cranks and connecting rods and not by cams as poppet valves are, they are not liable to go wild at even the highest motor speeds. The ports are opened and closed exactly at the proper time, and the openings or passages for the gas are so large that the motor capacity augments with an increase of speed. The Knight motor has been built in four, six and eight cylinder types. An eight cylinder V engine of this construction is shown at Fig. 107.

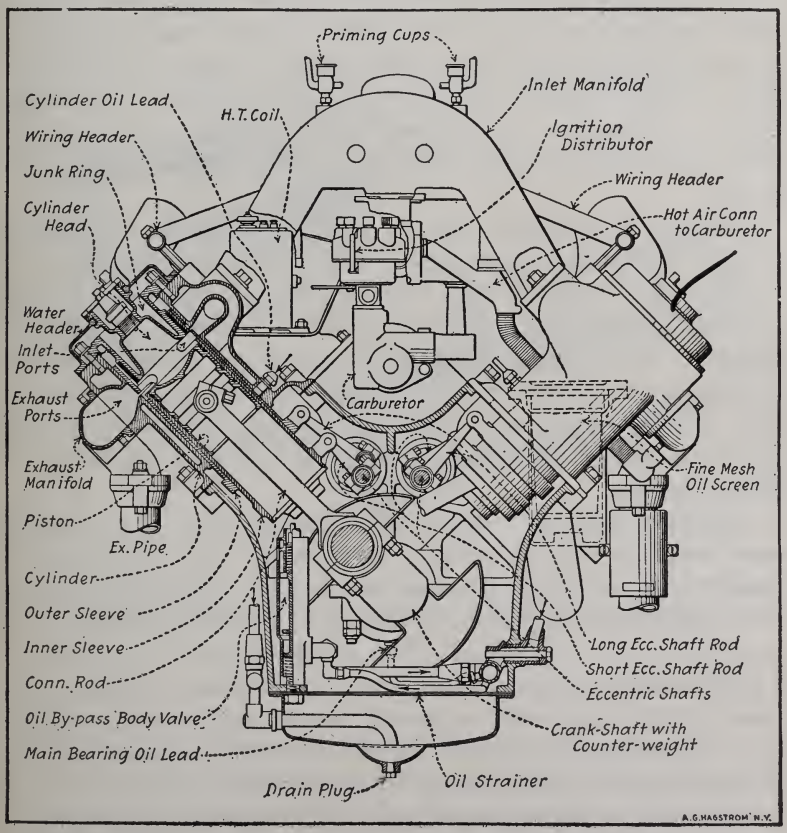


Fig. 107.—Part Sectional View of the Stearns-Knight Eight-Cylinder Engine.

In a comparative test of two similar motors, one with mushroom valves and the other with sleeves, the former developed but twenty-five horse power at 2,000 revolutions per minute, while the sleeve type generated in excess of thirty horse power under the same conditions. The Knight motor has been subjected to severe tests before

adoption in comparison with motors of the poppet valve type. In one of these an engine rated at thirty-eight horse power which had cylinders of 5-inch bore and stroke developed 55.3 horse power continuously during a period of 5½ days, or 132 hours. The fuel consumption was but 0.85 pint of gasoline per horse power hour. The average fuel consumption of the four-cycle type of motor is placed at one pint per horse power hour. At the completion of this running in test the power plant was installed in a car weighing 4,000 pounds. This was driven over 2,000 miles on Brooklands Motor Track, near London, England, at a speed which averaged forty-three miles per hour. At the completion of this test the motor was replaced on a test stand in the shop, where it developed an average of 57.25 horse power during a run of five hours at 1,200 revolutions per minute. The fuel consumption was reduced to 0.75 pint of gasoline per horse power hour and it had gained two horse power, or about four per cent by use.

This type of valveless motor is considered to be an improvement over the conventional forms, and it is all the more strange when one considers that the height of its development has been reached at a time when all believed the explosion motor had attained its maximum efficiency. The success attending the use of the Knight motor has promoted great interest in all forms of valveless motors, which are being actively experimented with at the present time. Some of the most successful of these types will be described in detail in the following chapters.

The Eight Cylinder V Motor.—The announcement of a prominent motor-car maker in the late fall of 1914 that he was to market an eight cylinder motor vehicle in 1915 created a furor in the automobile trade. This type of motor appealed strongly to the motorist as well as to the manufacturer, as is evidenced by the announcement of the production of eight cylinder models by more than a dozen makers. That manufacturers of engines anticipate a general demand for eight cylinder types can be judged by the fact that all of the leading engine builders are developing eight cylinder engines. Those who have followed the development of the gasoline engine will recall the arguments that were made when the six cylinder motor was introduced at a time that the four cylinder type was considered standard. The arrival of the eight cylinder has created similar discussion of its practicability.

The eight cylinder V type engine is not a new design by any means, although it is not generally known to automobilists. It has been a standard power plant for aeroplanes for many years, leading exponents being the Antoinette, the Woolsley, the E. N. V. in Europe and the

Curtiss in the United States. Messrs. De Dion-Bouton, a leading French automobile manufacturer, is credited with being the first to produce an eight cylinder motor as a commercial proposition. Many racing cars have been built with eight cylinder motors, notably the Rolls-Royce, the Darracq and Winton. The eight cylinder V type has also been widely used in racing motor boats and gasoline propelled railway coaches. It was not a surprise, therefore, to those who were familiar with internal combustion engineering when the eight cylinder engine was applied for automobile propulsion.

The reason the V type shown at Fig. 108-A is favored is that the "all-in-line form" which is shown below it is not practical for

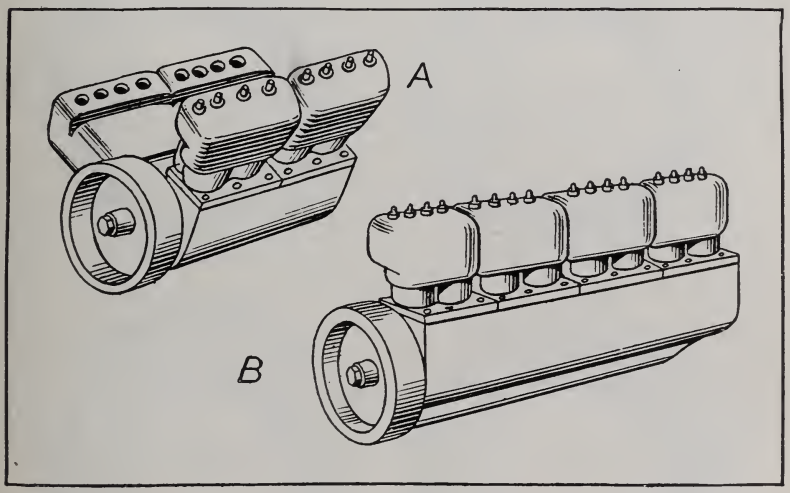


Fig. 108.—Types of Eight-Cylinder Engines, Showing Advantage of the V Method of Cylinder Placing in Securing Short and More Compact Engine.

motor vehicles because of its length. Compared to the standard four cylinder engine it is nearly twice as long and it required a much stronger and longer crank shaft. It will be evident that it could not be located to advantage in the automobile frame. These undesirable factors are eliminated in the V type eight cylinder motor, as it consists of two blocks of four cylinders each, so arranged that one set or block is at an angle of forty-five degrees from the vertical center line of the motor, or at an angle of ninety degrees with the other set. This arrangement of cylinders produces a motor that is no longer than a four cylinder engine of half the power would be.

Apparently there is considerable misconception as to the advantage of the two extra cylinders of the eight as compared with the six

cylinder. It should be borne in mind that the multiplication in the number of cylinders noticed since the early days of automobile development has not been for solely increasing the power of the engine, but to secure a more even turning movement, greater flexibility and to eliminate destructive vibration. The ideal internal combustion motor would be that which more nearly conforms to the steady running produced by a steam turbine or electric motor. The advocates of the eight cylinder engine bring up the item of uniform torque as one of the most important advantages of the eight cylinder design. A number of torque diagrams are shown at Figs. 109 and 110. While these

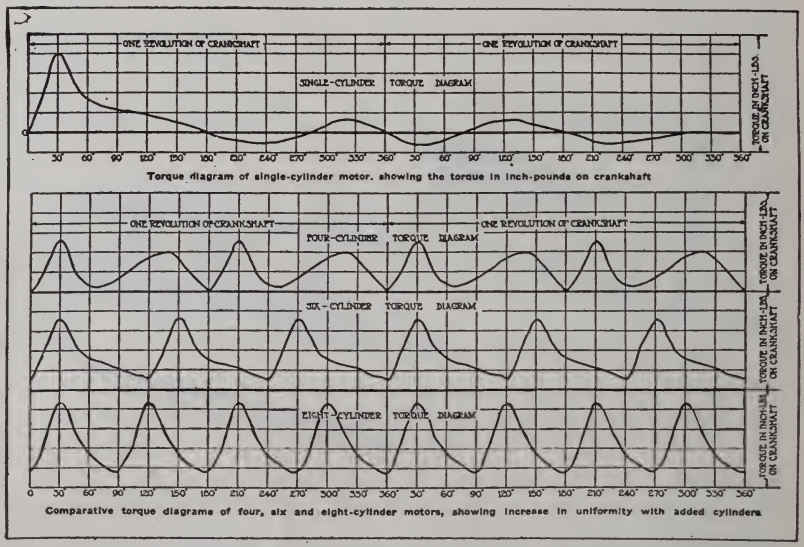

ONE REVOLUTION OF CRANKSHAFT
SINGLE-CYLINDER TORQUE DIAGRAM
TORQUE IN INCH-LBS ON CRANKSHAFT
Torque diagram of single-cylinder motor, showing the torque in inch-pounds on crankshaft
FOUR-CYLINDER TORQUE DIAGRAM
SIX-CYLINDER TORQUE DIAGRAM
EIGHT-CYLINDER TORQUE DIAGRAM
Comparative torque diagrams of four, six and eight-cylinder motors, showing increase in uniformity with added cylinders

Fig. 109.—Curves Showing Torque of Various Engine Types Demonstrate Graphically the Marked Advantage of the Eight-Cylinder Form.

appear to be deeply technical, they may be very easily followed when their purpose is explained. At the top of Fig. 109 is shown the torque diagram of a single cylinder motor of the four-cycle type. The high point in the line represents the period of greatest torque or power generation, and it will be evident that this occurs early in the first revolution of the crank shaft. Below this diagram is shown a similar curve, except that it is produced by a four-cylinder engine. Inspection will show that the turning moment is much more uniform than in the single cylinder; similarly, the six-cylinder diagram is an improvement over the four, and the eight-cylinder diagram is an improvement over the six-cylinder.

The reason that practically continuous torque is obtained in an

eight cylinder engine is that one cylinder fires every ninety degrees of crank shaft rotation, and as each impulse lasts nearly seventy-five per cent. of the stroke, one can easily appreciate that an engine that will give four explosions per revolution of the crank shaft will run more uniform than one that gives but three explosions per revolution, as the six cylinder does, and will be twice as smooth running as a four cylinder, in which but two explosions occur per revolution of the crank

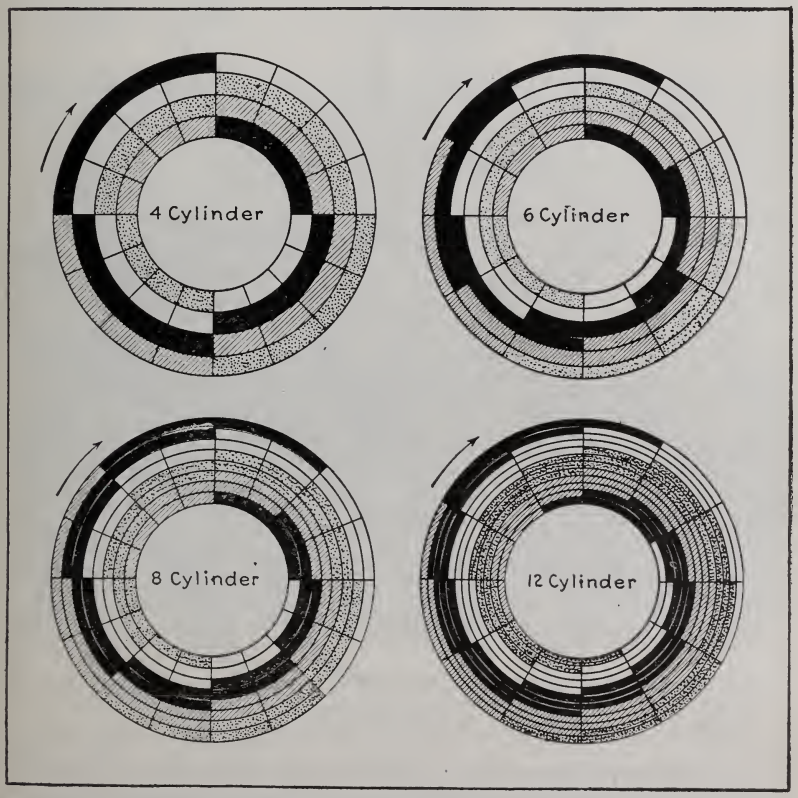


Fig. 110.—Diagrams Showing Power Strokes of Four, Six, Eight and Twelve Cylinder Engines Show More Uniform Power Application with Augmenting Cylinder Numbers.

shaft. The comparison is so clearly shown in the graphical diagrams that further description is unnecessary.

The front view of a typical eight cylinder engine with the cover removed from the timing gear case is outlined at Fig. 111. In this engine the cylinders are cast in blocks of four and are of the L head type, the valves being on the inside of the cylinder block facing those

of the other cylinders. This makes it possible to operate the valves by one cam shaft, driven by silent chain gearing from the pinion on the crank shaft. There is ample space between the two cylinder blocks to mount the carburetor, ignition distributor and other parts. The method of installing the eight cylinder motor in the Cadillac auto-

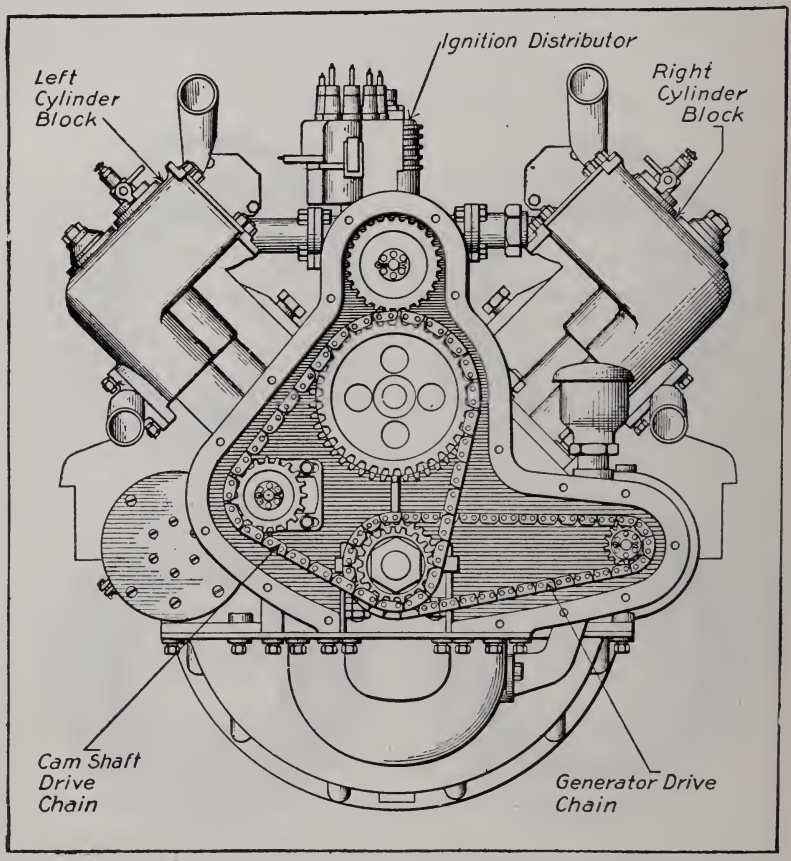


Fig. 111.—Front View of King Eight-Cylinder V Engine with Cover Removed from Timing-Gear Case to Show Use of Silent Chains for Driving Cam Shaft and Auxiliary Devices.

mobile frame is clearly shown at Fig. 112. The only points in which an eight cylinder motor differs from a four cylinder is in the arrangement of the connecting rod, as in many designs it is necessary to have two rods working from the same crank pin. This difficulty is easily overcome in some designs by staggering the cylinders and having the two connecting rod big ends of conventional form side by side on a com-

mon crank pin. In other designs one rod is a forked form and works on the outside of a rod of the regular pattern. Still another method is to have a boss just above the main bearing on one connecting rod to which the lower portion of the connecting rod in the opposite cylinder is hinged. A very popular eight-cylinder engine is shown in longitudinal section at Fig. 113.

As the eight cylinder engine may actually be made lighter than the six cylinder of equal power, it is possible to use smaller reciprocating parts, such as pistons, connecting rods and valve gear, and obtain

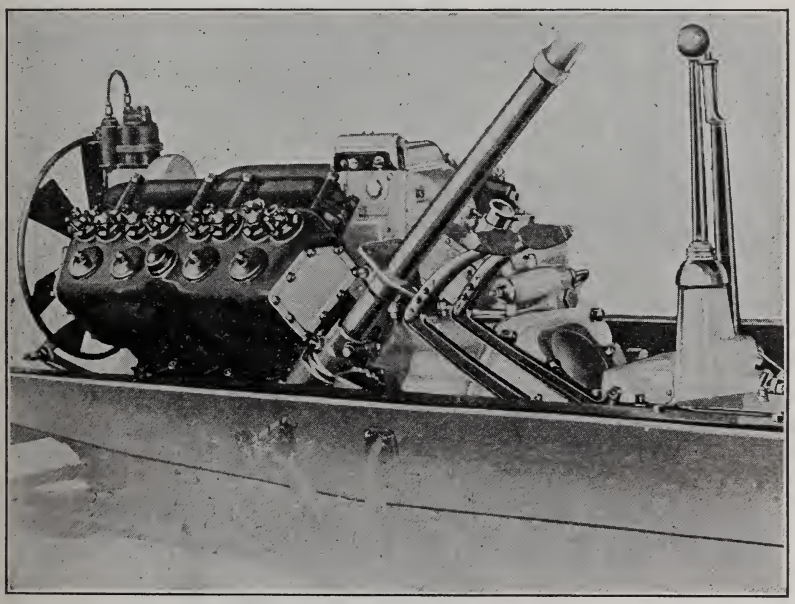


Fig. 112.—Method of Installing Cadillac Eight Cylinder in Motor Car Frame.

higher engine speed with practically no vibration. The firing order in nearly every case is the same as in a four cylinder except that the explosions occur alternately in each set of cylinders. In prevailing practice the sequence is 1-3-4-2. The firing order of an eight cylinder motor is apt to be confusing to the motorist, especially if one considers that there are eight possible sequences. The majority of engineers favor the alternate firing from side to side. This is given by several manufacturers as follows: 1-4-5-2-7-6-3-8. Another firing order, 1-8-3-6-4-5-2-7; still another, 1-6-3-5-4-7-2-8. Some makers call the left front cylinder, or that nearest the radiator, No. 1, and the opposite cylinder the No. 8. No difficulty is experienced in an eight cylinder engine either in carburetion or in firing the charge. In six cylinder en-

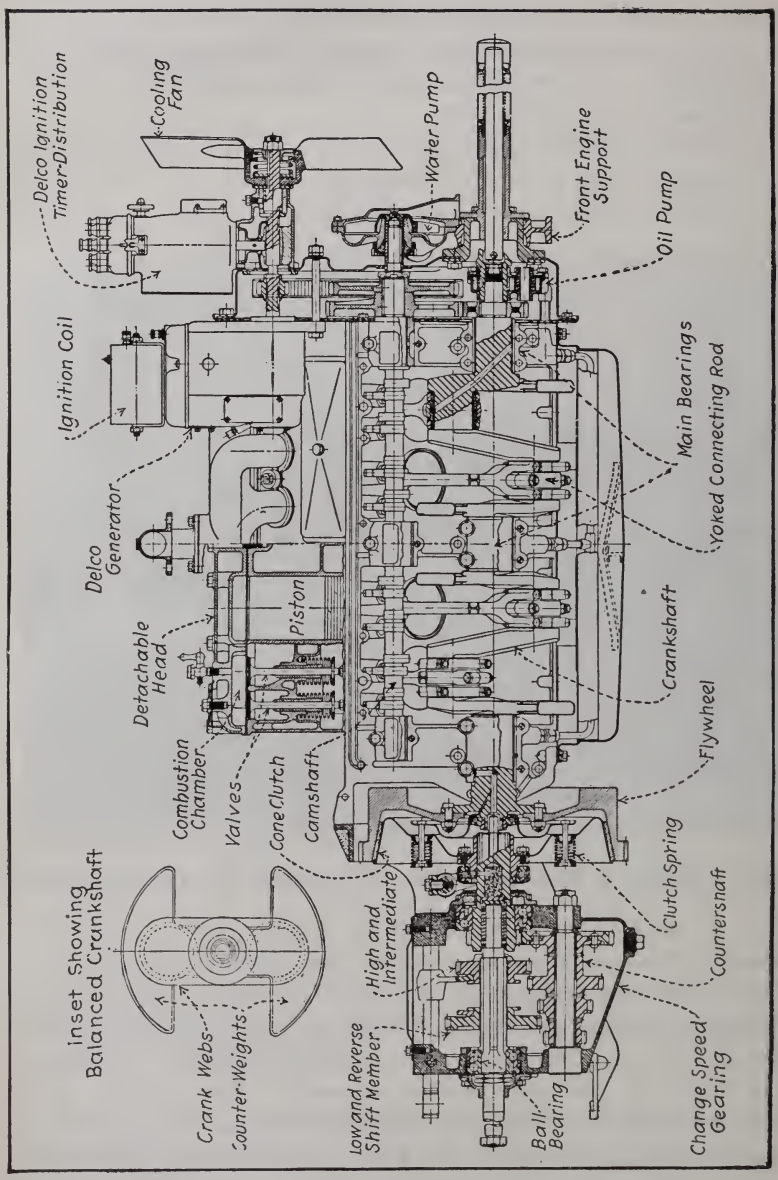


Fig. 113.—Part Sectional View of Eight Sectional Cole-Northway Engine

gines some difficulty is apt to be experienced in securing proper carburetor action, but in an eight the problem is as simple as in the four cylinder engine.

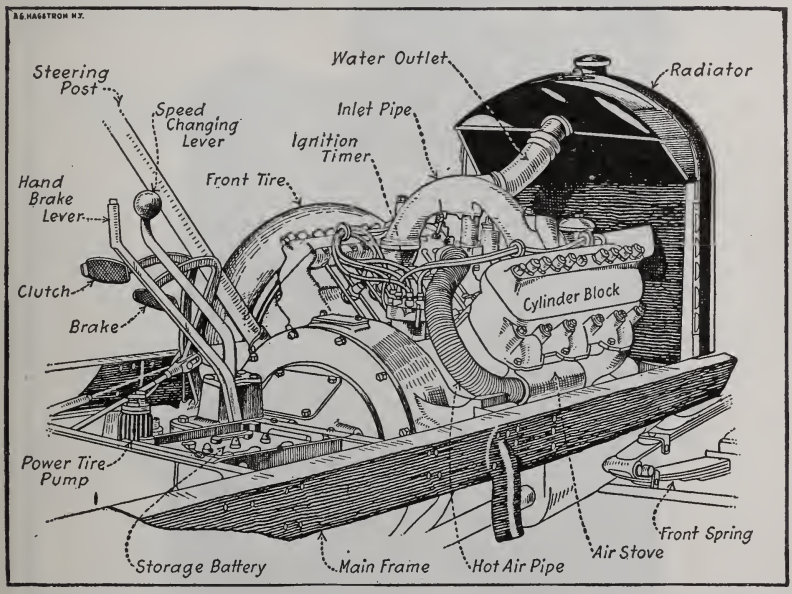


Fig. 114.—Showing Installation of Eight-Cylinder Engine in 1917 Jackson Chassis.

Packard Twelve-Cylinder Engine.—One of the first makers to announce a twelve-cylinder car for the 1916 season was the Packard Motor Car Company, of Detroit, Mich., which is building a high-speed motor incorporating all recent features of design in securing light reciprocating parts, large valve openings, etc. The twelve-cylinder motor shown at Fig. 115 incorporates the best features of high-speed motor design and there is no need at this time to discuss further the pros and cons of the twelve-cylinder versus the eight or six, because it is conceded by all that there is the same degree of increase of steady power application in the twelve over the eight as there would be in the eight over the six. The question resolves itself into having a motor of high power that will run with minimum vibration and that produces smooth action. It should be remembered that if an eight-cylinder engine will give four explosions per revolution of the fly wheel, a twelve-cylinder type will give six explosions per revolution, and instead of the impulses coming 90 degrees crank travel apart, as in the case of the eight-cylinder, these will come but 60 degrees of crank travel

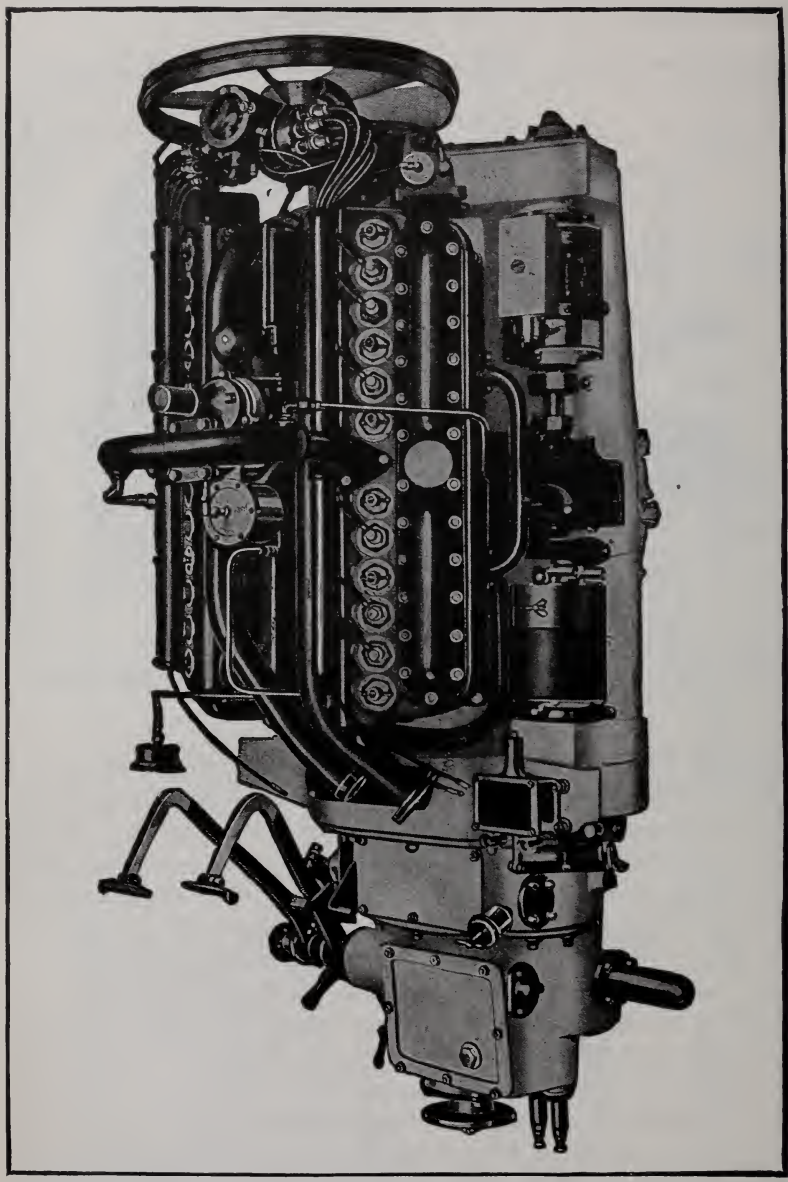


Fig. 115.—Top View of Packard Twin-Six Motor, to Show Carburetor Accessibility and Other Power Plant Auxiliaries.

apart in the case of the twelve-cylinder. When one realizes that the actual duration of the power stroke is considerably greater than 140 degrees crank travel, it will be apparent that the overlapping of explosions must deliver a very uniform application of power.

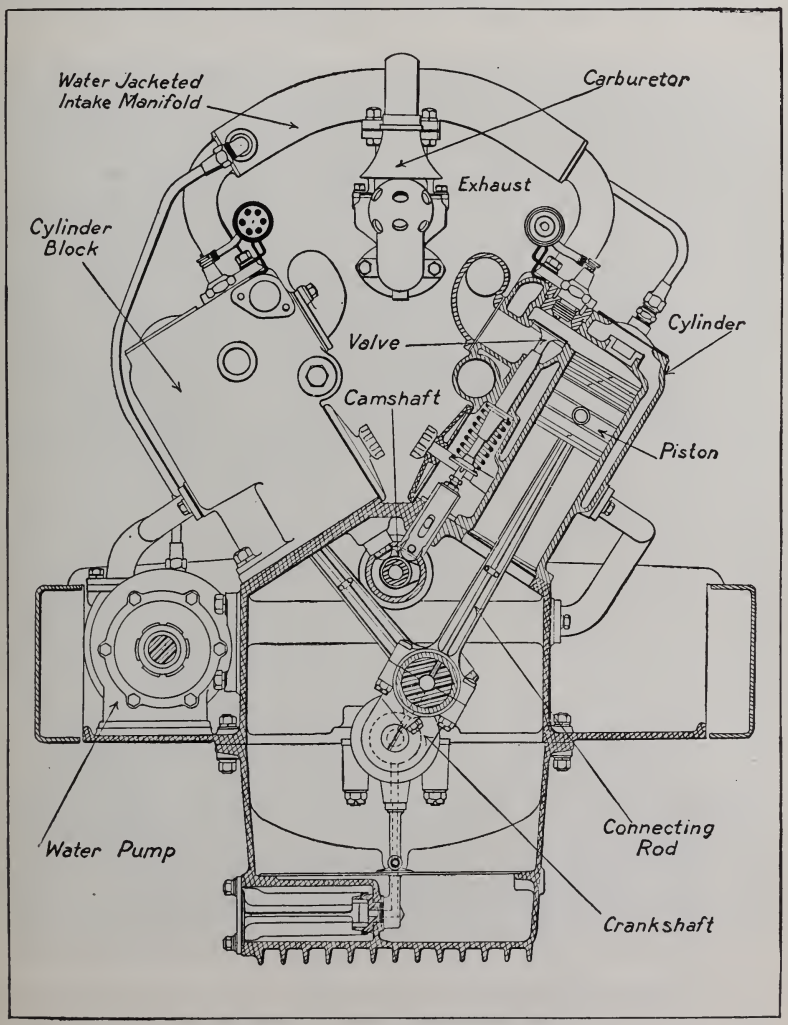


Fig. 116.—Sectional View Through End Section of Packard Twin-Six Motor, Showing Arrangement of Parts and Narrow Motor Made Possible by 60 Degree Cylinder Placing.

The dimensions of the new Packard motor are 3″ bore by 5″ stroke, giving a total piston displacement of 424 cubic inches. The motor will attain a speed of 3,000 R.P.M., or more if necessary,

although the multiplicity of explosions produces so much power at the low motor speeds that the high range of speed will be needed only when extreme conditions are encountered. The pistons are of aluminum alloy and the connecting rods are machined all over in order to have small reciprocating weight. The piston weighs but 17 ounces

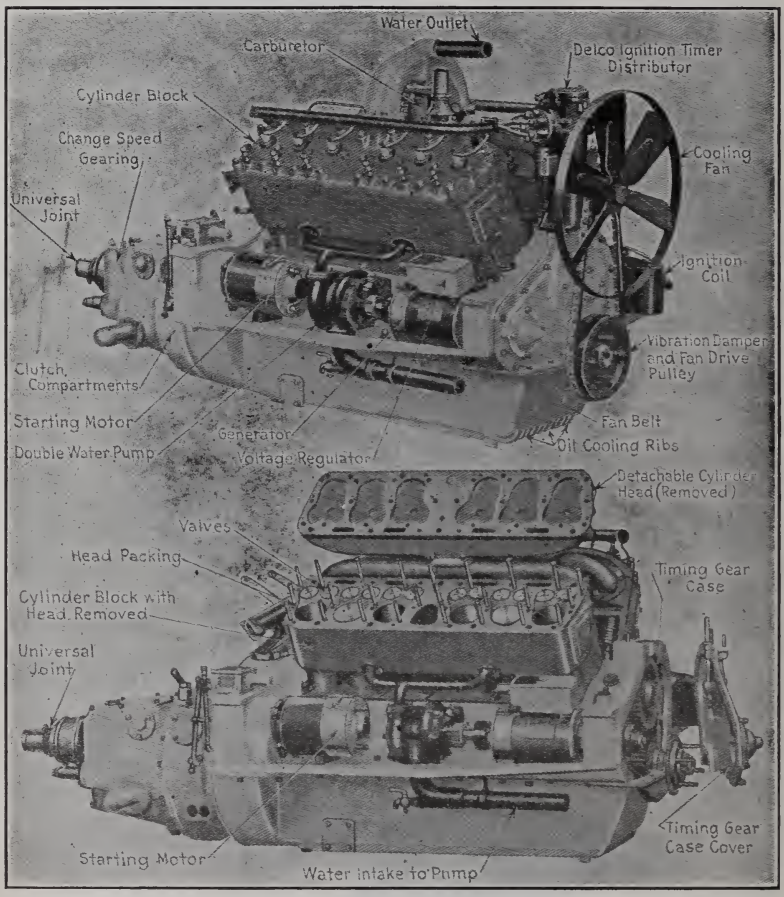


Fig. 117.—Views of the Packard Twin-Six Power Plant for 1917, Showing the New Detachable Head Construction

complete with rings, and the upper half of the connecting rod, which is considered a reciprocating mass, weighs but 8.5 ounces, this making a very small total mass of 1 pound 9.5 ounces. Knowing that the vibration which is present in the six-cylinder is due to the weight of pistons, etc., it will be apparent that if this weight is lessened, as it is

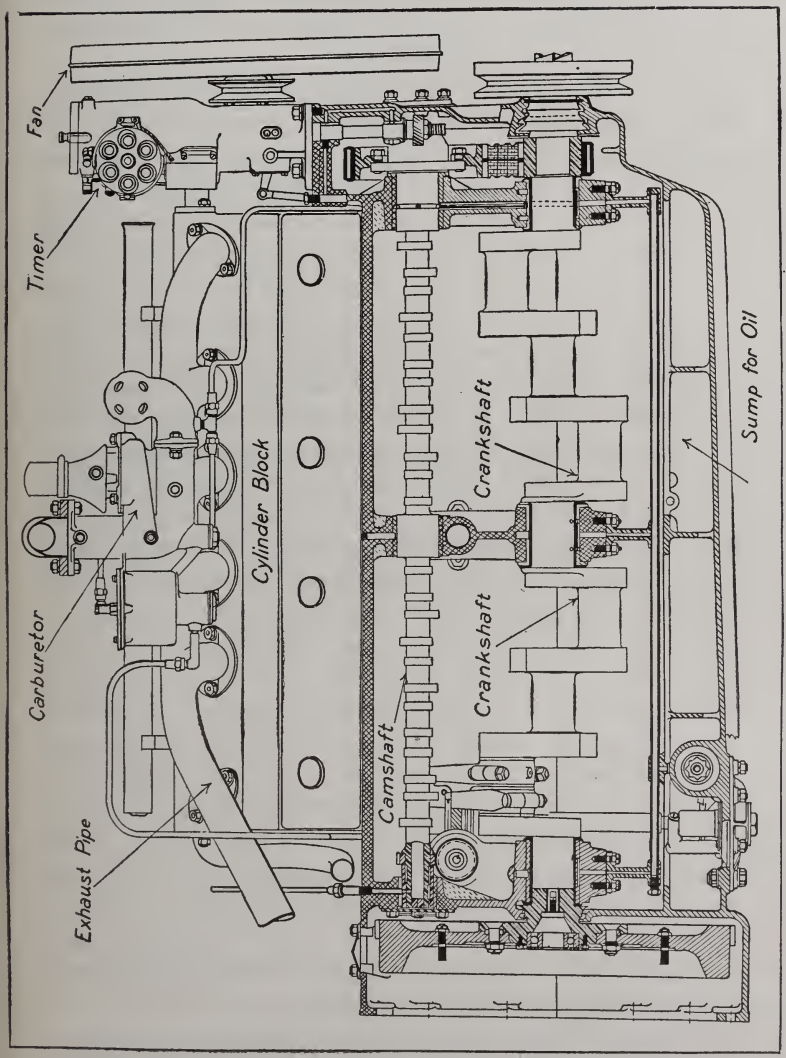


Fig. 118.—Longitudinal Section Through Packard Twin-Six Motor, Depicting Three-Bearing Crankshaft, Method of Attaching the Connecting Rods Side by Side on the Crank Pins, Oilways for Bearings and Camshaft with Twenty-four Integral Cams.

in the "Twin Six" design, a much smoother running motor will be obtained. One may say that the twelve-cylinder is an attempt to combine the advantages of the six and eight and to simultaneously eliminate some of the disadvantages of both types. While this is true to only a limited extent, it is apparent that for very powerful engines the twelve-cylinder will have a logical field.

The Packard motor, as the 1917 design illustrated at Fig. 117 shows, has two block castings consisting of six cylinders each, set on an aluminum crank case with the cylinder center lines 30 degrees each side of the vertical motor center line, which gives an included angle of 60 degrees between the two cylinder center lines. This arrangement gives the best torque, which is obtained with even intervals between the explosions. The valves are placed between the cylinders in the ordinary "L" fashion, but they are more accessible than in the eight-cylinder because the narrowness or reduction of width possible by the 60-degree placing of the cylinders allows the generator, starting motor, water pump and other attachments to be mounted alongside of the engine crank case just as in the ordinary four-cylinder engine. This clears the valves of all obstructions and the carburetor is placed high enough to be easily reached itself. Ignition is by battery and coil, two timer-distributors being used, one for each block of six cylinders. The latest designs have detachable cylinder heads to facilitate valve grinding and removal of carbon deposits.

In a recent test, the Packard motor used but one gallon to eleven miles, which is very good mileage for an engine of that horse power. To allow the motor to be used at continued high speed, a high-pressure oiling system is essential. The oil is carried up from the crank pins to the piston pins by pipes lying inside of the channel of the "H" section of the connecting rods. There are but three main crankshaft bearings, this being considered sufficient for the short length of the crankshaft. Besides the crankshaft and piston pin leads oil under pressure is distributed to the camshaft, generator shaft, air and oil-pump shafts and the timer shaft. Overflow from the generator shaft cares for the silent chain at the front which drives the camshaft and auxiliary units placed at the side of the motor.

It is stated that the marked advantages of the motor using twelve cylinders is found in actual road operation, where it is possible to run the car at a walking pace on the high gear and it is also possible to accelerate from this low speed to a speed of 30 miles per hour in twelve seconds on a level cement road on the high speed ratio. The car will attain a road speed of over 60 miles per hour with no perceptible motor vibration. A National twelve-cylinder engine will also

be offered in 1917, and several other makers of high-powered cars are offering cars with this type of engine.

Operating Principles of Two-Cycle Engines.—While the majority of automobiles always use four-cycle internal combustion engines for propulsion there are rare cases where the simpler two-stroke cycle motor has been used. Though it has been widely used in marine applications for years it has not become popular in motor-car service. If considered from a theoretical point of view the two-cycle engine has important advantages, and if ideal conditions were obtained in practice, motors of this type would develop twice the amount of power obtainable from four-cycle engines having the same number of cylinders, equal piston displacement and operating at the same crank shaft speed.

The two-cycle motor is much simpler than the other forms, and it has but three moving parts per cylinder. In this type a power impulse is obtained with each downstroke of the piston instead of every other downstroke. With the explosion occurring twice as often the energy delivered is increased in direct proportion and a more even turning movement of the crank shaft results because of the more rapid series of explosions. It has been shown that with the four-stroke engine three operations are necessary to obtain a useful power impulse. The first downward movement of the piston draws in the gas. The following upward movement compresses the mixture. The second down movement of the piston takes place during the expansion or explosion stroke, and is the third and power-producing part of the cycle. Following this operation the remaining stroke of the piston, which is upward, clears the cylinder of burned gas.

Obviously all the work is done at the top of the piston, and the differing functions take place in the combustion chamber or that portion of the cylinder above the piston. With a two-cycle engine all this work can be accomplished in half the number of strokes, and it is possible to secure an explosion stroke after each idle stroke. There is a power impulse every revolution of the crank shaft for each cylinder instead of every two turns, and energy is created every two strokes of the piston. To accomplish this, work is performed on both sides of the piston, as the crank case is utilized as well as the part of the cylinder above the piston. The top of this member compresses the charge and receives the pressure of the explosion, as these two essential functions can only take place in that portion of the cylinder above the piston. The crank case performs the duty of the inspiration stroke, as the mixture is drawn into the engine base by the upwardly moving piston. This is done at the same time that the piston is mov-

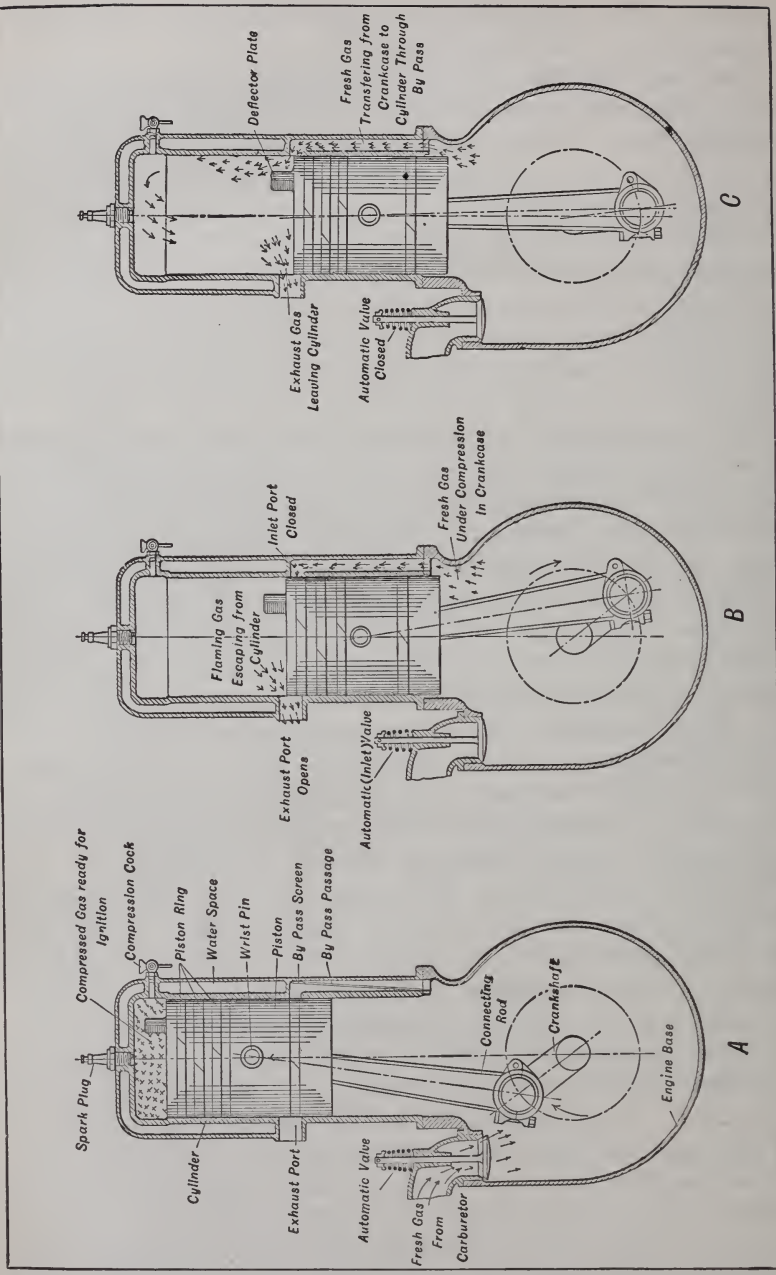


Fig. 119.—Defining Two-Port, Two-Cycle Engine Action.

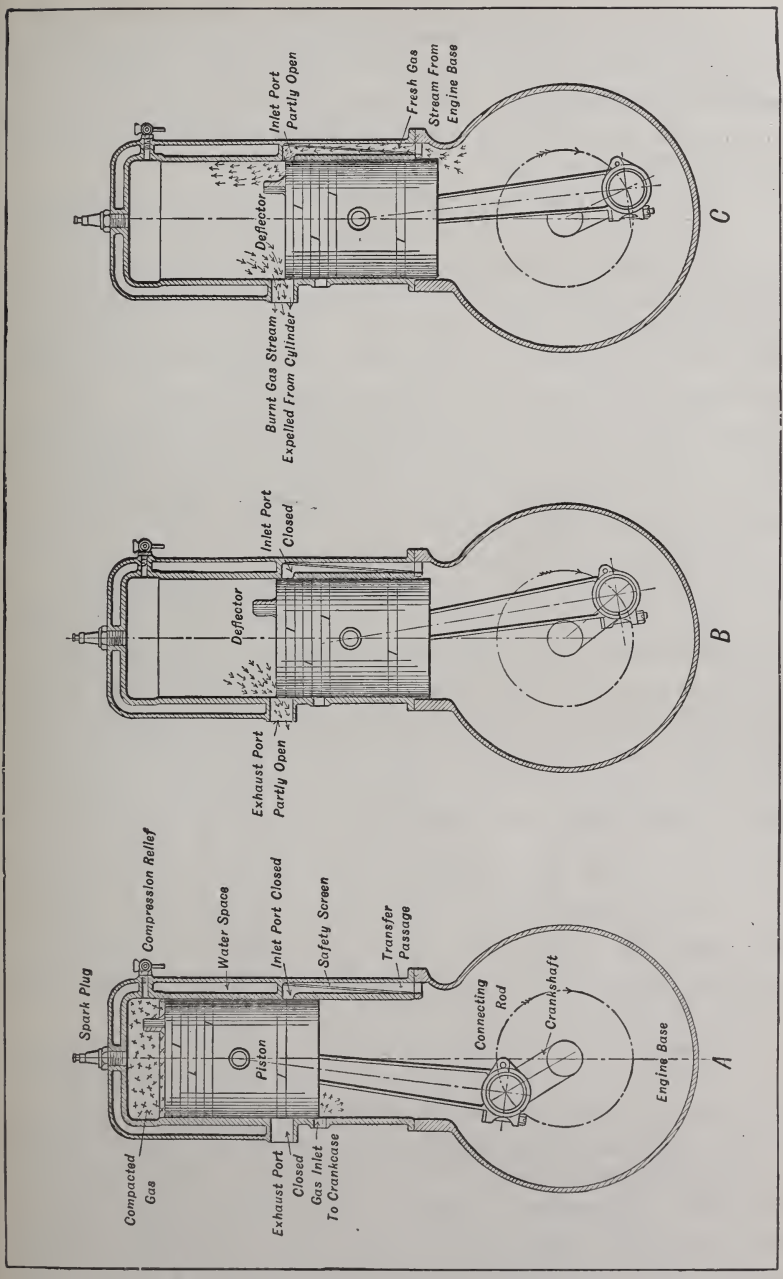


Fig. 120.—Showing Three-Port, Two-Cycle Engine Operation.

ing up to compress the gas above it, previously taken in. The views at Fig. 119 show the principles of operation of two-port, two-cycle engines, while those at Fig. 120 define the fundamentals of three-port two-cycle engine operation. The principle in the main is the same for both types, the only difference being in the method of introducing the gas to the crank case.

It will be seen that such engines are very simple, and that the pistons, connecting rods, and crank shaft are the only moving parts. Instead of valves and operating mechanism to control the gas flow by ports, or passages which are cast in the cylinder walls about halfway down their length are used. The gas is taken into the engine base, which is air tight, and of small capacity; in one case through an automatic check valve fitting to which the carburetor is attached. In the three-port form this valve is eliminated and the carburetor is coupled directly to the cylinder. The gas is transferred from the crank case to the cylinder through a bypass, or a passage leading from the engine base to the intake port.

Considering first the action of the two-port, two-cycle type it will be evident that if the base is air tight an upward movement of the piston will produce a suction in the engine base, drawing the inlet valve down from its seat and inspiring a mixture of gasoline and air from the carburetor. Thus when the piston moves up, the engine base fills with vapor. On the down movement of the piston the gas in the crank case is compressed, and when the top of the piston registers with the inlet port in the side of the cylinder the mixture will transfer to the cylinder above the piston because of its pressure. The intake port is opened as the piston side uncovers it. The compression in the engine base is light compared to that above the piston. While the compression pressure before ignition may be as high as eighty pounds per square inch, that in the engine base necessary to insure prompt transfer of the charge seldom exceeds ten pounds. The operation of this type engine is not difficult to understand.

Referring to Fig. 119, A, we will assume that there is a compressed charge of gas above the top of the piston, and that the crank case is full of mixture. The spark occurs at the spark plug and the resulting explosion forces the piston down on its power stroke, this movement also compressing the gas already in the engine base. When the piston uncovers the exhaust port it begins to open before the intake port is uncovered and the burned gases escape to the air because of their pressure. After the exhaust port has been open for a small period the inlet port is uncovered by the piston which is still on its downward movement. The compressed gas in the case flows through the bypass

and into the cylinder. It cannot escape out of the open exhaust port opposite, because the deflector directs the gases toward the top of the cylinder. The fresh gas coming in tends to force out any of the burned residue which tends to remain. As the piston rises on the return stroke both ports are closed and the gas in the cylinder is compressed. Simultaneously with the gas compression the partial vacuum created in the engine base draws in new mixture from the carburetor through the open check valve.

Three-port engine operation, as shown at Fig. 120, is very similar to that previously described, except that the intake port in the cylinder to which the carburetor is coupled is uncovered by the piston only when it has traveled up in the cylinder. There is a pronounced vacuum in the crank case when this port is uncovered and the rapid rush of gas insures quick charging. The three-port engine is considerably faster than the two-port type, and is more popular for motor-car service. In the three-port form of engine the mixture rushes in to fill the engine base as a body, whereas in the two-port type it is drawn in gradually during the whole upstroke of the piston.

If the reader compares the views of the simple two-cycle engines shown with the four-cycle types previously described, it will be seen that the former are simpler, because many of the small parts necessary for the successful action of a four-stroke motor are not needed in the two-stroke motor. The valves and operating mechanism are dispensed with, which means elimination of the cam shafts, driving gearing, cams, and push rods, incidental to valve operation. As the cylinder of the two-cycle engine is charged and cleaned through simple ports which are but orifices left after cutting away part of the cylinder wall, the gas can be introduced and discharged with much less mechanism. The ports are covered by the piston until the time comes when they are needed. In the two-port form both openings are opened fully only when the piston reaches the end of the downstroke, but in the three-port motor the remaining opening through which the crank case is charged is uncovered when the piston reaches the end of its upward movement.

The simple forms of two-cycle motors described have been replaced in some cases by types in which the preliminary compression of gas in the crank case has been eliminated. This is accomplished by the use of a two-diameter piston, as shown at Fig. 121. The cylinder proper consists of an upper and lower chamber. The small portion of the piston fits the upper cylinder while the enlarged part fits the lower end. Instead of the gas being inspired into the engine base it is drawn into the enlarged portion of the cylinder. It has been diffi-

cult to maintain regularity of two-cycle motor action when crank case compression was used, because any leakage at the bearings, or packings in the crank case, meant a reduction in vacuum and made for uncertain charging.

With the construction outlined at Fig. 121, the gas is taken into the large portion of the main cylinder, and as the pumping piston is provided with packing rings just as the working piston is, it is not difficult to keep a tight charging chamber. The positions of the pistons in the various cylinders of a four-cylinder motor using a differential piston arrangement are shown at Fig. 121. It will be seen that a rotary distributing valve must be used to permit the gas to enter the pump cylinder and flow into the working cylinder at the right time; this is turned by gearing from the crank shaft.

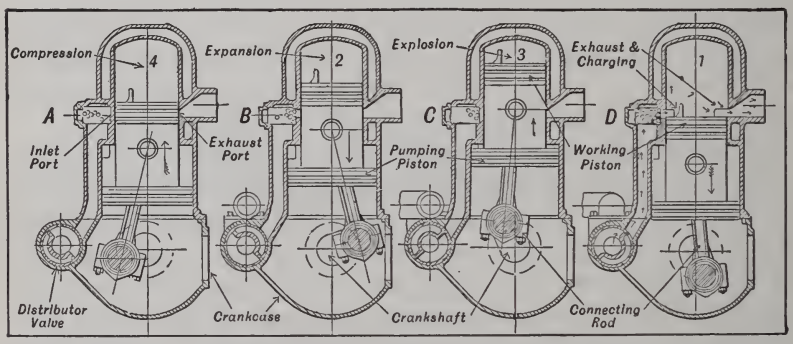


Fig. 121.—Explaining Action of Differential Piston Type of Two-Cycle Engines.

At A the piston is going up and a charge of gas is being compressed in both the working cylinder and the pump cylinder. At B, which represents the section through cylinder No. 2, the piston is moving down under the influence of the explosion and the pumping piston is drawing in a charge of gas through the distributing valve which is in communication with the inlet pipe. At C a section through cylinder No. 3 is shown. The working piston in this case has reached the top of its stroke and is ready to receive the impact due to the explosion of the charge. At D a section through cylinder No. 1 is outlined. The distribution valve has made communication with the pumping chamber of cylinder No. 3, as shown at C, and a charge of gas is being transferred to the working cylinder No. 1. The burned gases are expelled through the open exhaust port in the usual manner and admitted by the customary intake port adjacent to the deflector plate. The action in this type of engine may be easily un-

derstood if one considers that the pumping chamber of one cylinder is employed to draw in gas and compress it prior to transferring it to the working chamber of another cylinder.

Why Two-Cycle Motor is Not Used in Automobiles.—It has been previously stated that the four-cycle motor is almost universally used, and to properly understand the reason for the preponderance of this type over the simpler two-cycle forms it is necessary to compare the actual results obtained from the two-stroke motor in ordinary practice with the advantages a purely theoretical consideration will give it. There are a number of problems to be solved before the two-cycle motor will compare with the other type in efficiency. To obtain maximum power it is necessary that a full charge of explosive gas enter the cylinder; that this mixture must be properly proportioned; that it should be compacted to a certain point before ignition, and that it must be ignited promptly and at the proper time. In order to obtain a full charge of pure mixture it is evident that the exhaust gases must be entirely expelled from the cylinder in order that the incoming fresh gas will not be contaminated by mixing with the dead products of combustion.

It is much more difficult to secure a full charge of clean mixture with a two-cycle engine than with a four-cycle. In the former, the charging with fresh gases and expulsion of dead gases must take place in half the time allowed in the latter form, and the piston does not pump in a charge or force the burned gases out of the cylinder, as is the case with a four-stroke engine. As the two-cycle motor does not fully expel the burned products it cannot run as fast because of a tendency to choke up at high speeds. In the four-cycle engine a full stroke of the piston is employed in emptying the cylinder, and the natural gas pressure is increased by the reduction of cylinder volume caused by the upwardly moving piston.

In the two-cycle forms the burned gas is discharged through the open exhaust port by its own pressure. If prompt charging and clearing of the cylinder was the only problem to be solved in securing efficient action it would not be difficult to provide large enough ports to attain this end. The port size must be restricted, however, and carefully proportioned because as both intake and exhaust passages are uncovered by the piston at practically the same time a large portion of the incoming gas may be discharged with the burned product, this making for a large fuel consumption and material reduction of efficiency. As the gas is not perfectly clean and pure, some difficulty may be experienced in igniting it. Trouble is also experienced with the cooling, lubrication, and carburetion groups, as most two-cycle

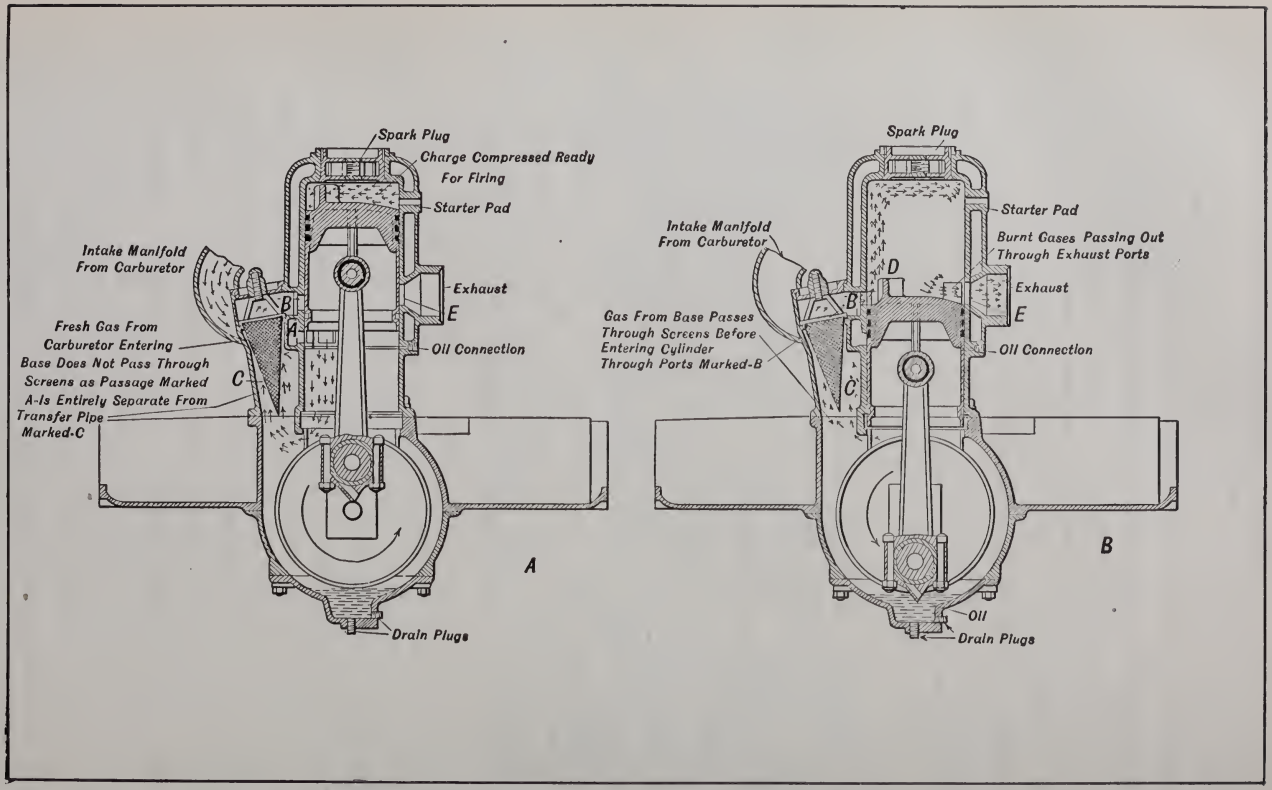


Fig. 122.—Sectional View of Amplex Two-Cycle Motor. A—Piston at Top of Stroke, Ready to Receive Impact Due to Gas Explosion. B—Piston at Bottom of Stroke. Note Gas Transfer from Engine Base and Expulsion of Burnt Gases.

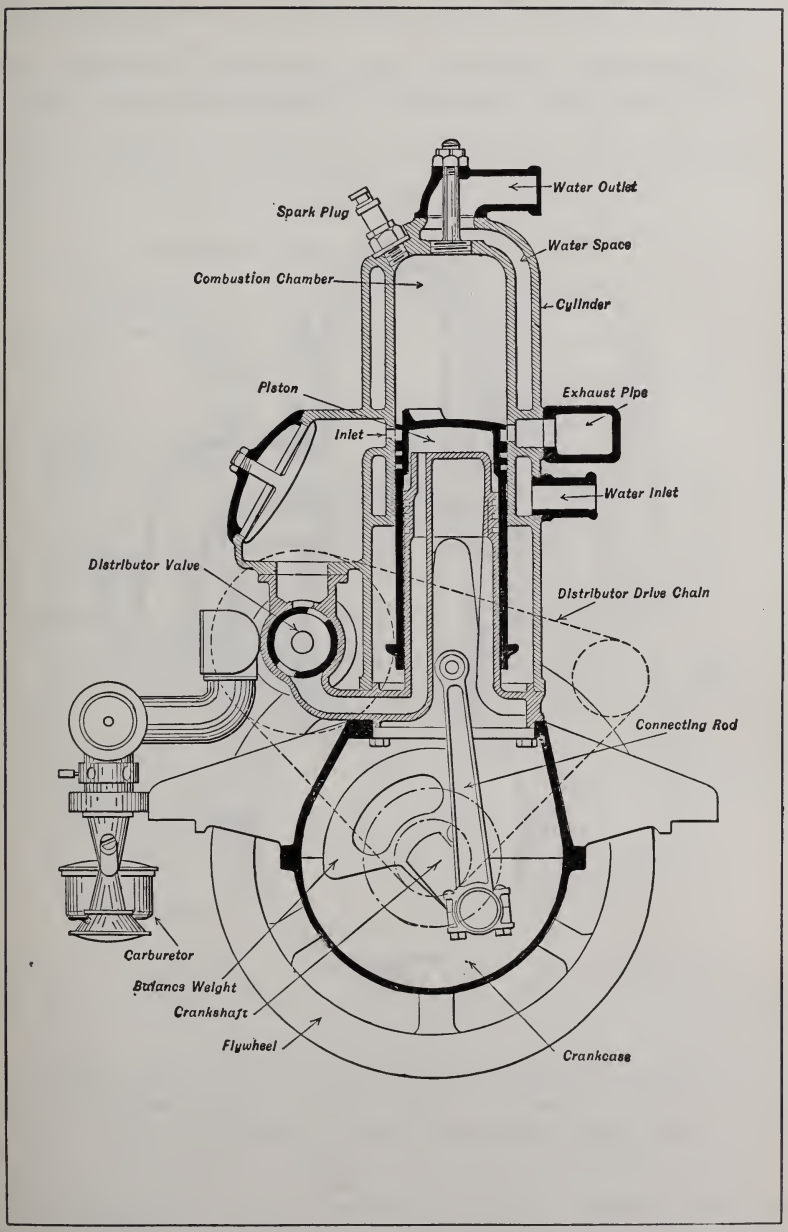


Fig. 123.—Sectional View Showing Construction of Legros (French) Two-Cycle Motor Defining Peculiar Cylinder Construction.

motors have peculiarities which make proper oiling and gas supply difficult.

Most automobile designers have adopted the four-cycle power plant, because it has been perfected to a greater degree than the two-

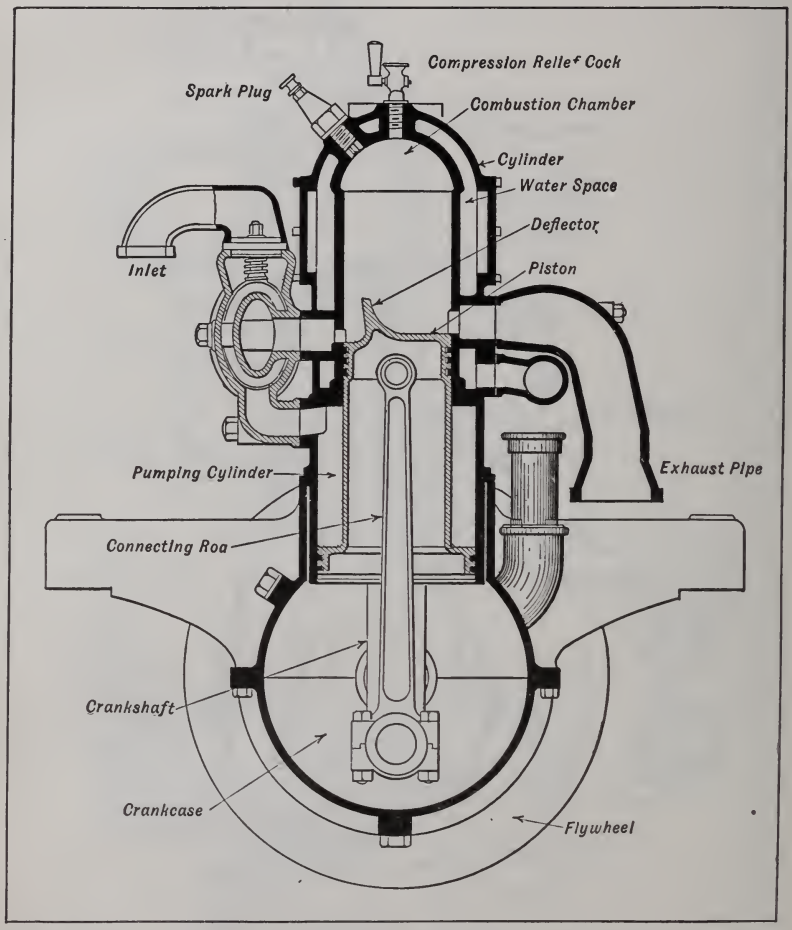


Fig. 124.—The Coté (French) Two-Cycle Motor is a Good Example of the Type Employing a Two-Diameter Piston and Distributor Valve.

cycle, and is easier to keep adjusted and in good running condition. Though the two-cycle motor is undoubtedly the simplest form, it is liable to be erratic in operation and it is sometimes difficult to locate the trouble positively. They consume more fuel than the four-cycle engine of the same power and are not so flexible. Various types of

two-cycle engines which have been designed for automobile use will now be described.

Typical Two-Cycle Motors.—As a general rule the two-stroke cycle engines that have been adapted for automobile propulsion differ materially from the simple forms previously described. Some boat makers, who use the simple form in their work, have been able to secure very satisfactory results in practice by careful attention to port

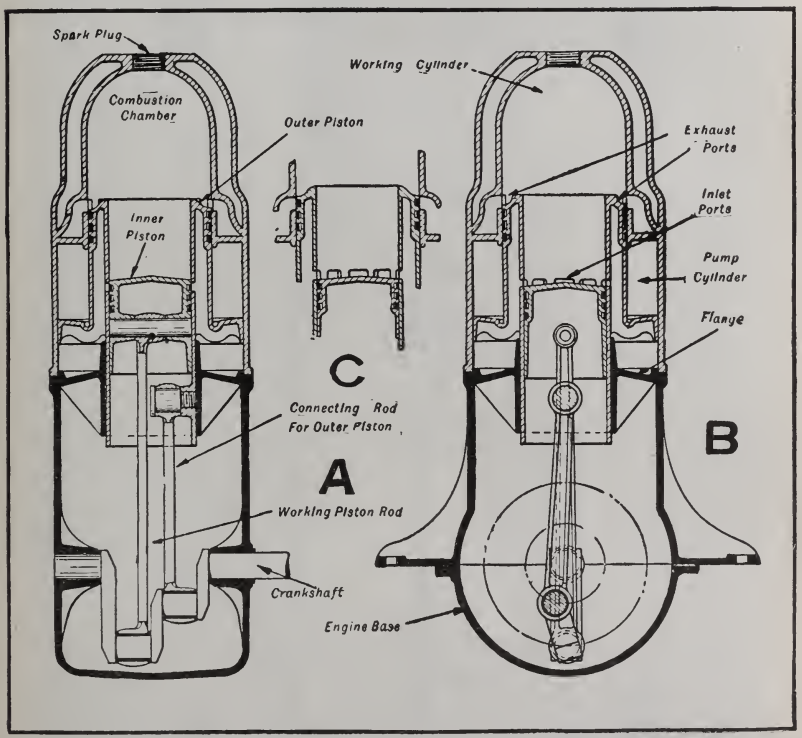


Fig. 125.—The Rayner (English) Two-Cycle Motor Employs Distinctive Double Piston Arrangement. A—Side View, Showing Crank Shaft and Connecting Rods. B—End Section, Showing Relative Angularity of Connecting Rods. C—Inner Piston Uncovers Inlet Ports, Outer Piston Covers Exhaust Passage.

design. When a two-cycle motor is to be used for motor-boat propulsion, it is a moderate speed proposition and great flexibility or efficiency is not sought. In the automobile, however, the conditions that obtain make it necessary to design the power plant in such a way that it would have a wide range of speed and so that it can be easily accelerated from its lowest to its highest speed without missing explosions or running irregularly.

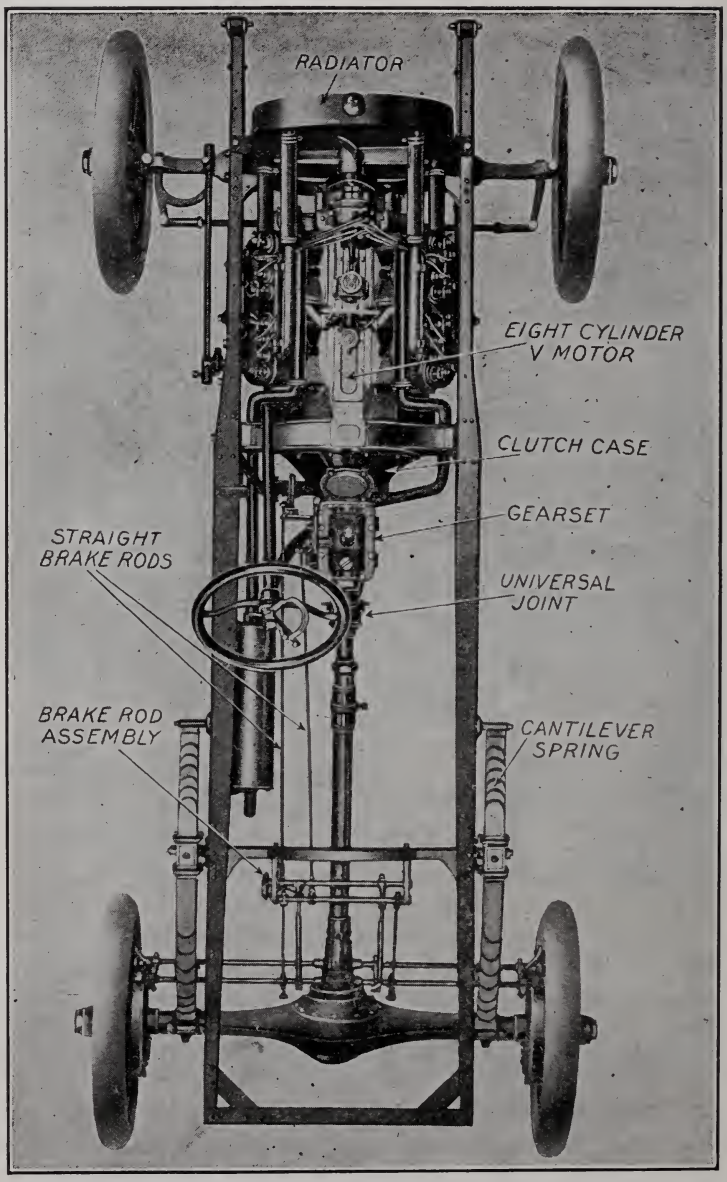


Fig. 126.—Plan View of King Eight-Cylinder Automobile Chassis, Showing Installation of Unit Power Plant.

A sectional view through the cylinder of the Amplex two-cycle motor (no longer manufactured) is shown at Fig. 122, A. This motor is a simple construction which resembles the marine type in general design, though great care has been taken in proportioning the ports and gas passages to obtain the flexibility which is so essential to the motor-car power plant. This motor is a three-port type and the gas is taken into the engine base through ports which are uncovered by the piston when it reaches the end of its compression stroke. When the parts are in the position shown at A, the piston has reached the top of

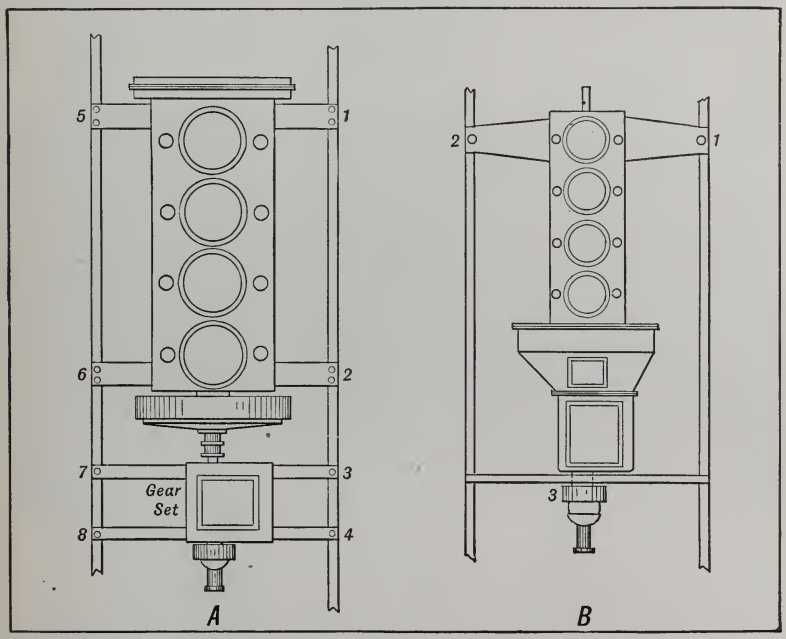


Fig. 127.—Defining Advantages of Unit Power Plant Construction when Supported on Three Points.

its stroke and the compressed gas in the cylinder is ready for ignition. At the same time the inlet ports just at the bottom of the piston have been uncovered and the gas flows through the intake manifold from the carburetor. In the other view shown at B, the position of the parts when the piston has completed its power stroke is depicted. The exhaust port is fully opened and the burned gases are discharged through it. Communication is also made between the engine base where the charge has received preliminary compression necessary to insure its transfer through the safety screen and the open ports in the cylinder wall. The entering fresh gas is deflected to the top of the cylinder by

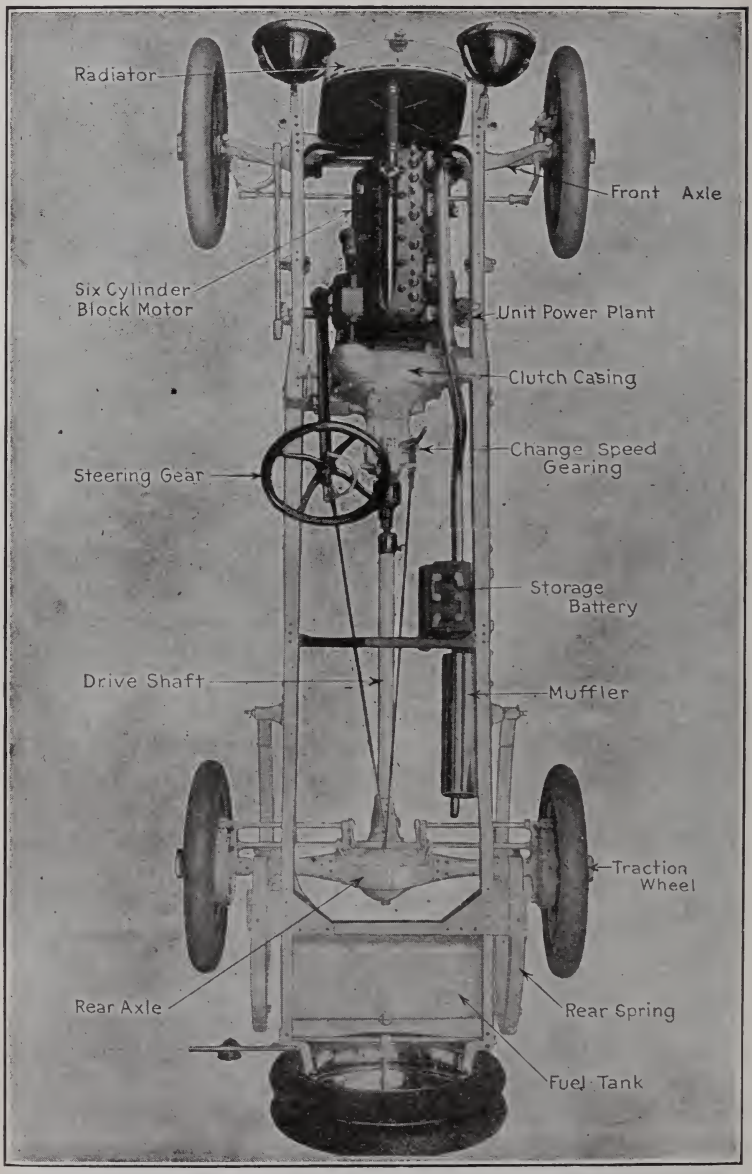


Fig. 128.—Plan View of Empire Model 60 Chassis, Showing Installation of Six-Cylinder Unit Power Plant.

the deflector place provided on the top of the piston, as is usual practice. The Amplex motor is a four-cylinder type and gives very satisfactory results in practice.

The Legros two-cycle motor, which is of French derivation, embodies a distributor valve and a peculiar arrangement of pistons. In this construction a stationary member is placed inside of the regular working piston and it is the space between these members that is utilized to store the gas taken in, prior to transferring it from the pump portion of the engine to the combustion chamber. The action is very similar to that of the usual form of differential piston motor. When the piston goes up on the compression stroke it draws in a

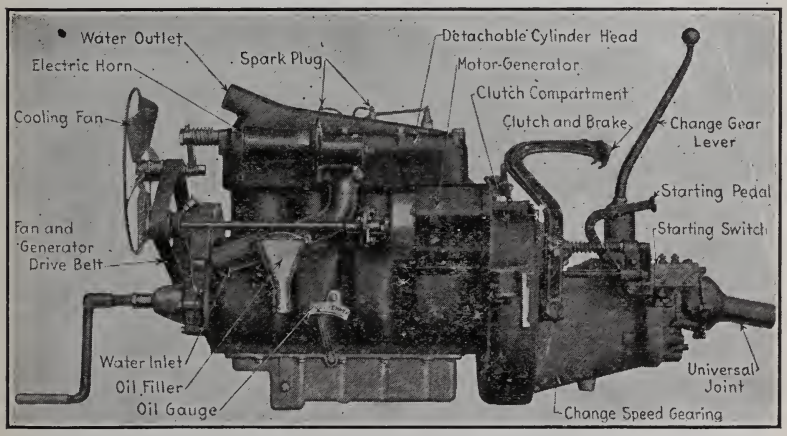


Fig. 129.—The Maxwell Unit Power Plant.

charge of gas from the carburetor through the rotary distributor valve and up through the passage which joins the valve chambers to the space between the stationary and movable pistons. When the piston reaches the top of its stroke the rotary valve turns to such a position that it cuts off the carburetor from the pumping chamber and provides communication between the pumping chamber and the cylinder by means of the usual transfer passage and inlet ports cored into the cylinder wall. Otherwise the action is just the same as that of the more simple forms of engines. The construction of this motor is clearly shown at Fig. 123, and as all parts are clearly indicated the principle of operation should be easily grasped.

Another differential piston motor designed by a French engineer, Monsieur Coté, is shown at Fig. 124. In this a double-diameter piston is used and the cylinder is formed so that the smaller of these

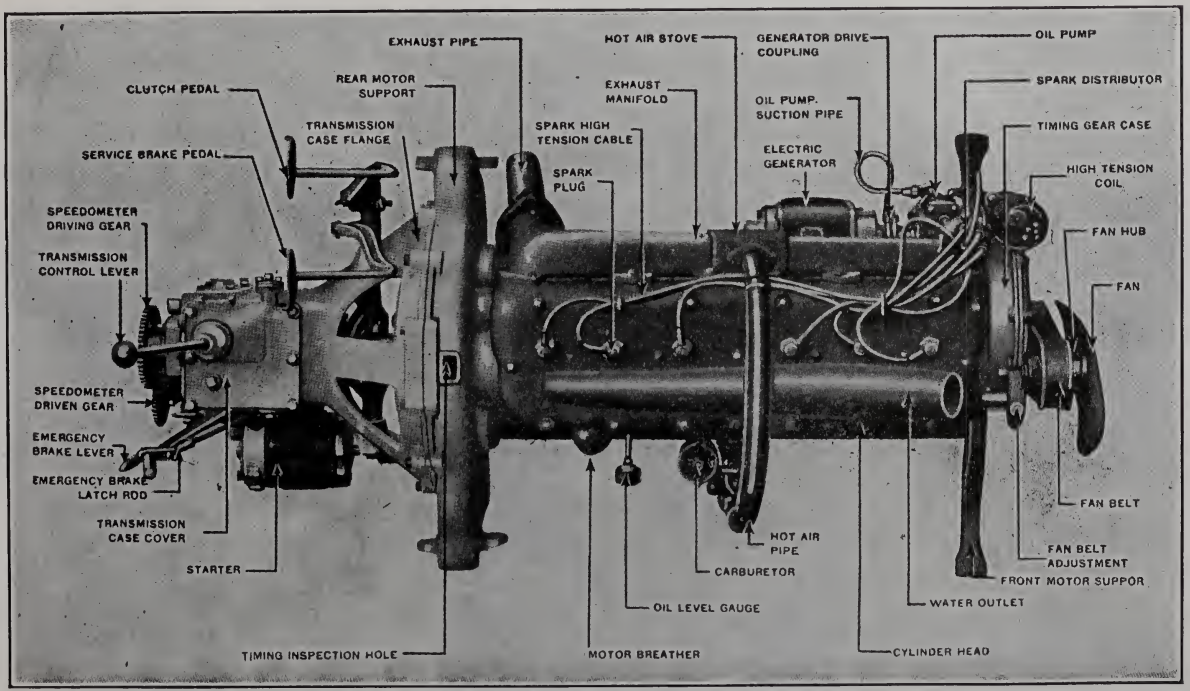


Fig. 130.—Top View of the Chalmers Six-Cylinder Unit Power Plant.

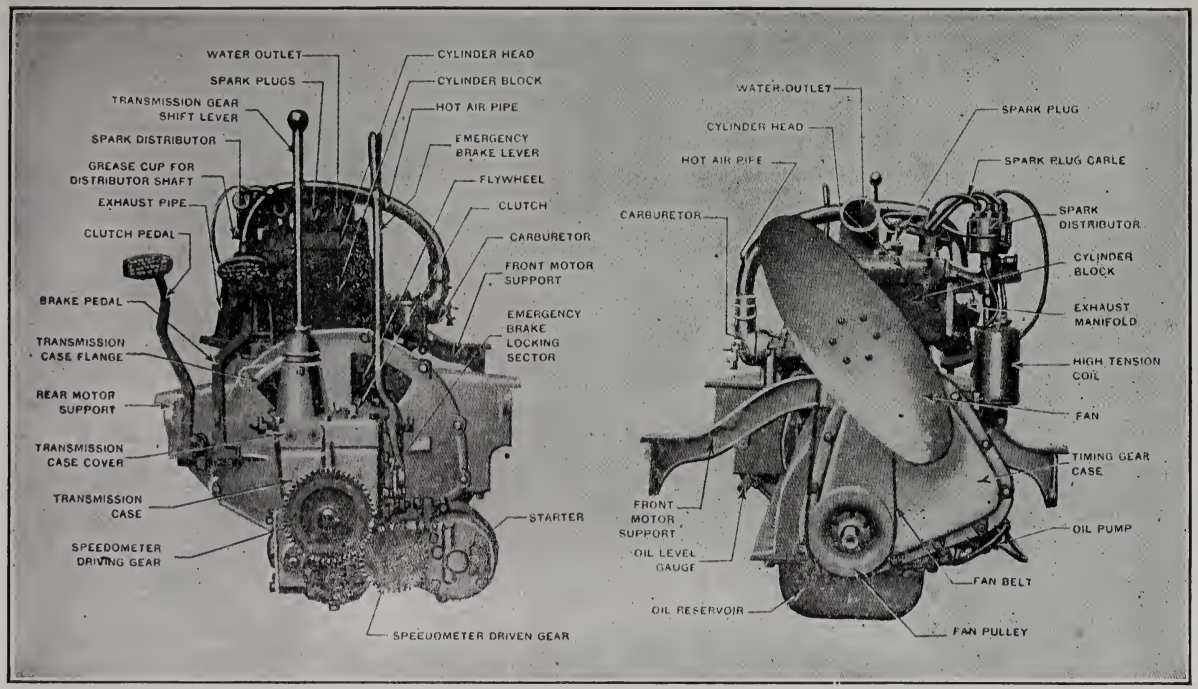


Fig. 131.—Front and Rear Views of the Chalmers 1917 Motor.

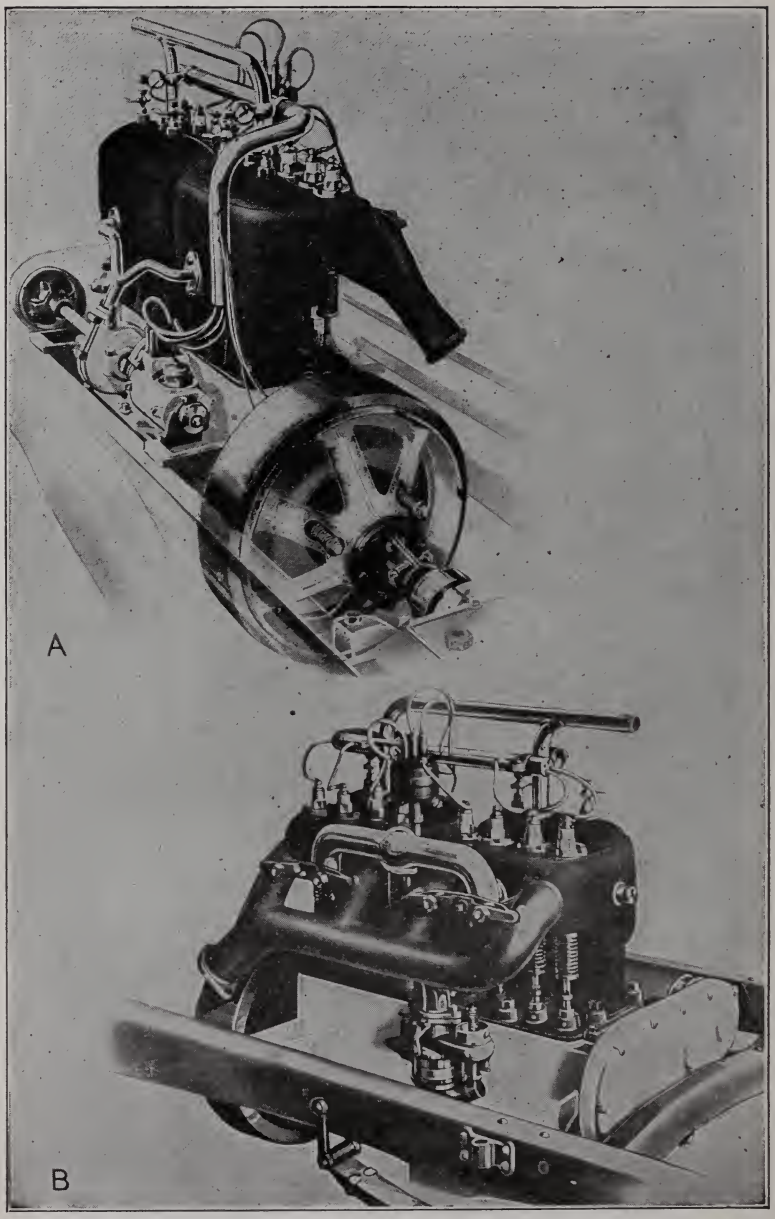


Fig. 132.—Views of Typical Power Plant Installed in Motor Car Frame.

members fits the upper portion while the large end of the piston fits the correspondingly enlarged lower portion. The functions of compression and explosion of the charge take place in the smaller cylinder, while the lower member acts as a pump. On every downstroke of the piston a charge of gas is drawn into the annular space between the piston and cylinder wall, and on every upward stroke it is compressed and forced into the working cylinder adjacent. The construction outlined is applicable only to motors having an even number of cylinders, and the arrangement must be such that they will work in pairs and that the piston in one cylinder will be at one end of its stroke while that of its mate is in the other extreme position. The peculiar type of transfer passage depicted is necessary because the pumping portion of one cylinder must be joined to the working portion of the other member. Outside of peculiarities of construction, the operating cycle is just the same as other two-stroke engines, and an explosion is obtained in each cylinder every two strokes of the piston.

An unconventional two-cycle engine of English design is shown at Fig. 125. Two pistons are used, one working inside of the other; the outer member carries an annular flange which fits the enlarged bore of the cylinder and acts as a pump for taking in the gas and subjecting it to preliminary compression. The pump chamber is divided from the crank case by a flange, which also acts as a guiding member for the bottom of the large piston. At the end of the downstroke each piston uncovers a ring of ports, the outer member opening the exhaust while the inner piston controls the inlet openings. A peculiar form of crank shaft having two throws for each cylinder is used, and the crank to which the inner piston is attached has twice the amount of throw the crank connected to the larger member has. This means that both pistons work in the same direction, but that the inner member travels twice the distance the big piston does. The crank which controls the movement of the outer piston is given a lead of about twenty degrees so that the exhaust ports are opened at the proper time in relation to the opening of the inlet passages.

When the pistons travel on the upstroke, the inner one is compressing a charge previously supplied the working cylinder and simultaneously fresh gas is being inspired into the pump chamber. When the pistons reach the top of the stroke the spark takes place and the resulting explosion drives the piston down and imparts power to the crank shaft in the usual manner. At the same time that the pistons are driven down by the explosion, the new charge which has been drawn in through the pump chamber is partially compressed. Near the end of the stroke the outer piston uncovers the exhaust ports, and the

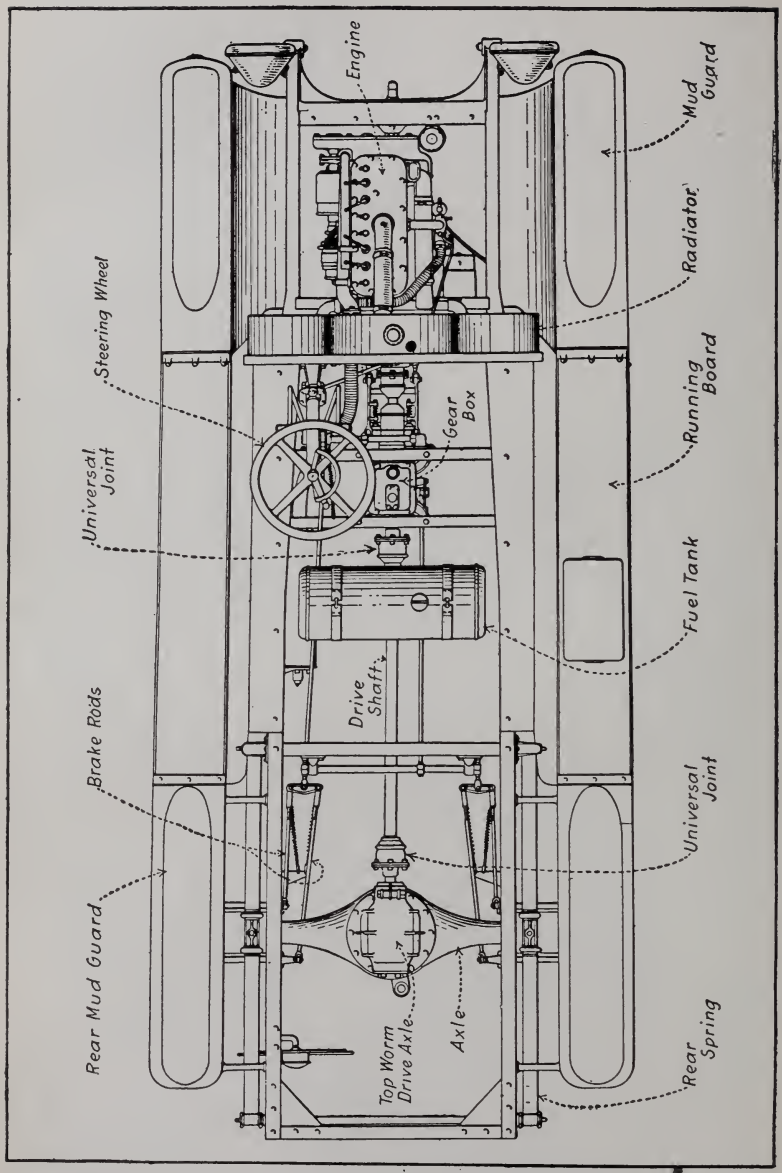


Fig. 133.—Plan View of Lippard-Stewart Light Truck, Showing Power Plant Installation.

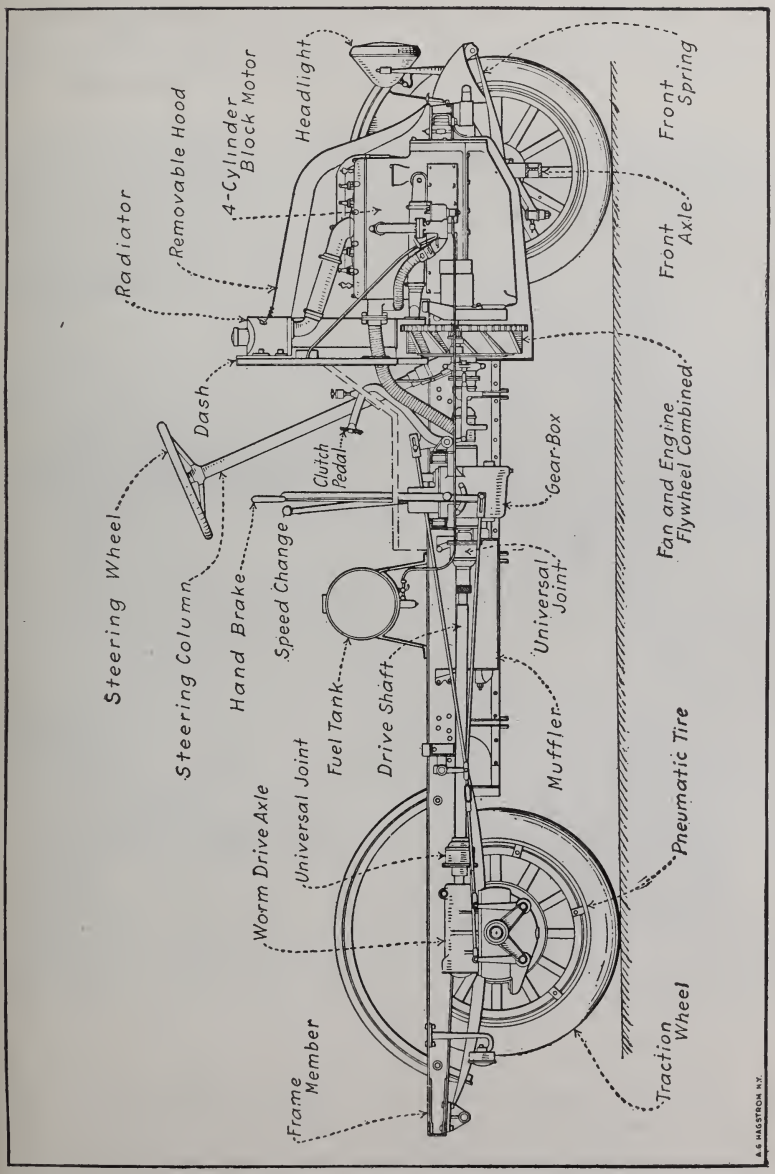


Fig. 134.—Side Elevation of Lippard-Stewart Light Truck.

burned gases escape by virtue of their pressure. The inlet ports open and new gas enters the cylinder in the usual manner and is directed to the top of the cylinder by the peculiar formation of the outer piston, which acts as a chimney to direct the gases to the top of the combustion chamber. As the new charge enters at considerable speed the

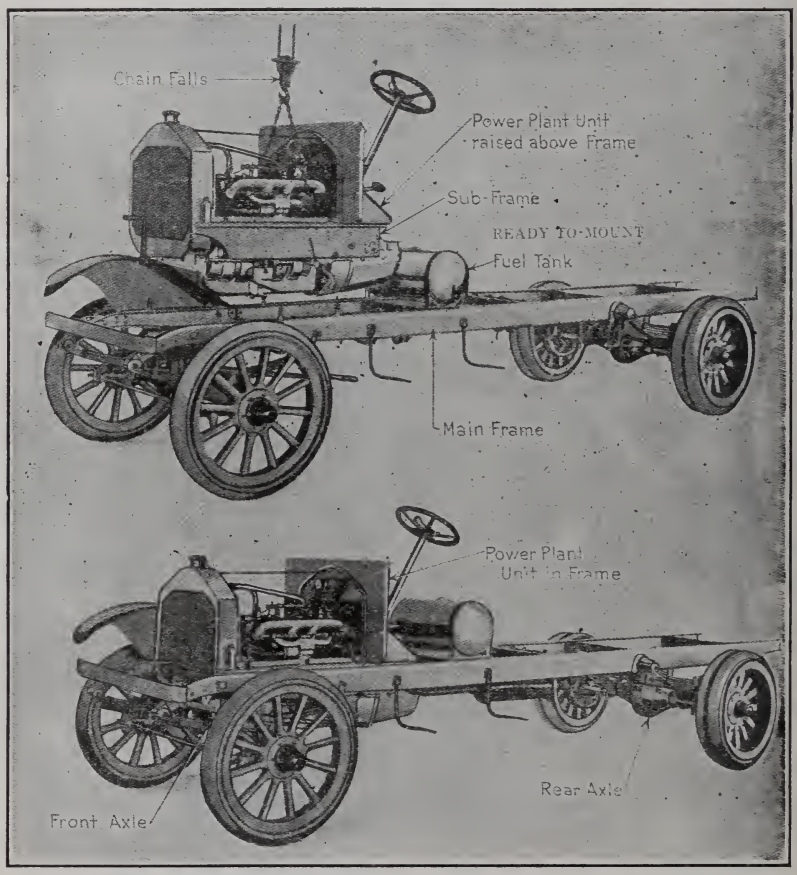


Fig. 135.—Diagram Showing Removable Power Plant Unit in Maccar Truck.

high velocity of the gas forces out the burned products and insures thorough scavenging. The view at A is a side section and depicts the arrangement of the pistons relative to each other and the peculiar arrangement of the crank shaft. At B an end section is presented, this to show the angularity of connecting rods, showing how the short throw crank is given a slight lead over that which works the inner piston. The inset at C is given to enable the reader to un-

derstand the principle involved in controlling the intake and exhaust ports.

Power Plant Installation.—The method of installing the power plant varies on different types of automobiles, though the majority of cars have the engine placed at the extreme front end of the chassis. In some early types of cars where single or double cylinder motors of the horizontal type were used the motor was placed under the body. This type of construction is nearly obsolete at this time, and is found only on early forms of vehicles and one or two commercial cars.

The power plant is nearly always combined with the clutch and change speed gearing in such a way as to form a unit construction.

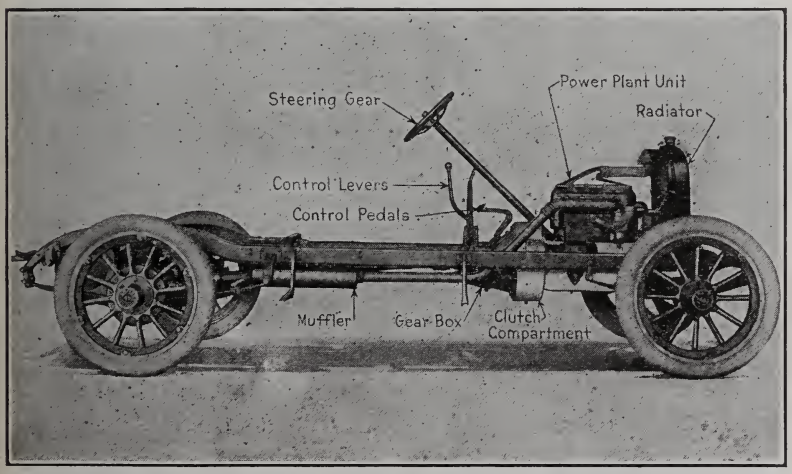


Fig. 136.—Side View of Empire Model 45 Chassis, Showing Installation of Power Plant Unit.

This method of joining the parts is widely used at the present time, and is superior to the other common method where the motor and change speed gears are independent units. Each method has advantages. As will be seen by inspecting Fig. 127, A, when the gearset and motor are separate the transmission may be removed from the chassis frame without disturbing the power plant, and vice versa. At the other hand, when the unit construction, as shown at B, is employed, it is sometimes difficult to remove one member without having to take the entire unit from the frame.

The unit construction has the advantage of retaining positive alignment of the gearset with the engine indefinitely. This relation between the parts is obtained when they are first assembled and the

alignment cannot be changed by any condition of operation after the unit is installed in the frame. This method of mounting also permits the three-point suspension which is very desirable. For in-

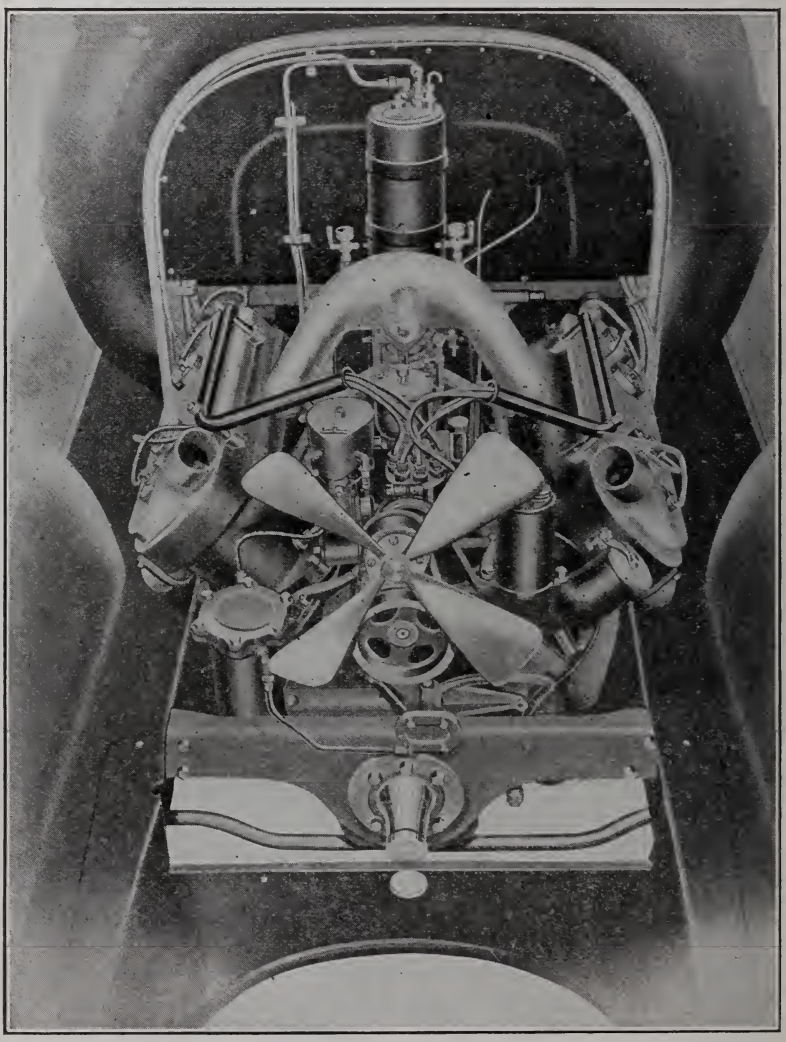


Fig. 137.—Front View of Stearns-Knight Chassis, Showing Installation of Eight-Cylinder Motor and Auxiliaries.

stance, the power plant shown at Fig. 127, A, is supported on four points and the gearset is supported on another series of four points. While the tendency of these members is to brace the frame and prevent

disalignment, it is possible on extremely rough roads for the frame distortion to vary the relation of the transmission and engine shaft to some extent. Where a three-point suspension is employed, as outlined at Fig. 127, B, and at Fig. 128, the frame distortion will not impose stress on the individual members of the power plant because in a rigid unit construction all parts must remain in alignment. The advantages of this design are becoming better appreciated and it is widely used at the present time.

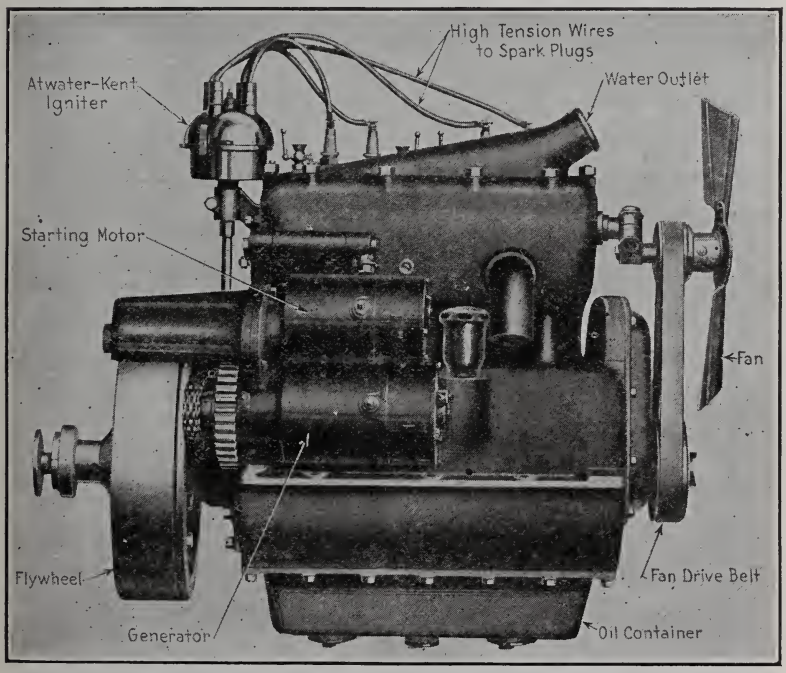


Fig. 138.—The Saxon Four-Cylinder Engine.

At Fig. 129, a typical four-cylinder power plant and transmission unit adapted for three-point support is clearly shown, while at Figs. 130 and 131 a six-cylinder unit power plant which is designed for attachment to the frame at four points is illustrated. To show the method of power-plant installation that was generally employed when engine and gearset were separate units the views at Fig. 132 are presented, these representing a typical four-cylinder power plant of four years ago viewed from the front and rear, showing clearly the method of supporting the engine base by four arms and also outlining the position of the various auxiliary components. In most types of com-

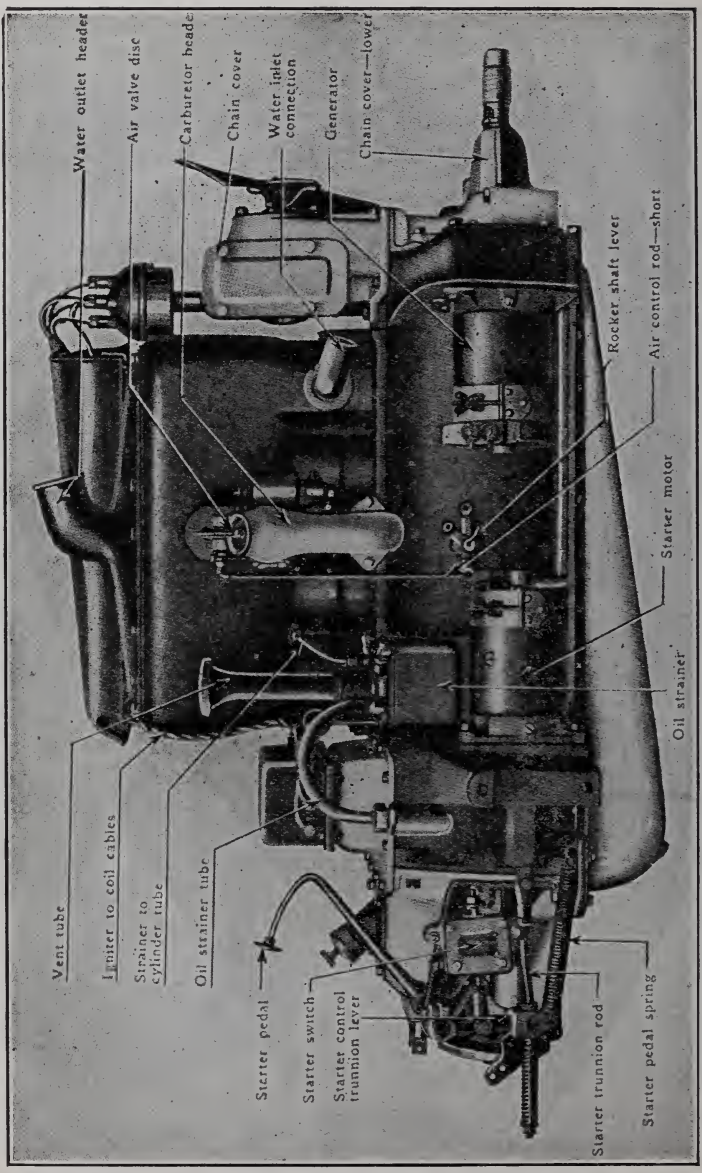


Fig. 139.—Power Plant of 1917 Hupmobile Car.

mercial vehicles the motor is installed at the front end under the hood as in pleasure car practice, but in rare cases it is placed at practically the same point but under floor boards or driver's seat. The

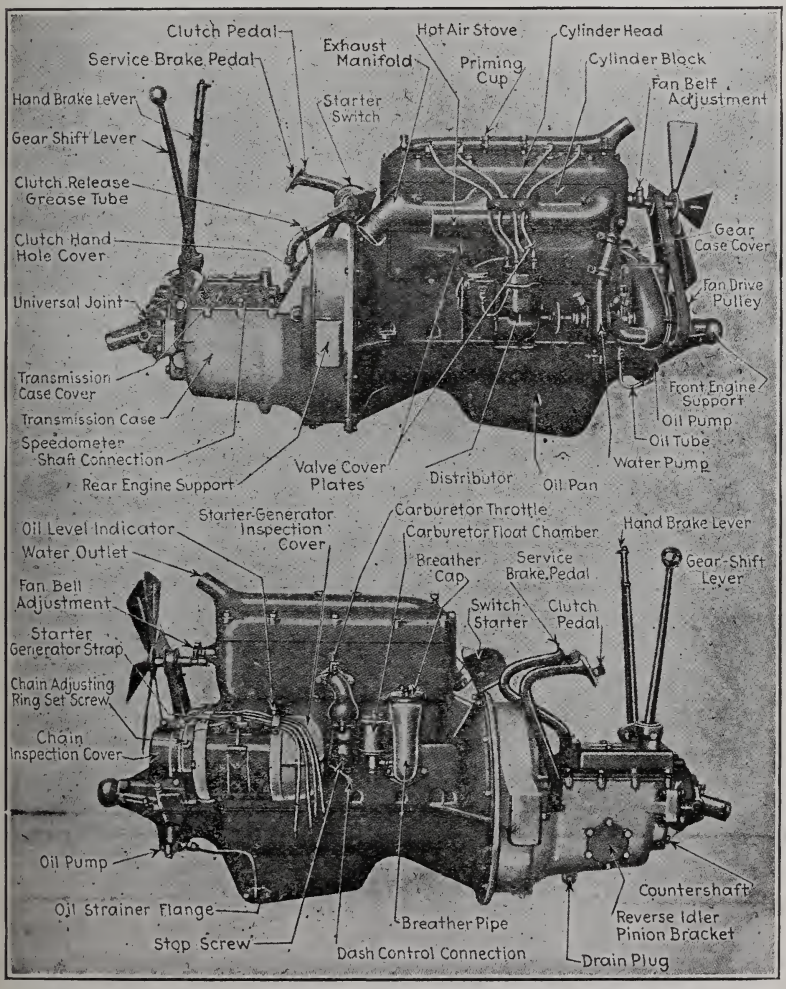


Fig. 140.—Views of Four-Cylinder Engine Used in 1917 Dodge Brothers Automobile, Showing All Important Parts.

plan and side elevation views of a typical light truck chassis at Figs. 133 and 134 show how closely pleasure car practice is followed in trucks of light and medium capacity.

The advantages of the motor under the seat location may be very

well summed up by saying that it permits more loading space and less over all or wheel base for a given carrying capacity. The shorter wheel base vehicle is especially valuable in congested city traffic, because it may be more easily controlled when driving in narrow thoroughfares, taking corners, or backing up to a loading platform. The

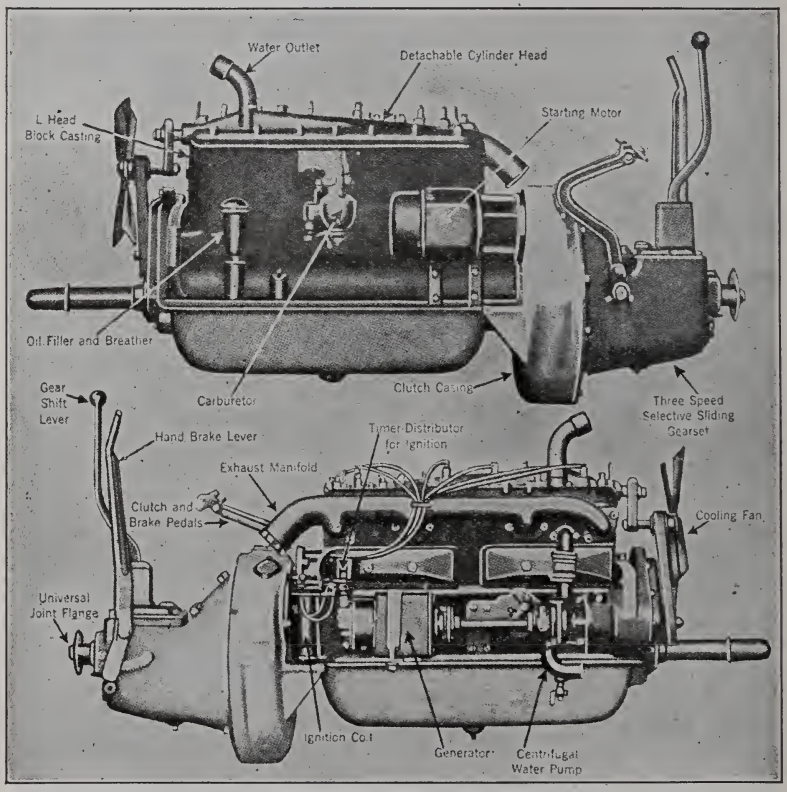


Fig. 141.—Typical High Speed Light Six Unit Power Plant.

main advantage advanced for the motor in front type of commercial vehicle is accessibility of power plant, which may be easily reached by raising the hood. This feature is not lost when the motor is placed under the seat, however, because all average adjustments may be made by raising the floor boards or by opening a hinged door at the side of the motor compartment. Some makers install the motor in a subframe and arrange the components in such a manner that they may be removed as a unit, permitting ready access to the motor and making for its prompt removal in event of overhauling or serious accident.

Such a construction is shown at Fig. 135, which depicts a medium capacity truck with the power plant units removed from the frame. It will be seen that this unit includes the radiator, control levers, engine, gearbox and frame for the support of the floor boards. The seat unit is separate and is designed to fit over the fuel tank when it is in place on the chassis.

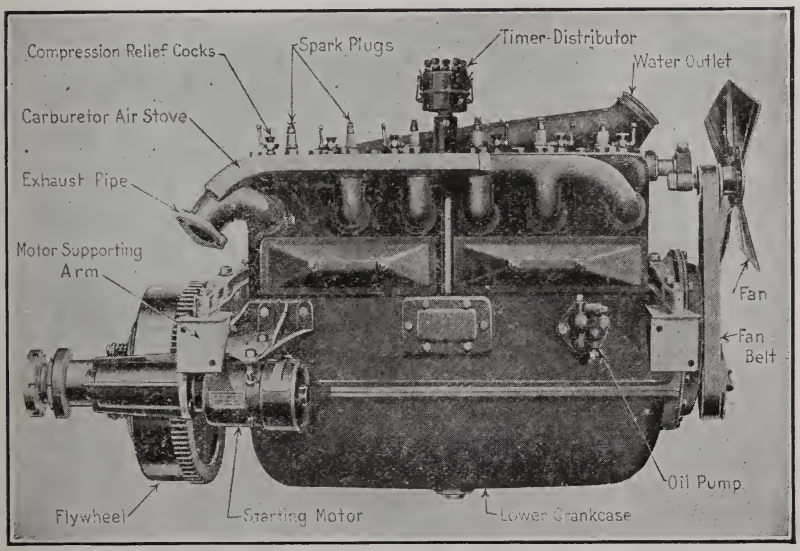


Fig. 142.—The Saxon Light Six Motor Used on 1917 Models.

1917 Automobile Engine Practice.—The power-plant situation does not differ materially from that of last year. No definite decision has been reached regarding the best number of cylinders. Several new four-cylinder models have been announced, but as almost double the number of new cars equipped with six-cylinder engines have been advertised, it may be said that the latter type is receiving the preference. The eight- and twelve-cylinder engines have not made the gains that were predicted when these were first offered. The most popular form of engine is the six-cylinder of the small bore, long stroke type, running at fairly high speeds, such as shown at Figs. 141 and 142. Two new four-cylinder types have been announced both by representative companies which have adapted principles worked out in racing cars to those designed for every-day use. Very high speeds have been secured from racing cars of the four-cylinder type in which twice the usual number of valves are used in each cylinder. This has led to the

development of the sixteen-valve four-cylinder motor. As it is possible to secure a quicker charging and clearing of the cylinders due to the greater valve area provided, considerably more power and speed and greater flexibility of action can be obtained with a given piston

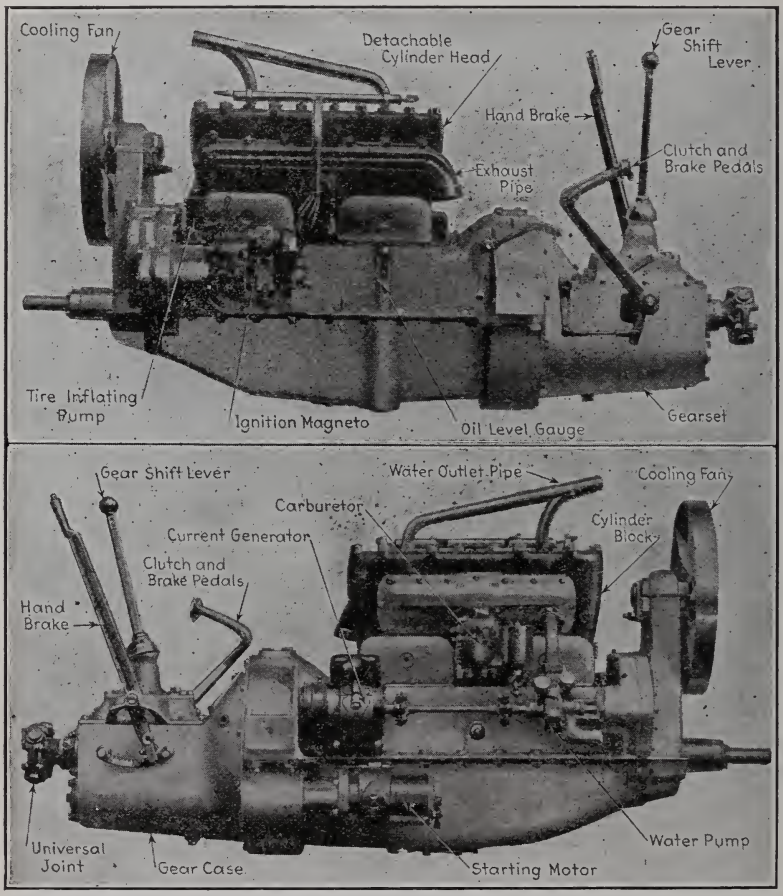


Fig. 143.—Views of the White Four-Cylinder Sixteen-Valve Motor Used as Power Plant in 1917 Model.

displacement than with the commonly accepted types. The White sixteen-valve four-cylinder T-head engine is shown at Fig. 143. The Wisconsin-Stutz 300-cubic-inch racing motor, having valves in the head, with overhead camshaft actuation, is shown at Fig. 144. Curves showing the mean effective pressure variation and horse-

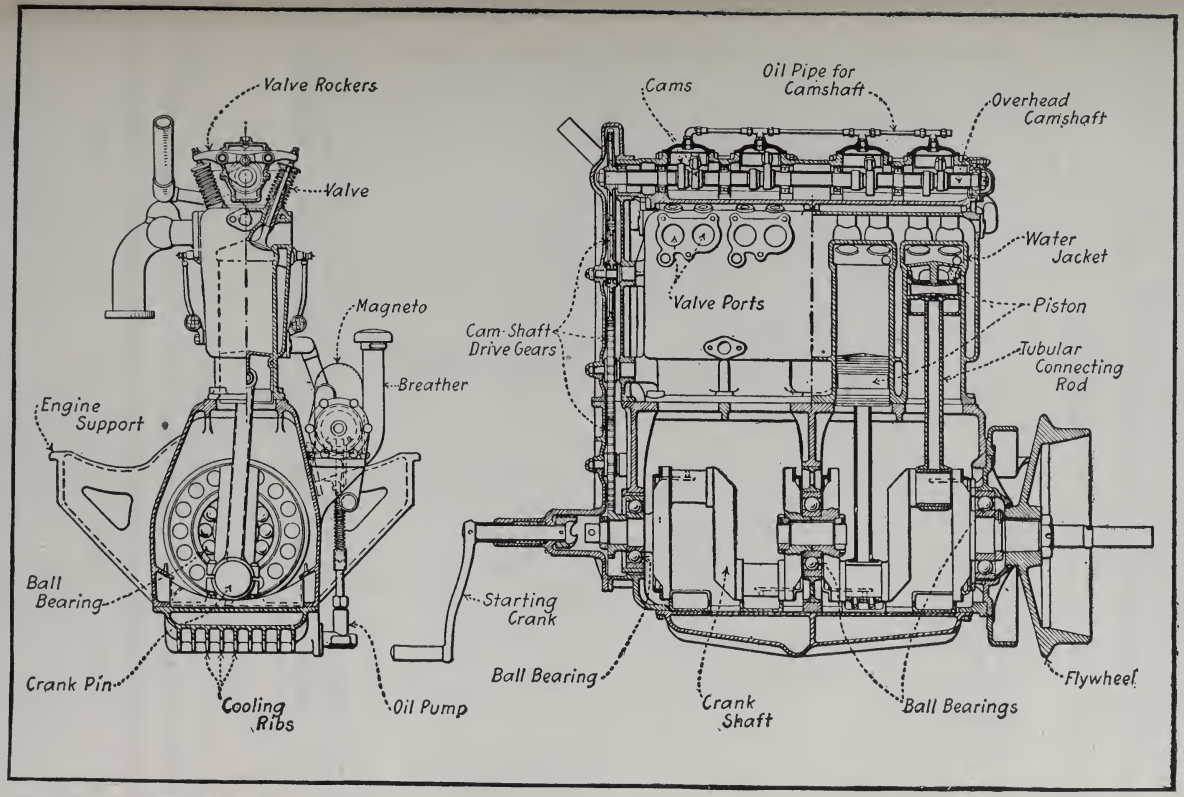


Fig. 144.—Sectional Views Showing Construction of the Stutz-Wisconsin Three-Hundred-Cubic-Inch Sixteen-Valve Racing Motor.

power increase with augmenting crank-shaft speed are shown at Fig. 145.

The six-cylinder engine, however, has made a very definite gain over the four-cylinder and has not surrendered any of the advantage

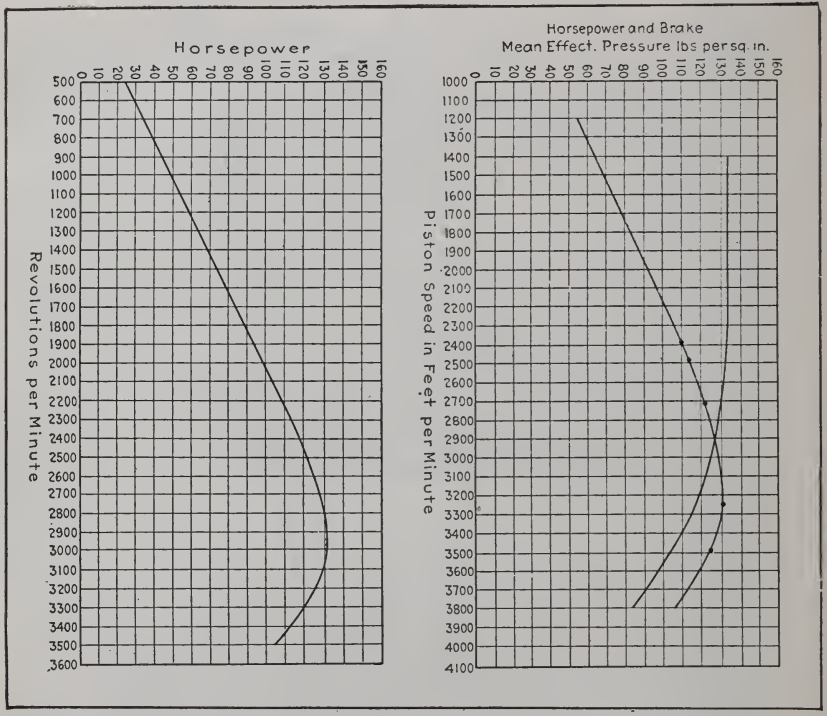

Horsepower
Revolutions per Minute
Horsepower and Brake
Mean Effect. Pressure lbs per sq. in.
Piston Speed in Feet per Minute

Fig. 145.—Charts Showing Mean Effective Pressure and Horse-Power Increase with Augmenting Engine Speed in the Wisconsin-Stutz Sixteen-Valve Racing Model.

it had over the eight- and twelve-cylinder types during the past year. When one considers the smoothness of an action that can be obtained with any well-designed, high-speed six-cylinder engine driving through spiral bevel gears in the rear axle with a final drive ratio ranging between 4 to 1 and 5 to 1, it is difficult to see how the greater mechanical complication of the twin-fours and twin-sixes can balance the advantages such a construction offers to the average automobile owner. Their field seems to be particularly in the "luxury" cars, where no expense need be spared and the owners of which expect the best that can be procured.

The small bore high speed six-cylinder engines have an average rating of about 35-horsepower and are remarkably efficient as regards fuel consumption, and as they are small and compact they reduce the car weight without sacrificing any of the desirable features. The reduction in weight and the smooth power application conduce to tire economy, and it is not unusual to obtain 6,000 miles' service from

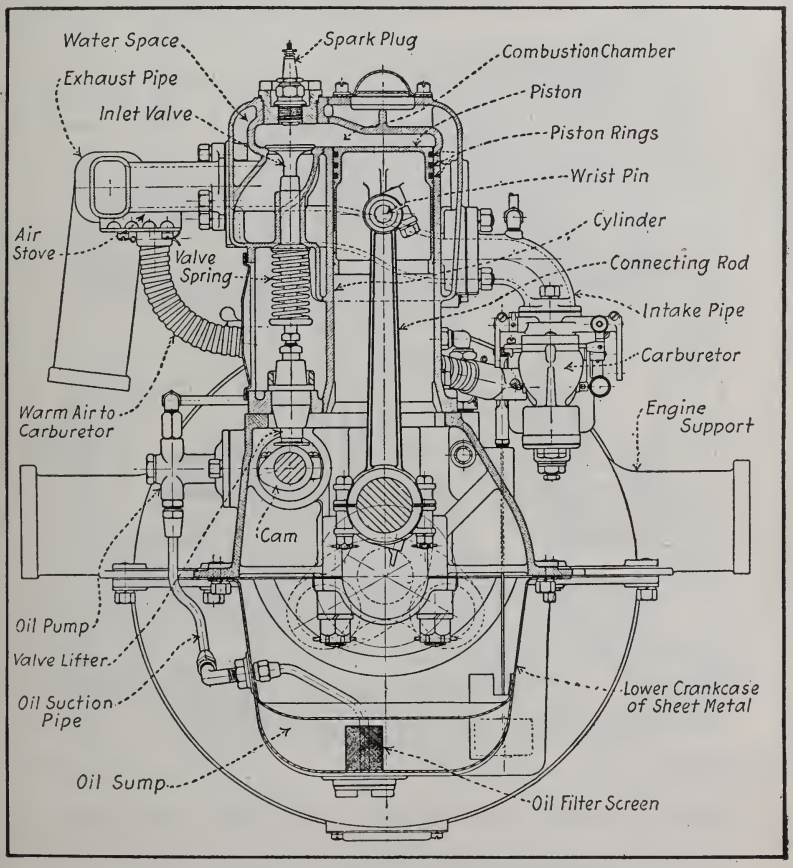


Fig. 146.—A Transverse Section Through the Haynes 1917 Light Six Motor.

tires of average quality on these light six chassis. The percentage of chassis models fitted with six-cylinder engines reached its high point at the beginning of 1915, when about 53 per cent. of the cars were fitted with six-cylinder engines. Owing to the development of the eight-cylinder during the year 1915-16 and the twelve-cylinder

at the beginning of the past year the proportion of the six-cylinder engines was naturally less at the beginning of 1916 than it was a year previous. About 44 per cent. of the 1916 models were six-cylinder types. For 1917 the percentage has increased so that about 50 per cent. will be equipped with this type of power plant. Three years ago 62 per cent. of the car models were fitted with four-cylinder engines, but 33 per cent. of the 1917 models will be furnished with this type of power plant. There has been a slight decrease in the number of

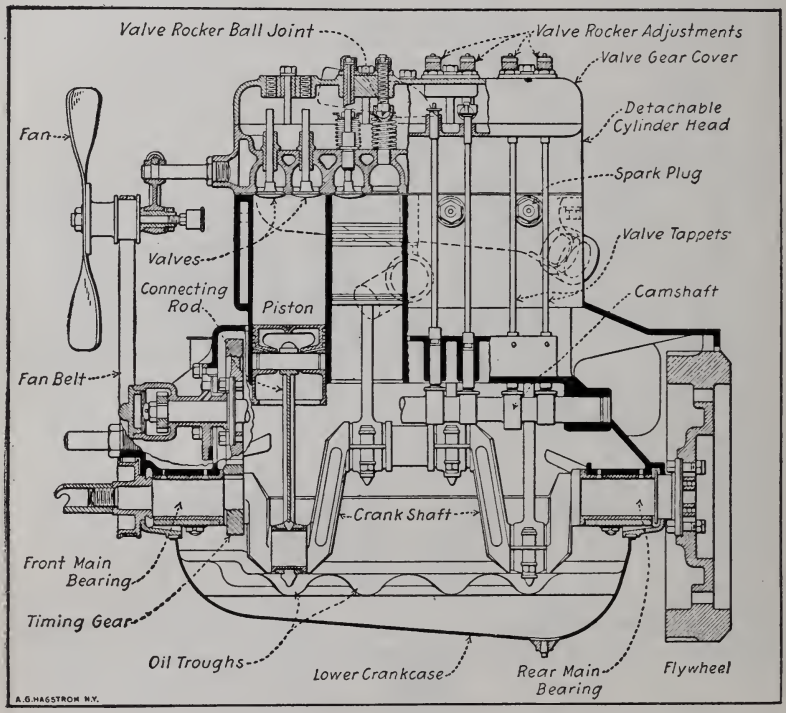


Fig. 147.—Typical Overhead Valve, Four-Cylinder, High-Speed Engine.

eight-cylinder engines and a very slight increase in the number of twelve-cylinder power plants. It is estimated that about 12 per cent. of the coming models will be equipped with the former and about 5 per cent. with the latter.

The accepted practice on practically all four-cylinder engines and in most of the six-cylinder constructions is to cast the cylinders in a single block. Another pronounced trend is the provision of detach-

able cylinder heads. While this construction is somewhat more costly to the manufacturer, its advantages have been so apparent to the motorist that this feature has been incorporated in even the latest "twin-six" power plants. Block castings are used on 95 per cent. of the four-cylinder engines and 75 per cent. of the six-cylinder.

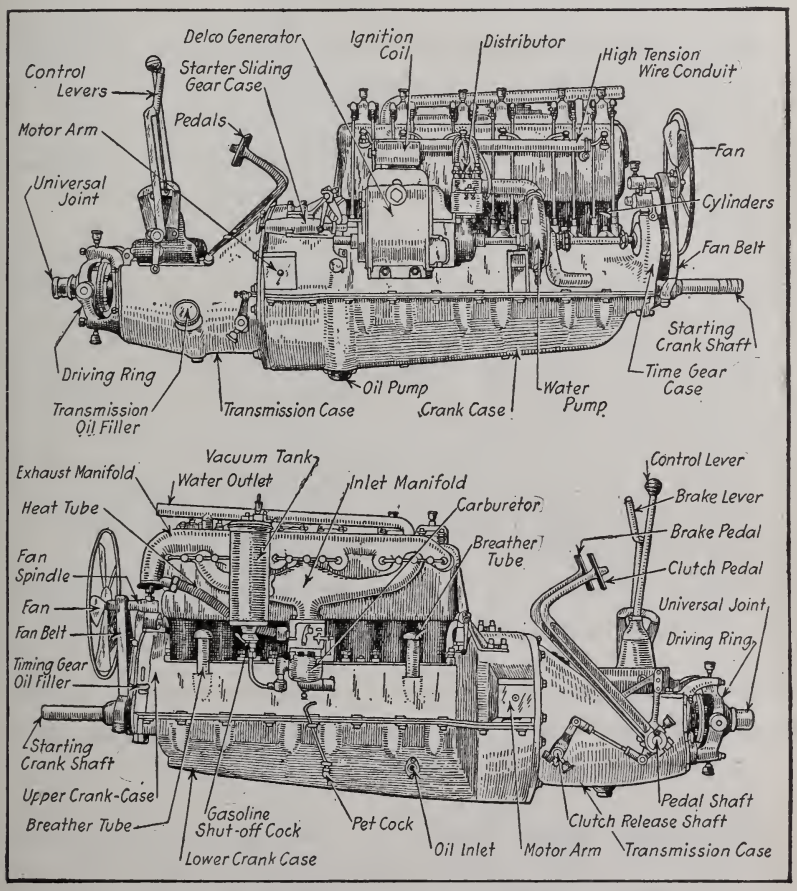


Fig. 148.—Views of a 1917 Buick Light Six Power Plant.

The favorite valve location seems to be the L-head construction, as about 70 per cent. of the 1917 engines have cylinders of this type, or as shown at Fig. 146. The valve-in-the-head location has made material gain at the expense of the T-head construction, several very flexible, high-speed engines of the four-cylinder type, shown at Fig. 147, having been developed for light cars. The six-cylinder Buick

engine, illustrated at Fig. 148, is an excellent example of this form of construction. About 14 per cent. of the cars of last year had the valves-in-the-head. This number has increased to 20 per cent. for the coming season. The T-head construction, which was used in about 10 per cent. of last year's engines, is found only in approximately 4 per cent. of this year's.

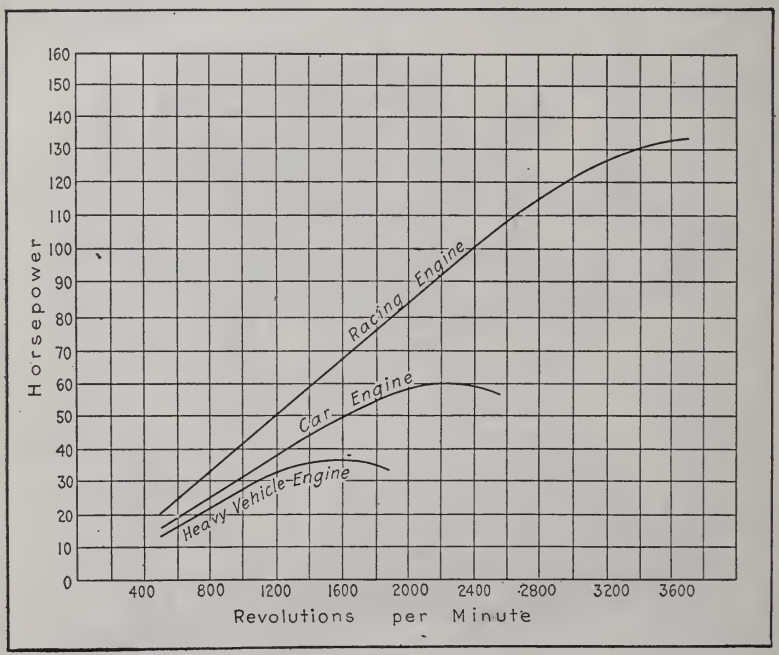


Fig. 149.—Horse-power Curves of Typical Truck, Pleasure Car and Racing Engines.

Some Modern Engine Details.—The table on the opposite page, reproduced from the *Automobile,* shows the power-plant equipment of a number of prominent car manufacturers who do not build their own engines.

The curves at Fig. 149 show the power variation and speeds of crank-shaft rotation of engines for various purposes. Naturally, racing engines have the most power and are capable of higher speeds than either the commercial or pleasure car types. This chart shows that truck engines develop their greatest power at a speed of about 1,500 r. p. m., and that they average about 35 H. P. Pleasure car engines average about 60 H. P. at 2,200 r. p. m. The great speed of

Car and model	Make motor	Cyl.	Bore	Stroke	N.A.C.C. rating
Abbott, 6-44	Continental	6	3¼	4¼	25.35
Anderson, 6-40	Continental	6	3¼	4¼	25.35
Argo, 17	Massnick	4	3⅛	4	15.63
Auburn	Teetor	6	3⅛	5	23.44
Austin, King H-wy	Weidley	12	2⅞	5	39.68
Bour-Davis, 1917	Continental	6	3¼	4½	25.35
Briscoe, 8-38	Ferro	8	3	3½	28.8
Chevrolet, 490	Mason	4	3 11/16	4	21.5
Chevrolet, F5-F2	Mason	4	3 11/16	4	21.5
Cole, 860	Northway	8	3½	4½	39.2
Crow-Elkhart, CE-35	Lycoming	4	3½	5	19.6
Daniels, A	Herschell-Spillman	8	3¼	5	33.8
Davis, Light Six	Continental	6	3¼	4½	25.35
Davis, Big Six	Continental	6	3½	5¼	29.4
Dispatch, G	Wisconsin	4	3¾	5	22.5
Dixie Flyer, 1917	Lycoming	4	3¼	5	16.9
Drummond, 8	Herschell-Spillman	8	3	5	28.8
Elgin	Falls	6	3	4¼	21.6
Glide, Light Six 40	Rutenber	6	3⅛	5	23.44
Grant	Falls	6	3	4¼	21.6
H. A. L	Weidley	12	2⅞	5	39.68
Halliday	Rutenber	6	3⅛	5	23.44
Hollier, 186	Falls	6	3	4¼	21.6
Howard, 1917	Continental	6	3¼	4½	25.35
Inter-State	Rutenber	4	3½	5	19.16
Jackson, Wolverine	Ferro	8	3	3½	28.8
Jones, 26-B	Lewis	6	3½	5¼	29.4
Kline Kar, 6-38 Series F	Continental	6	3¼	4½	25.35
Lambert, 90	Rutenber	4	4¼	5¼	28.9
Lambert, 80	Continental	6	3¼	4½	25.35
Lexington, 6-P	Continental	6	4⅛	5¼	40.84
Lexington, 6-O-17	Continental	6	3¼	4½	25.35
Liberty Six, 10-A	Continental	6	3⅛	4½	23.44
Luverne, 17	Continental	6	3¾	5¼	33.75
Madison	Rutenber	6	3⅛	5	23.44
Madison, 8	Herschell-Spillman	8	3¼	5	33.8
Maibohm, 17	Massnick	4	3⅛	4	15.63
Marion-Handley, 6-40-A	Rutenber	6	3⅛	5	23.44
Marion-Handley, 6-60-B	Continental	6	3½	5¼	29.4
McFarlan, 1917	Teetor	6	4½	6	48.6
Meteor	Weidley	12	2⅞	5	39.68
Monroe, M-3	Sterling	4	3	4¼	14.4
Moon, 6-43	Continental	6	3¼	4½	25.35
Moon, 6-66	Continental	6	3½	5¼	29.4
Moore, 35	G. B. S	4	3¾	4¼	22.5
Murray, 70-T	Herschell-Spillman	8	3¼	5	33.8
Napoleon, 30	Lycoming	4	3½	5	19.6
Oakland, 34	Northway	6	2 13/16	4¾	19.5
Oakland, 56	Northway	8	3½	4½	39.2
Olds, 45	Northway	8	2⅞	4¾	26.45
Overland, 85	Continental	6	3¼	4½	25.35
Paige, 6-46	Continental	6	3½	5¼	29.4
Paige, 6-38	Rutenber	6	3⅛	5	23.44
Partin-Palmer, Twenty	Le Roi	4	3⅛	4½	15.63
Paterson, 6-45	Continental	6	3¼	4½	25.35
Pathfinder	Weidley	12	2⅞	5	39.68
Pilot, 6-45	Teetor	6	3⅛	5	23.44
Princess, 4-36-F	G. B. S	4	3¾	4¼	22.5
Pullman, 424-32	G. B. S	4	3¾	4¼	22.5
Roamer	Rutenber	6	3¼	5	24.1
Ross, C	Herschell-Spillman	8	3¼	5	33.8
Saginaw, 1917	Massnick	8	3⅛	4½	31.25
Saxon, B-5-R	Continental	4	2¾	4	12.1
Saxon, S-4	Continental	6	2⅞	4½	19.84
Scripps-Booth, D	Ferro	8	2⅝	3¾	22.05
Scripps-Booth	Sterling	4	3	4¼	14.4
Singer, 17	Herschell-Spillman	6	4	5½	38.4
Standard, E	Herschell-Spillman	8	3	5	28.8
Standard, F	Herschell-Spillman	8	3¼	5	33.8
Stephens, 60-65	Continental	6	3¼	4½	25.35
Stutz, R	Wisconsin	4	4¾	5½	36.10
Sun, 17	Beaver	6	3⅛	5	23.44
Velie, 27	Continental	6	3½	5¼	29.4
Velie, 28	Continental	6	3¼	4½	25.35
Westcott, S-17	Continental	6	3½	5¼	29.4
Yale	Massnick	8	3⅛	4½	31.25

racing engines and the high power output can be clearly ascertained. The following horsepower table, taken from *Motor Age,* is presented for the convenience of the readers desiring to compare power outputs of various sizes of engines:

HORSEPOWER TABLE BY N. A. C. C.—FORMERLY A. L. A. M. FORMULA; ALSO KNOWN AS S. A. E.

In using table, find bore of cylinder in inches of millimeters in the proper left hand column, then read across to right under column for the number of cylinders that the motor under consideration has.

BORE = D		NUMBER OF CYLINDERS = N			
Inches	Millimeters	4	6	8	12
2½	64	10.00	15.00	20.00	30.00
2⅝	68	11.03	16.54	22.05	33.08
2¾	70	12.10	18.15	24.20	36.30
2⅞	73	13.23	19.84	26.45	39.68
3	76	14.40	21.60	28.80	43.20
3⅛	79	15.63	23.44	31.25	46.88
3¼	83	16.90	25.35	33.80	50.70
3⅜	85	18.23	27.34	36.45	54.68
3½	89	19.60	29.40	39.20	58.80
3⅝	92	21.03	31.54	42.05	63.08
3¾	95	22.50	33.75	45.00	67.50
3⅞	99	24.03	36.04	48.05	72.08
4	102	25.60	38.40	51.20	76.80
4⅛	105	27.23	40.84	54.45	81.68
4¼	108	28.90	43.35	57.80	86.70
4⅜	111	30.63	45.94	61.25	91.88
4½	114	32.40	48.60	64.80	97.20
4⅝	118	34.23	51.34	68.45	102.68
4¾	121	36.10	54.15	72.20	108.30
4⅞	124	38.03	57.04	76.05	114.08
5	127	40.00	60.00	80.00	120.00
5⅛	130	42.03	63.04	84.05	126.08
5¼	133	44.10	66.15	88.20	132.30
5⅜	137	46.23	69.34	92.45	138.68
5½	140	48.40	72.60	96.80	145.20
5⅝	143		75.94	101.25	151.88
5¾	146		79.35	105.80	158.70
5⅞	149		82.84	110.45	165.68
6	152	57.60	86.40	115.20	172.80

The formula from which the above table was compiled has been criticized because it assumes average conditions that are often improved materially in engines of recent development. It gives results that apply to average designs and not highly refined types of sixteen-valve or sleeve-valve motors. It is valuable for purposes of comparison, however, and affords a convenient means of approximate power determination when practical results are desired.

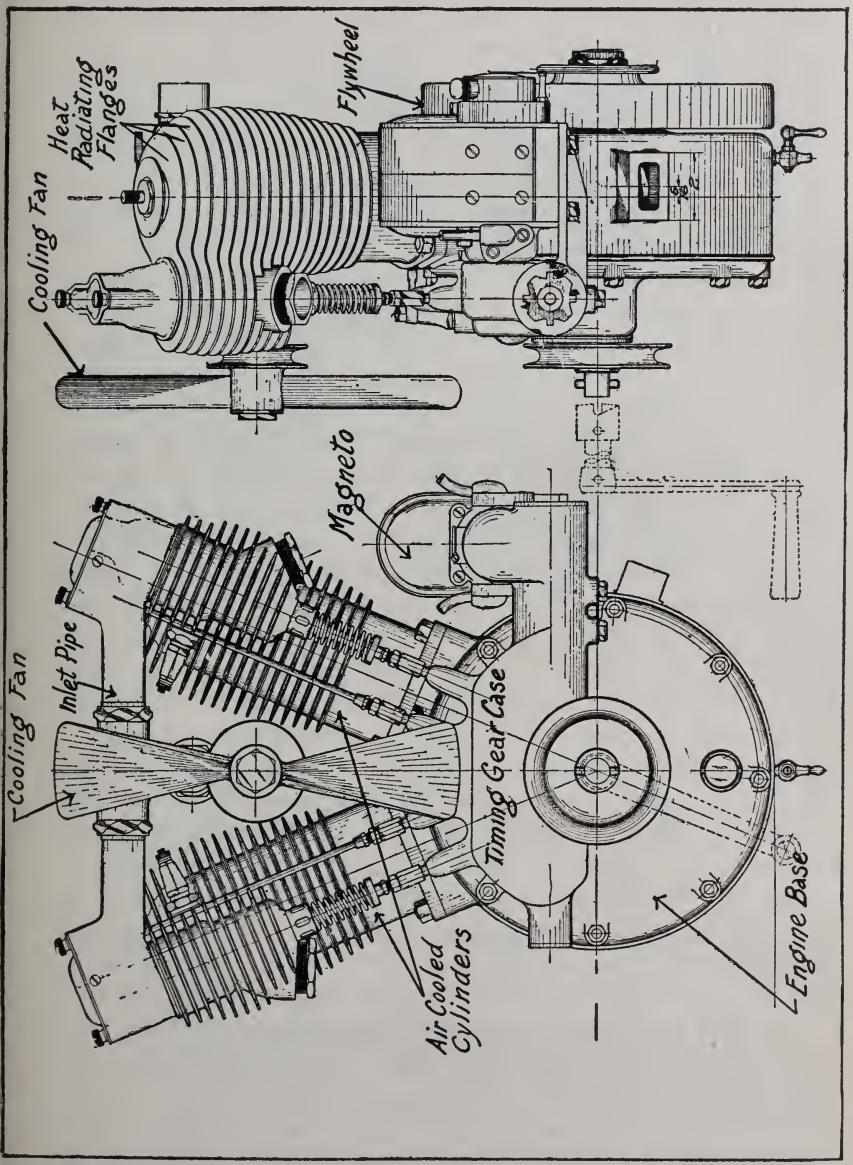


Fig. 150.—Front and Side Views of Spacke De Luxe Cyclecar Motor.

Cyclecar and Light Car Power Plants.—The type of power plant utilized in cyclecar propulsion depends entirely upon the nature of the vehicle. For instance, the simple type or true cyclecars used motors patterned after forms that have received general application in motorcycle service, while the light cars or those which follow automobile practice more closely employ water-cooled motors, usually of the four-cylinder type. The engine shown at Fig. 150 is a two-cylinder form that will develop about 12 H. P. at a maximum speed of 2,500 r. p. m., and follows motor bicycle practice very closely in that it employs two air-cooled cylinders, disposed one each side of the crank case center line at an angle of about 22½ degrees with the crank case center line, or one might say that the two cylinders had an included angle of 45 degrees. As is common with the light engines used in motor cycles, the inlet valves are mounted above the exhaust valves and are operated by tappet rods and rocker arms, whereas the exhaust valve stems are actuated directly by the usual form of push rods. In order to make for steady running, the motor is provided with an outside flywheel in addition to the balancing members mounted inside of the enclosed crank case. To insure adequate cooling when the vehicle is standing still, a two-blade fan directs a current of air against the cylinders. Ignition is by high-tension magneto, and the weight of the entire power plant, including magneto, carburetor, external flywheel, and cooling fan, is but one hundred pounds. This type of motor is efficient, fairly well balanced, and powerful enough for the simple form of cyclecar that does not weigh over five or six hundred pounds. It will propel such vehicles at speeds up to 50 miles per hour with difficulty, and is very economical of fuel, inasmuch as one gallon of gasoline will serve for 50 miles if the carburetor is properly adjusted.

Another form of motor which has been adapted to cyclecar and light car service in England is shown at Fig. 151. This is a two-cylinder water-cooled type having the cylinders cast in a pair with a common water-jacket. The cylinders are of the T-head type and follow conventional practice in regard to the location and operation of the valves. It will be noted that the crank pins are spaced 180 degrees apart, which means that while the engine has a fair mechanical balance, it will not have a good explosion balance, because the power impulses are not separated by equal intervals, one occurring immediately after the other and then a lapse of one turn of the flywheel takes place before another power impulse is obtained. This form of motor is used to some extent, but is not as popular as the V type, when only two cylinders are used. The two-cylinder vertical form has received

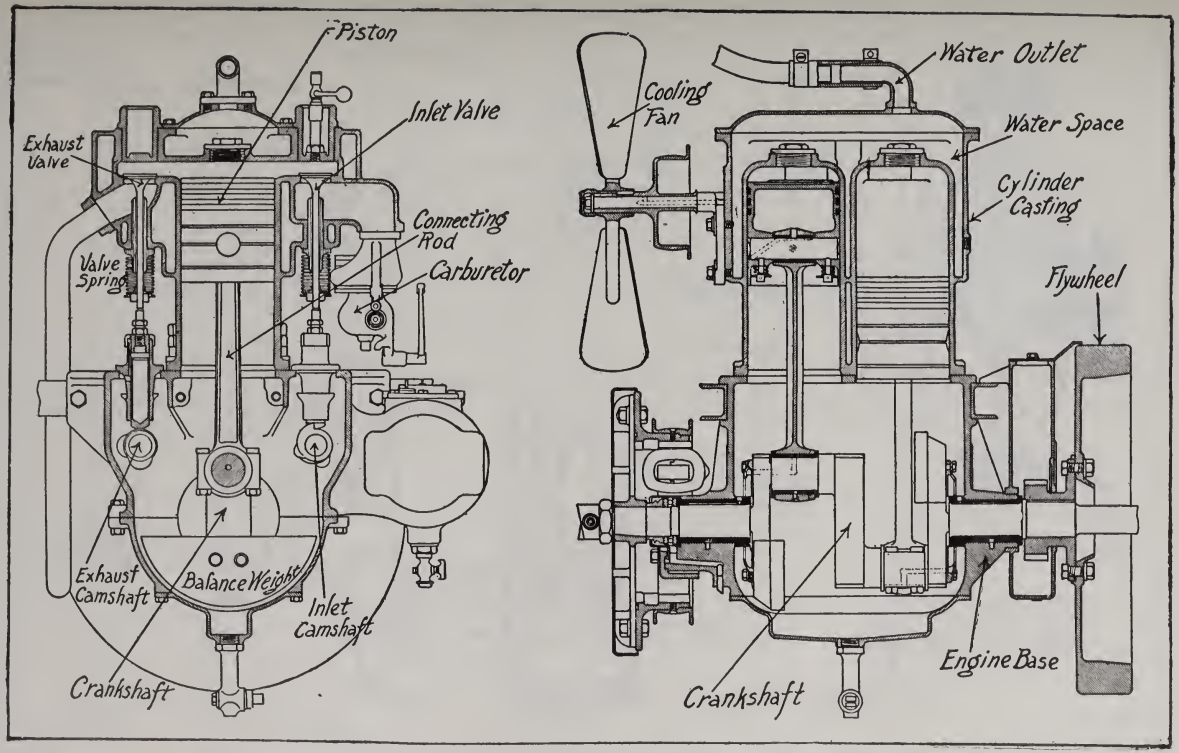


Fig. 151.—A Two-Cylinder Vertical Engine of English Design, a Type Used on Some Foreign Light Cars.

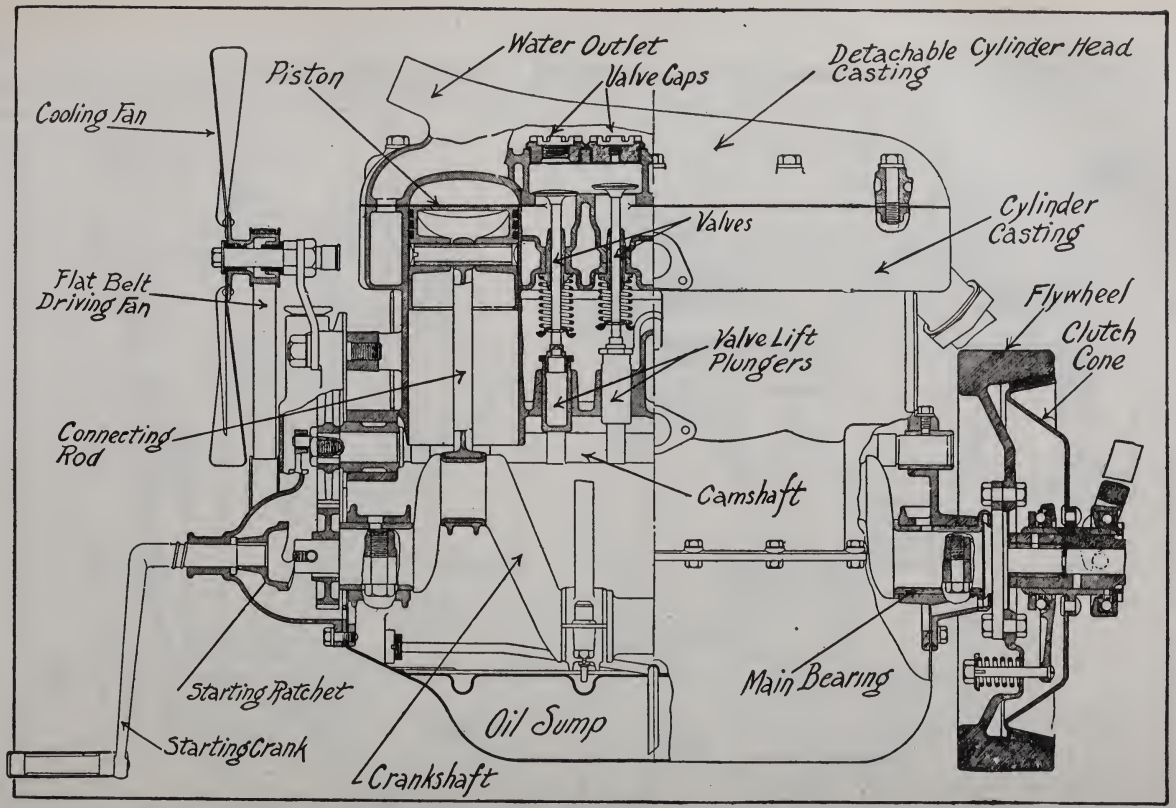


Fig. 152.—Part Sectional View of the Maxwell 25 Motor, which Is Representative of the Class Using Detachable Cylinder Head.

much wider application in Europe than in America. In this country the two-cylinder V type or horizontal opposed motors are preferred.

Many four-cylinder motors employed on light cars follow the general lines of design depicted at Fig. 152. This motor, which was utilized on the Maxwell "25" automobile, is of the same general pattern employed in the Ford, Metz and other light cars. The cylinders and upper half of the crank case are cast together, while the cylinder head, which also includes the valve chamber, is a separate casting secured to the cylinder block by bolts. A gas-tight joint is obtained between the two members by a copper asbestos gasket, which is tightly compressed to form a very satisfactory packing when the retention bolts are properly tightened.

Diesel Engines for Automobile Work.—The "Commercial Motor" offers suggestions for use of constant pressure motors in vehicle work in an article explaining the Diesel system on the assumption that the reader is not previously acquainted with it and suggesting the modification illustrated in the accompanying sectional view, Fig. 153. The article explains in substance as follows: Little progress has as yet been made as to the development of the Diesel engine in making it suitable for installing in commercial vehicle chassis. The difficulties of design undoubtedly increase as the size of the engine decreases. The principle of working is as follows:

The engine is made in three forms, viz., as a four-stroke cycle single engine, as a two-stroke single acting, and as a two-stroke double-acting engine. An essential feature in the actual Diesel engine is that it requires, besides its own cylinders and pistons, an auxiliary air compressor capable of producing a pressure of up to 700 lbs. per square inch. The principal difference between the Diesel cycle and the ordinary gasoline motor cycle is that air only is compressed in the cylinder instead of a mixture of air and fuel.

In the four-stroke Diesel engine there is an air inlet valve, a fuel valve, and exhaust valve worked by cams, and a valve for starting purposes.

First (down) Stroke.—The inlet valve is opened during the whole of the stroke, and the cylinder becomes filled with atmospheric air at atmospheric pressure.

Second Stroke.—The air valve is closed and the piston returns to the top of the cylinder compressing the air. The clearance is so pro-

portioned that in ordinary working the pressure becomes about 500 lb. per square inch and the temperature of the air about 1,000 deg.

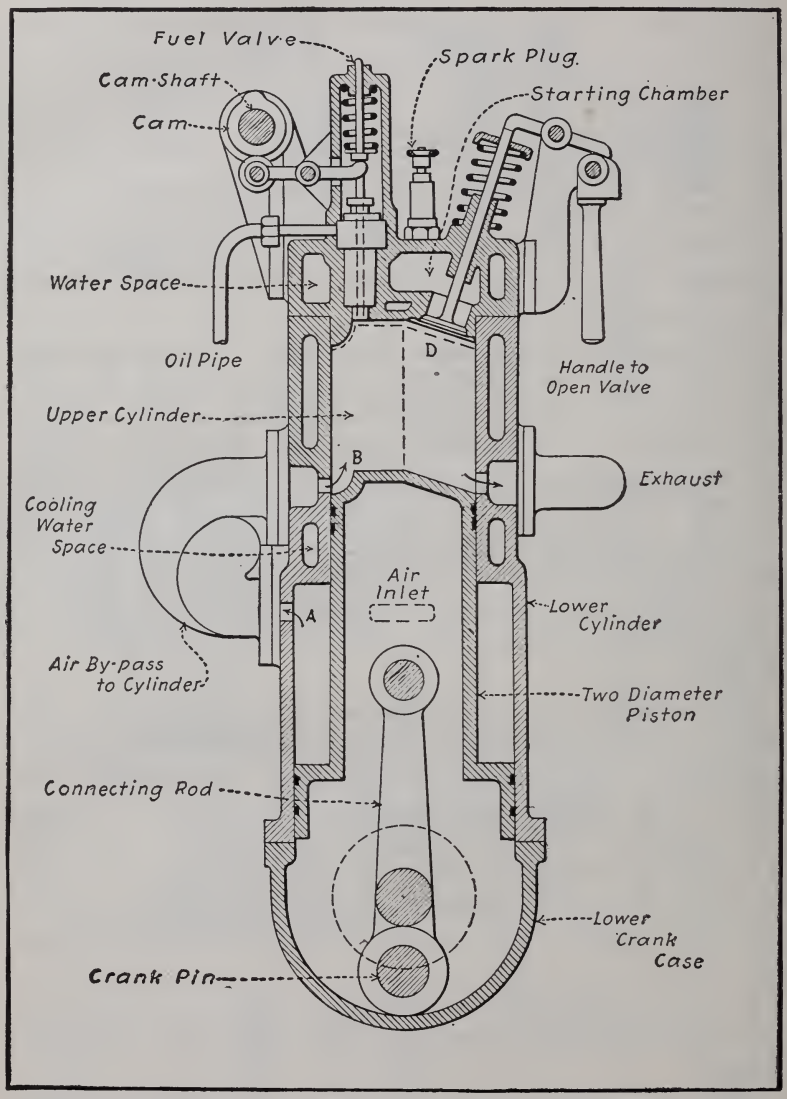


Fig. 153.—Suggested Design of Diesel Type Engine Suitable for Commercial Vehicle or Other Heavy Duty Service.

Fahr. Near the end of the stroke a quantity of fuel is injected through the fuel valve into the cylinder by means of a blast of com-

pressed air supplied from the auxiliary air compressor. The construction of the fuel valve is such that the oil is divided into a spray of fine particles. These, coming into contact with the very hot air, ignite automatically, and combustion takes place, increasing the pressure of the cylinder.

Third (down) Stroke.—The fuel valve remains open for about one-tenth of the stroke. During the portion of the stroke the pressure remains practically constant, about 600 lb. per square inch. During the remainder of the stroke the products of combustion expand. This stroke is the working stroke.

Fourth Stroke.—The return of the piston (during which time the exhaust valve is open) drives out the burnt gases. After this the cylinder starts afresh.

In the two-stroke engine, the cylinder head is similarly fitted with fuel valve and air valve for starting purposes, and with an air valve called a scavenging valve, but the exhaust valve is replaced by ports cast in the cylinder walls. In some makes of two-stroke engine, scavenging ports are also cast in the sides of the cylinder. The cycle of operations is then as follows:

When the piston is at the bottom of the stroke, the cylinder is full of air at atmospheric pressure, which air has just been admitted through the scavenging valve. During the up stroke the air is compressed to a high pressure, and attains a high temperature. At the top of the stroke, fuel is injected by the blast of air into the hot air within the cylinder, combustion takes place, and the gases expand, thus acting on the piston. When the piston has reached about six-sevenths of the down stroke, the piston commences to uncover the exhaust ports cast in the cylinder walls. The scavenger valve opens and air is admitted under low pressure, about 5 lb. per square inch, which blows out the burnt gases and fills the cylinder with air ready for the next compression stroke. Different arrangements are used by different makers for supplying the scavenging air, some makers using a separate air pump, other makers using a stepped or double piston.

In the double-acting engine the piston is attached to a piston rod which works through a gland and metallic packing at the bottom of the cylinder. A cycle of operations, similar in action to that described for the two-stroke engine, takes place at both ends of the cylinder.

Difficulties and Variations.—From the foregoing descriptions it will be seen that various difficulties arise in the design of the Diesel

engine. The engine requires to be stoutly designed, owing to the high pressure involved. The high temperatures attained make it necessary for careful attention to be given to the cooling of the various parts of the engine, and the air compressors necessary for supplying the air for starting purposes and for fuel injection, and the fuel valves themselves, all present difficulties which, although overcome in large engines, tend to put the Diesel at a great disadvantage when used for comparatively small powers.

Various makes of small-power, semi-Diesel engines have appeared which require no compressors for starting or injecting the fuel. These engines have a much lower compression than the purely Diesel engine, varying from about 120 lb. to 200 lb. per square inch, but they require blow-lamps to heat up the cylinder heads for starting purposes. On the cylinder head a bulb-shaped chamber is formed which is heated by means of the blow-lamp. Into this chamber the air drawn into the cylinder is compressed. The temperature of the air is increased by the hot bulb and by the increase of the pressure. Fuel is injected into the cylinder by means of an oil pump, and the pressure due to the combustion of the fuel acts on the piston.

Example of Modified Diesel Motor.—Various methods have been invented for reducing the compression in small motors intended to work on the Diesel cycle. One of these is illustrated herewith, showing a section through a two-stroke, two-cylinder motor having a stepped piston, the larger one acting as an air pump for scavenging.

By this particular method the invention is intended to provide a scheme by means of which the engine could be started as an ordinary gasoline engine by rotating the crankshaft. It is obvious that in an ordinary Diesel engine it would be impossible to turn the motor over the centers, owing to the high compression. Cast in the cylinder covers is a chamber *C* which can be put into communication with the working cylinder, through the valve *D*. This chamber is used for burning gasoline supplied by an ordinary carburetor and incidentally for reducing the high compression, so that the motor may be started by rotating the crankshaft. A valve is introduced in connection with the inlet valve of the motor, which may allow it to draw either pure air or a mixture from the carburetor.

To start this particular engine, the valve *D* is opened, putting chamber *C* into communication with the cylinder. A mixture of air and gasoline is drawn into chamber *A* through the air inlet on

the downstroke of the stepped piston. On the upstroke the gas is transferred into the upper part of cylinder *B* and is compressed into chamber *C*. It is ignited by means of a spark plug, and the combustion of the gas sets the engine in motion. Heavy oil is now injected into the cylinder through the fuel valve, the gasoline supply is cut off and pure air is drawn into the cylinder. Valve *D* is shut and the spark plugs are also put out of action. Exhaust takes place through ports cast in the cylinder wall. The engine is now working on the pure Diesel system.

Such a scheme could probably be applied to the hot-bulb type of motor, so that a blow-lamp could be dispensed with. The motor would use gasoline as fuel until it was sufficiently hot for combustion to take place when oil was injected into the air in the cylinder. The gasoline supply could then be cut off. After so starting the motor could be run as a hot-bulb motor.

It seems probable that if an engine is developed suitable for use on commercial vehicle chassis, it will not run on the pure Diesel cycle, but some sort of engine will be developed that can be started as an ordinary gasoline engine and afterward changed over to run on the Diesel or the hot-bulb system, or some combination of these methods. After much experience, a solution of the problem may perhaps be found along these lines, and although the difficulties are much greater than appear at first sight, the proposition is far from hopeless, seeing that Diesel and semi-Diesel engines have been adapted to other branches of employment with success.

Constant Pressure Cycle Engines.—The low thermal efficiency of internal combustion engines operating on either the conventional two or four cycle principles has started automobile engineers to think of the development of heat engines using the cheaper liquid fuels and operating on principles other than the almost universal Otto or four stroke cycle system. There are various other possible cycles among which may be mentioned the constant temperature and the constant pressure cycles. It is the general impression that the former has disadvantages of such moment that it is not worthy of much consideration. At the other hand, the constant pressure cycle has demonstrated its efficiency in large units and as it has a higher thermal efficiency than the Otto cycle it would seem that some study of engines operating on this principle could be made to advantage. The best known engine of this type is really a variation of the true constant pressure engine and has been made in many large units, and has an efficiency as high as 35%, which is considerably higher than possible to obtain with

Otto cycle. The use of Diesel engine has been previously considered and some of the disadvantages of this type when attempts are made

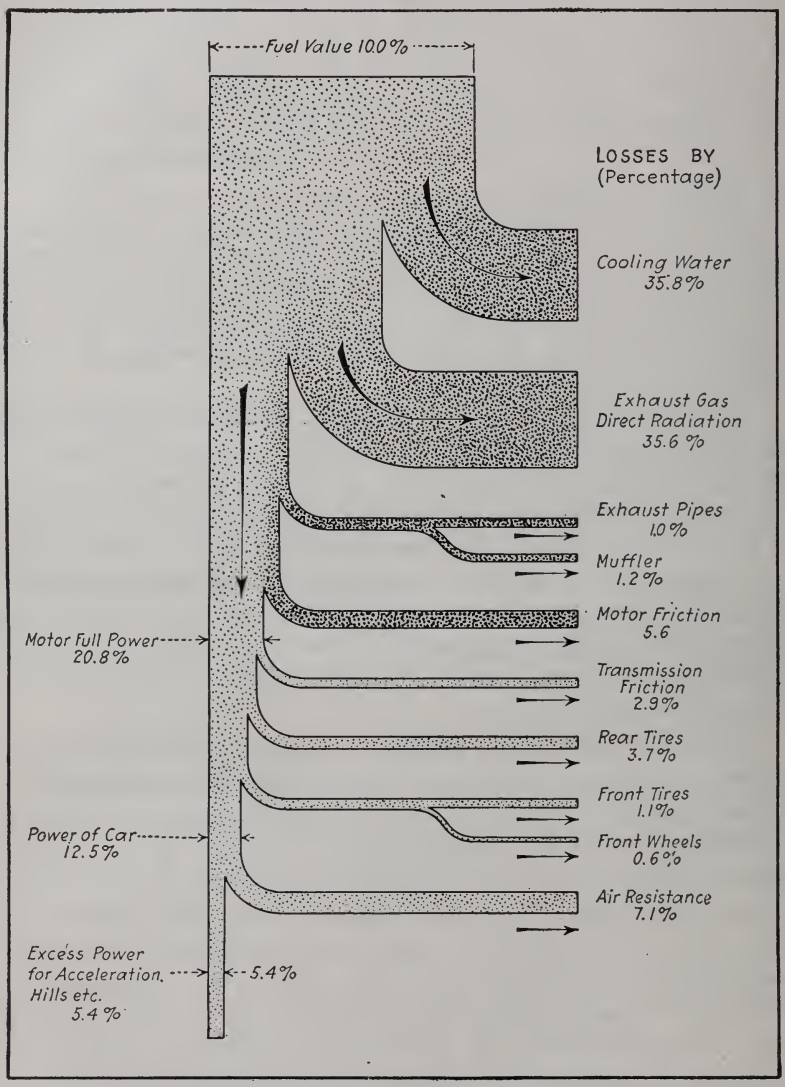


Fig. 154.—Diagram Showing Graphically the Disposition of Heat Energy Derived from the Burnt Fuel in Touring Car of Good Design when Traveling Forty Miles per Hour on Direct Drive.

to produce it in low-powered units have been considered. It is possible that study and experiment will develop semi-Diesel types that

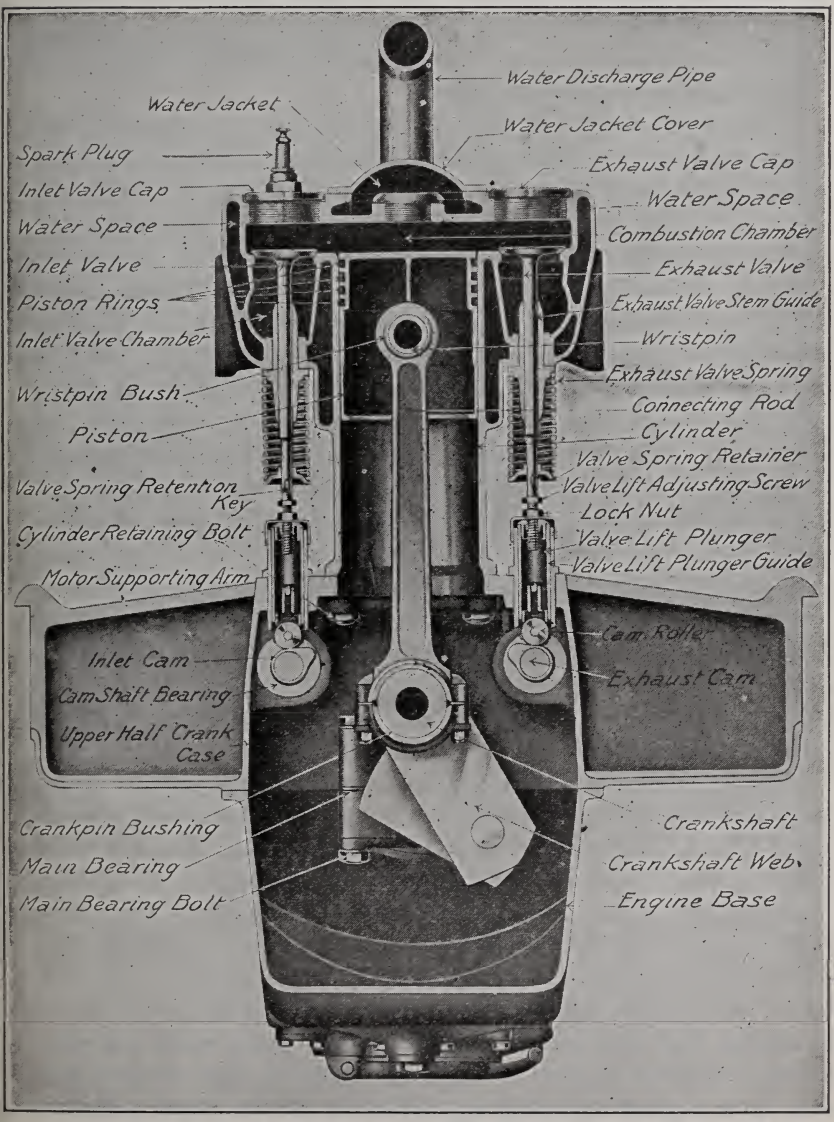


Fig. 155.—End Sectional View of Typical Internal Combustion Motor, the Prime Mover that Made the Automobile, Motorcycle, Aircraft and Motorboat Possible.

can be used successfully for vehicle propulsion. The development of electric transmission systems and the promise given by the successful types of hydraulic drives would lead one to believe that in commercial vehicles or tractor work, at least, that the constant pressure cycle engine might be successfully applied.

The main difficulty seems to be in the design of parts that will be light and yet sufficiently strong to withstand the high pressure necessary in injecting fuel against pressures much higher than ordinarily met with in automobile engines. With the high compression it is evident that gaseous mixtures cannot be used owing to pre-ignition troubles. By taking in air alone, compressing it to such a high degree where it is sufficiently hot to ignite injected fuel, it is possible to attain a higher thermal efficiency, and inasmuch as the fuel is admitted in successive small quantities, the power will endure during the greater part of the power stroke and will be due to a series of impulses, due to burning, rather than the single violent shock or high explosive pressure produced at the time of explosion in the four-cycle engine where the mixture is compressed to never more than 100 lbs. per square inch. The mean effective pressure in the Otto cycle engine results in having the maximum pressure as close to the inception of the power stroke as possible and as a result, with the small throttle opening used in operating a car at speeds under 20 miles per hour these mean effective pressures fall off faster than the resulting diminishment in the fuel consumption justifies. This, of course, produces relatively low thermal efficiency.

It is believed that if the constant pressure engine can be refined and developed to give high efficiency at speeds comparable to average automobile driving speeds that it will be possible to make a material reduction in the cost of operation because the cheaper, non-volatile fuels can be used instead of the more expensive liquids that evaporate readily and which are absolutely necessary where liquid vapor is drawn into the cylinder and compressed before ignition. It is believed that in the light of present-day developments, such as the knowledge that now obtains relative to high grade steels and other metals and alloys of great strength and lightness, that constant pressure cycle engines operating approximately on the Diesel principles will be developed that will not be impractical on industrial vehicles. In order to enable the reader to understand the low thermal efficiency of the type of engine ordinarily used, the graphic diagram at Fig. 154 is presented to show the heat losses in an average Otto cycle engine. It will be apparent that 20% of the heat obtained by the explosion is available for useful work. With gasoline selling at 24 cents

per gallon the cost of operation is $0.03 per horsepower hour. With a Diesel type engine it is possible to use a fuel oil that will not cost over $.03 per gallon, which brings the cost of operation down to about $0.0035 per horsepower hour.

CHAPTER III

CYLINDER CONSTRUCTION AND VALVE SYSTEMS

Methods of Cylinder Construction—Individual Cylinder Castings—Block Casting Advantages—Removable Head Construction—Water Jackets Cast Integral—Influence on Crank Shaft Design—Combustion Chamber Design—Bore and Stroke Ratio—Meaning of Piston Speed—Advantages of Off-set Cylinders—Influence of Cylinder Construction on Engine Design—Valve Location of Vital Import—"T" Head Construction—"L" Head Construction—Valve-in-the-Head Types—Concentric Valves—Valve Design and Construction—Composite Construction—Valve Operation—Cam Forms—Valve Lift Plungers—Valve Operating Means—Valve Placing Methods Reviewed—Methods of Driving Cam Shaft—Silent Chain Drive—New Valve Operating Systems—Overhead Camshafts—Positively Closed Valves—Valves Operated by Drum Cams—Why Four Valves Per Cylinder Give More Power—Novel Sixteen Valve Designs—Unconventional Valve Arrangement—Piston and Rotary Valve Motors—Slide Valve Motors—Miesse Engine—Itala Rotary Valve Motor—Reynolds Rotary Valve Design—Miscellaneous Rotary Valve Forms—Rotary Cone Valve of Carbon—Sphinx Ring Valve Motor—Darracq Rotary Distributor Motor—Hewitt Piston Valve Motor—Fischer Slide Valve Motor—Valve Timing—Blowing Back—Exhaust Closing, Inlet Opening—Closing the Inlet Valve—Time of Ignition—Typical Timing Diagrams.

The improvements noted in the modern internal combustion motors have been due to many conditions. The continual experimenting by leading mechanical minds could have but one ultimate result. The parts of the engines have been lightened and strengthened, and greater power has been obtained without increasing piston displacement. A careful study has been made of the many conditions which make for efficient motor action, and that the main principles are well recognized by all engineers is well shown by the standardization of design noted in modern power plants. There are many different methods of applying the same principle, and it will be the purpose of this chapter to define the ways in which the construction may be changed and still achieve the same results. The various components may exist in many different forms, and all have their advantages and disadvantages. That all methods are practical is best shown by the large number of successful cars which use radically different designs.

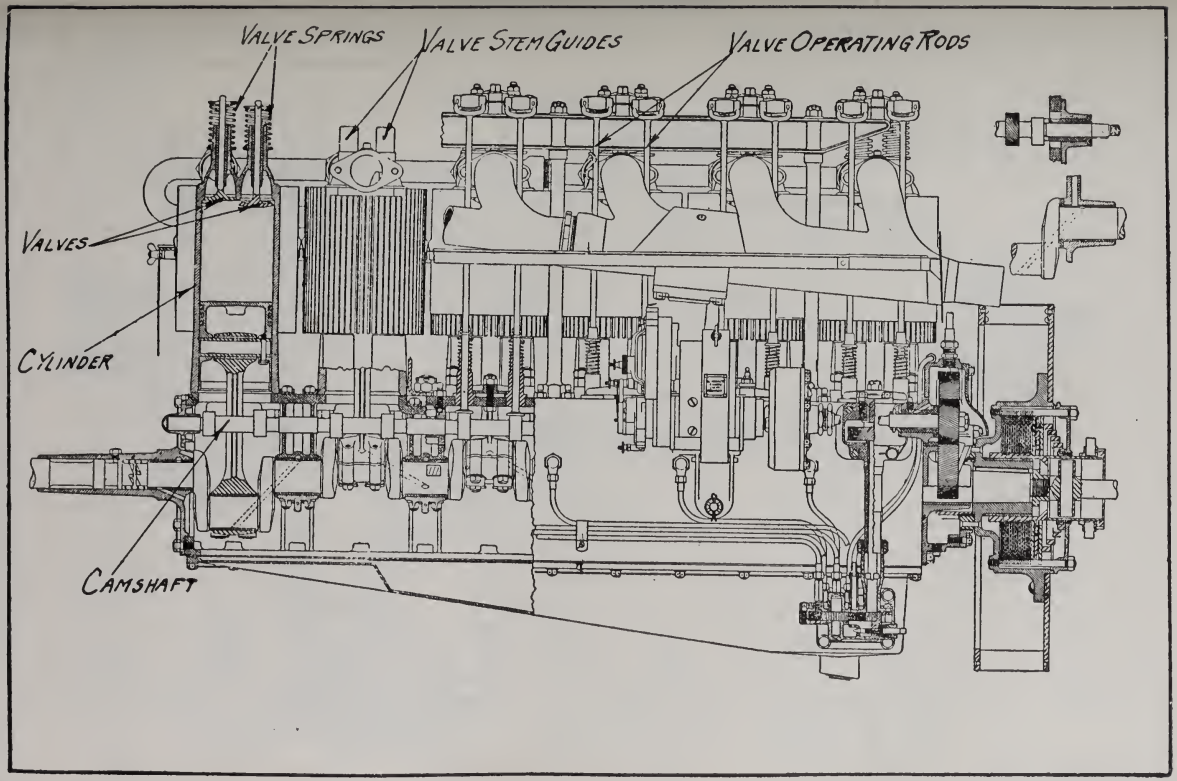


Fig. 156.—Part Sectional View of Franklin Six-Cylinder Air-Cooled Engine, Showing Unconventional Valve Installation.

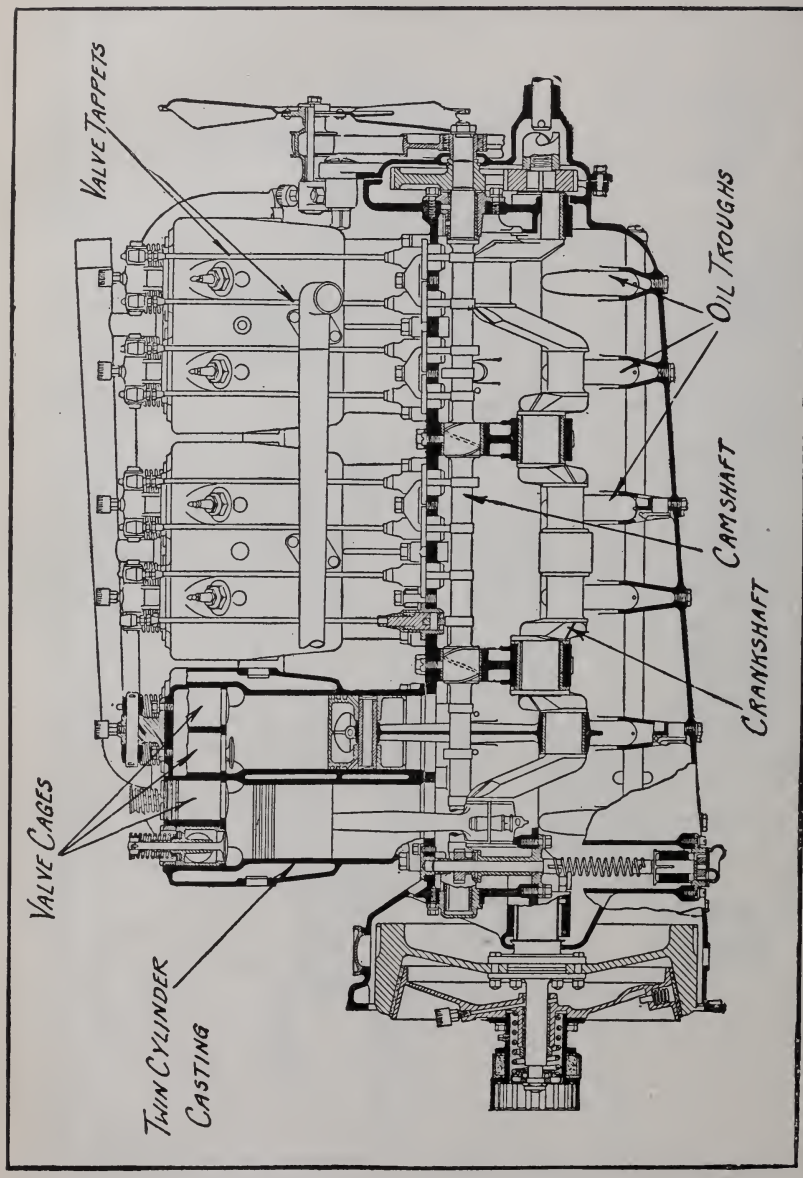


Fig. 157.—Part Sectional View of Six-Cylinder Buick Motor, Showing Cylinders Cast in Pairs and Method of Valve Installation and Operation.

Methods of Cylinder Construction.—One of the most important parts of the gasoline engine and one that has material bearing upon its efficiency is the cylinder unit. Of late there has been a tendency to depart from the previous methods of casting the cylinders individually, or in pairs, and make all cylinders a unit or block casting. Some typical methods of cylinder construction are shown at Figs. 156 to 163. The appearance of individual cylinder castings of the air-cooled type are shown at Fig. 156. In the Buick engine, shown at Fig. 157, the cylinder and cylinder head are cast integral and the valves are supported by inserted cages. In some cylinder designs described in proper sequence, the head member is a separate casting from that forming the cylinder, and the valves seat directly in this member. It is held to the cylinder by means of numerous bolts. The cylinder casting shown at Fig. 158 comprises two cylinders and is the now un-

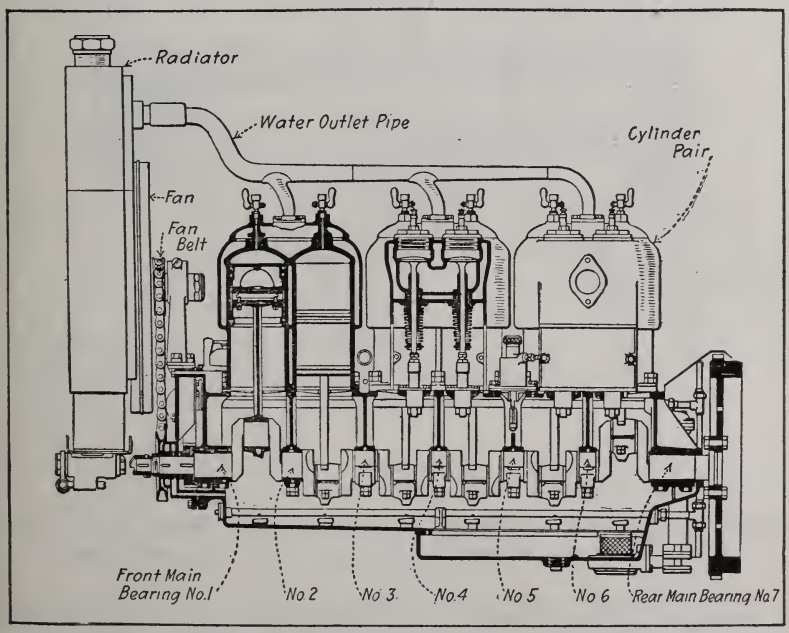


Fig. 158.—Sectional View of Locomobile 1917 Six-Cylinder Engine, Showing the Method of Casting the Cylinders in Pairs and Installation of Seven-Bearing Crankshaft.

usual form used in high-powered engines. That at Fig. 160 is a block casting in which the six cylinders are cast together and conforms to up-to-date practice.

Considered from a purely theoretical point of view, the individual

cylinder casting has much in its favor, especially on air-cooled engines. It is advanced that more uniform cooling is possible than where the cylinders are cast either in pairs or three or four in one casting. More uniform cooling insures that the expansion or change of form due to heating will be more equal. This is an important condition because the cylinder bore must remain true under all conditions of operation. If the heating effect is not uniform, which condition is liable to obtain if metal is not evenly distributed, the cylinder may become distorted by heat and the bore be out of truth. When separate cylinders are used it is possible to make a uniform water space and have the cooling liquid evenly distributed around the cylinder. In multiple cylinder castings this is not always the rule, as in many instances, especially in four- and six-cylinder block motors where compactness is the main feature, there is but little space between the cylinders for

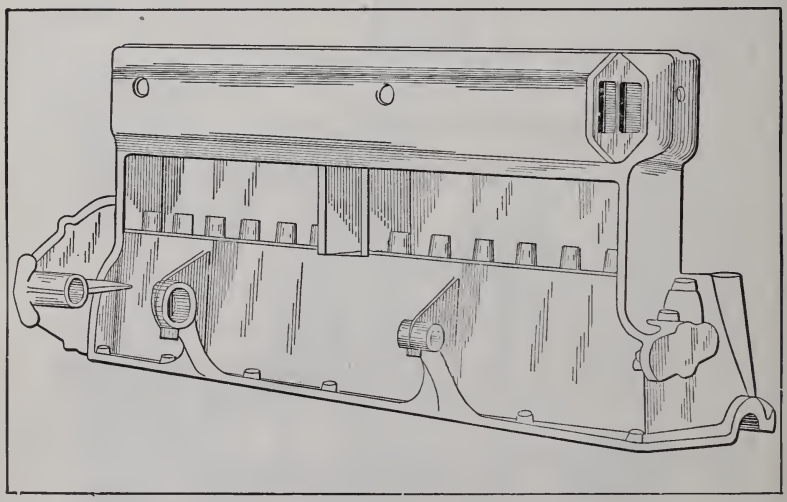


Fig. 159.—Modern Block Casting, in which Six Cylinders, Upper Part of Crank Case and Inlet and Exhaust Manifold are Included in One Casting.

the passage of water. Under such circumstances the cooling effect is not even, and the stresses which obtain because of unequal expansion may distort the cylinder to some extent.

The advantage of casting the cylinders in blocks is that a motor may be much shorter than it would be if individual castings were used. It is admitted that when the cylinders are cast together a more compact, rigid, and stronger power plant is obtained than when cast separately. There is a disadvantage, however, in that if one cylinder becomes damaged it will be necessary to replace the entire

unit, which means scrapping three or more good cylinders because one of the four has failed. When the cylinders are cast separately one need only replace that one that has become damaged. The casting of four or six cylinders in one unit is made possible by improved foundry methods, and when proper provision is made for holding the cores when the metal is poured and the cylinder casts are good, the construction is one of distinct merit. It is sometimes the case that the

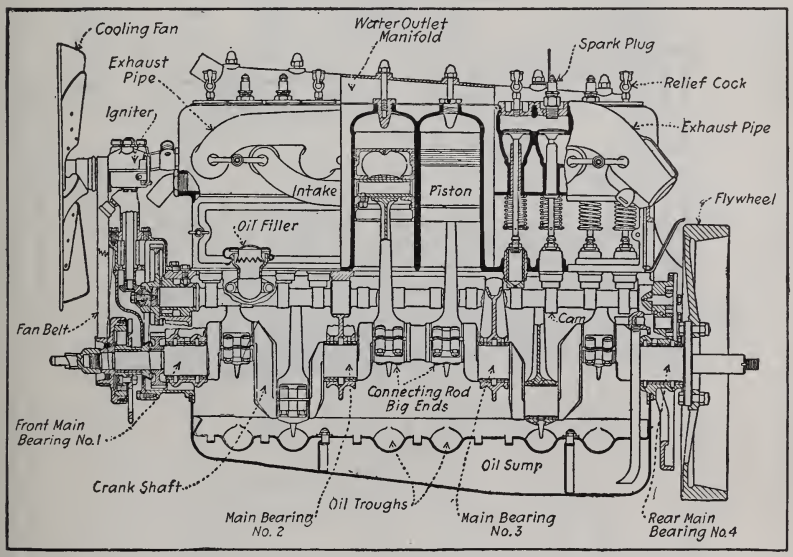


Fig. 160.—Part Sectional View of Studebaker Six Cylinder, Showing Cylinder and Cylinder Head Cast Integral; also Four-Bearing Crankshaft.

proportion of sound castings is less when cylinders are cast in block, but if the proper precautions are observed in molding and the proper mixtures of cast iron used, the ratio of defective castings is no more than when cylinders are molded individually. As an example of the courage of modern motor-car engineers in departing from old-established rules, the cylinder casting shown at Fig. 159 may be considered typical. This is a remarkable departure from standard construction, because not only the six cylinders are cast in a block but the upper part of the engine base and the inlet and exhaust manifold are also included in the one casting.

Removable Head Construction.—A method of construction which is attracting some attention at the present time is that shown at Fig. 161. This is a six-cylinder motor in which the six cylinders and the top half of the crank case are cast together, but employs a separately

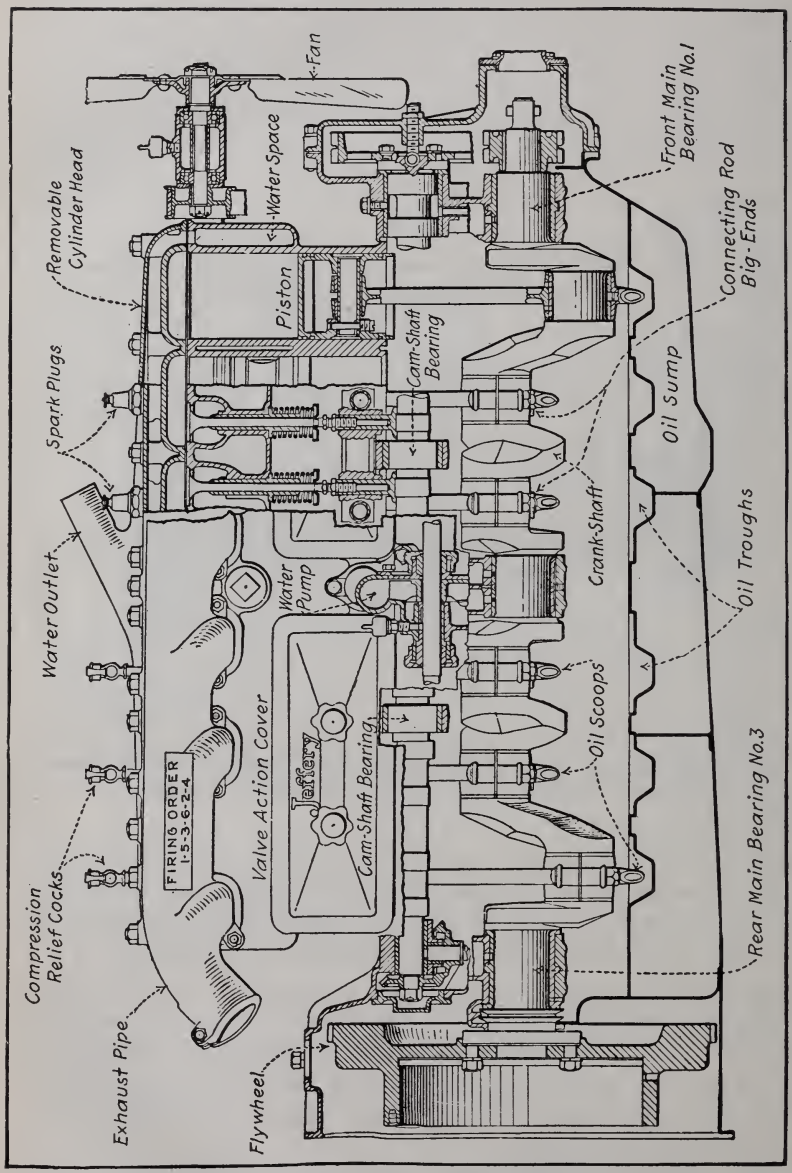


Fig. 161.—Part Sectional View of Jeffery Six-Cylinder Block Motor, Showing Detachable Cylinder Head and Three-Bearing Crankshaft.

cast head member which is common to all cylinders. This is held to the cylinder casting by means of a series of bolts, and a copper-asbestos gasket, or packing, is utilized in making a gas- and water-tight joint between the parts. The advantage of this construction is that it permits ready access to pistons and valves without dismantling the entire motor, as is necessary when the conventional form of cylinder casting is employed. This type of construction is also used on many

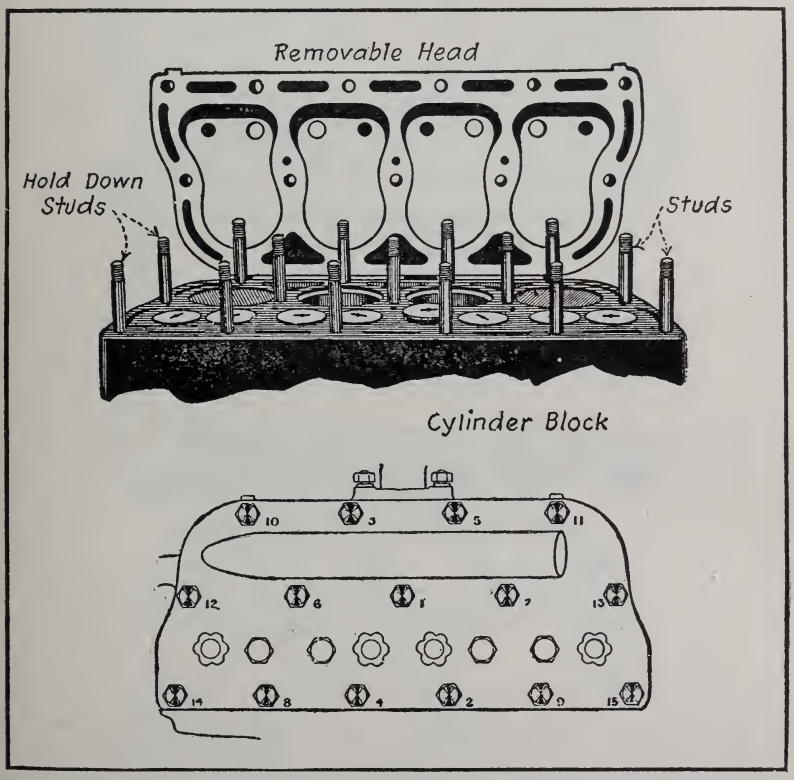


Fig. 162.—Illustration at Top Shows Head Removed from Cylinder Block. That Below Shows the Order in which the Bolts Should Be Tightened when Replacing Head.

motors of the four-cylinder type as outlined at Fig. 163. In some of the eight-cylinder type engines four cylinders and a portion of the crankcase are cast together, as shown at Fig. 164. In one eight-cylinder engine, the eight cylinders and upper portion of the crankcase are combined in one casting.

Water Jackets Cast Integral.—It is common practice to cast the water jackets integral with the cylinders, and this is also the most

economical method of applying it because it gives good results in practice. An important detail is that the water spaces must be proportioned so that they are equal around the cylinders whether these members are cast individually, in pairs, in threes or fours. When cylinders are cast in block form it is good practice to leave a large opening in the jacket wall, which will assist in supporting the core and make for uniform water space. These openings are closed after the

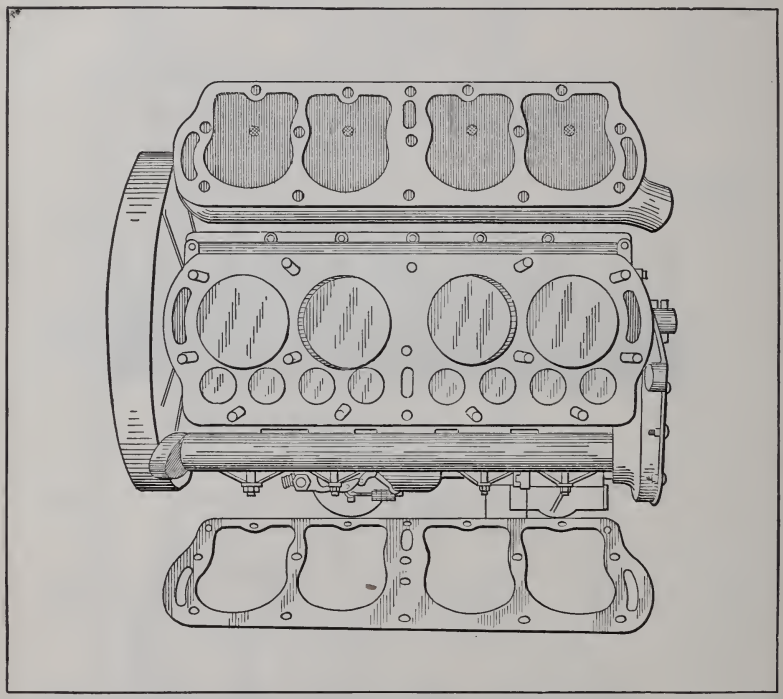


Fig. 163.—Example of Four-Cylinder Block Motor, Having One Separately Cast Head Member, Common to All Cylinders. A Copper-Asbestos Gasket is Utilized in Making a Gas- and Water-tight Joint Between the Parts. Note Accessibility of Pistons and Valves.

interior of the casting is thoroughly cleaned of all sand, core wire, etc., by brass, cast iron or aluminum plates. These also have particular value in that they may be removed after the motor has been in use, thus permitting one to clean out the interior of the water jacket and dispose of the rust, sediment, and incrustation which are always present after the engine has been in active service for a time.

Among the advantages claimed for the practice of casting cylinders in blocks may be mentioned compactness, lightness, rigidity, simplic-

ity of water piping, as well as permitting the use of simple forms of inlet and exhaust manifolds. The light weight is not only due to the

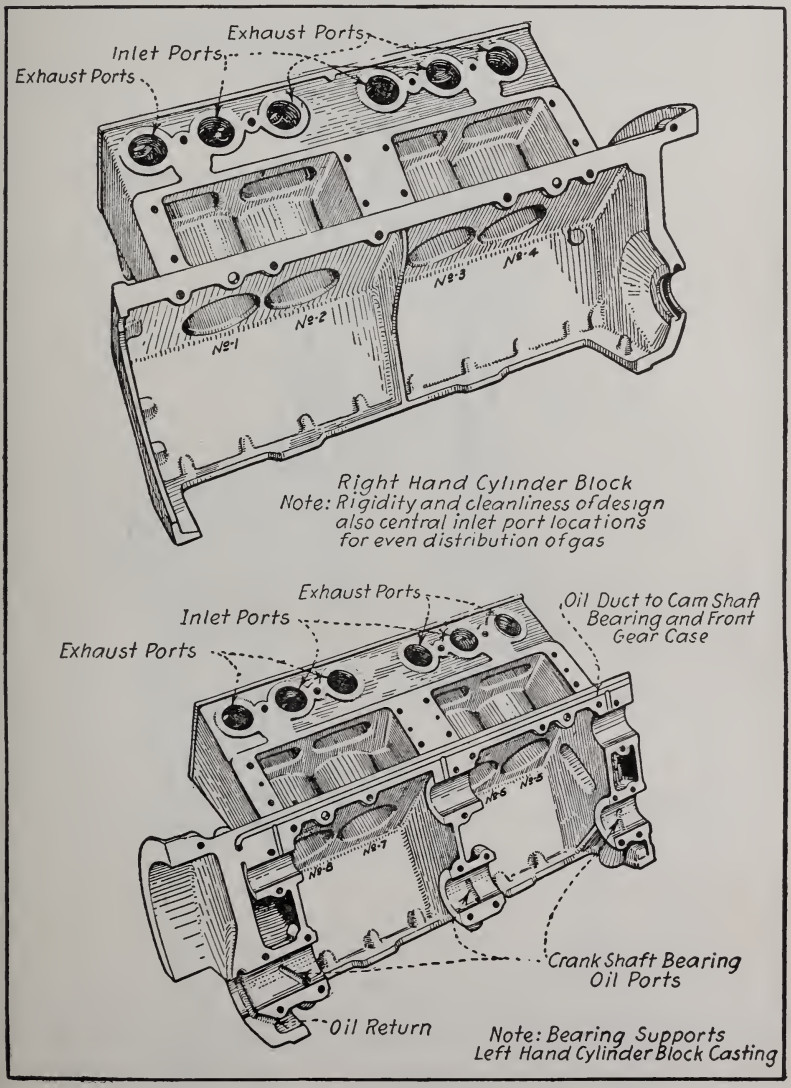


Fig. 164.—Views Showing Right and Left Hand Cylinder Block Casting of Cole Eight-Cylinder Motor, Showing Method of Combining Cylinder Block with Portions of Upper Part of Crank Case.

reduction of the cylinder mass but because the block construction permits one to lighten the entire motor. The fact that all cylinders are

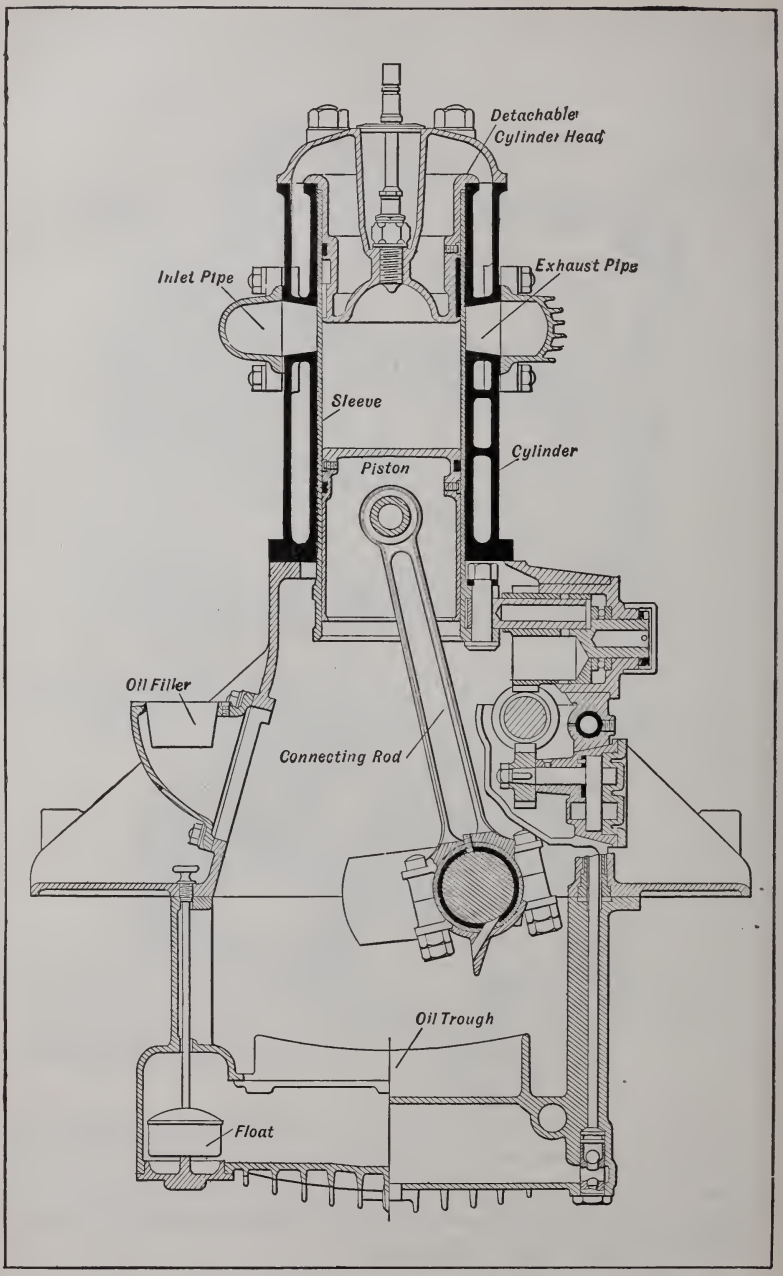


Fig. 165.—Showing Separate Head Construction of Argyl Sleeve Valve Motor Made Necessary by Use of Sleeve.

cast together decreases vibration, and as the construction is very rigid, disalignment of working parts is practically eliminated. When inlet and exhaust manifolds are cored in the block casting, as is sometimes the case, but one joint is needed on each of these instead of the multiplicity of joints which obtain when the cylinders are individual castings. The water piping is also simplified. In the case of a four-

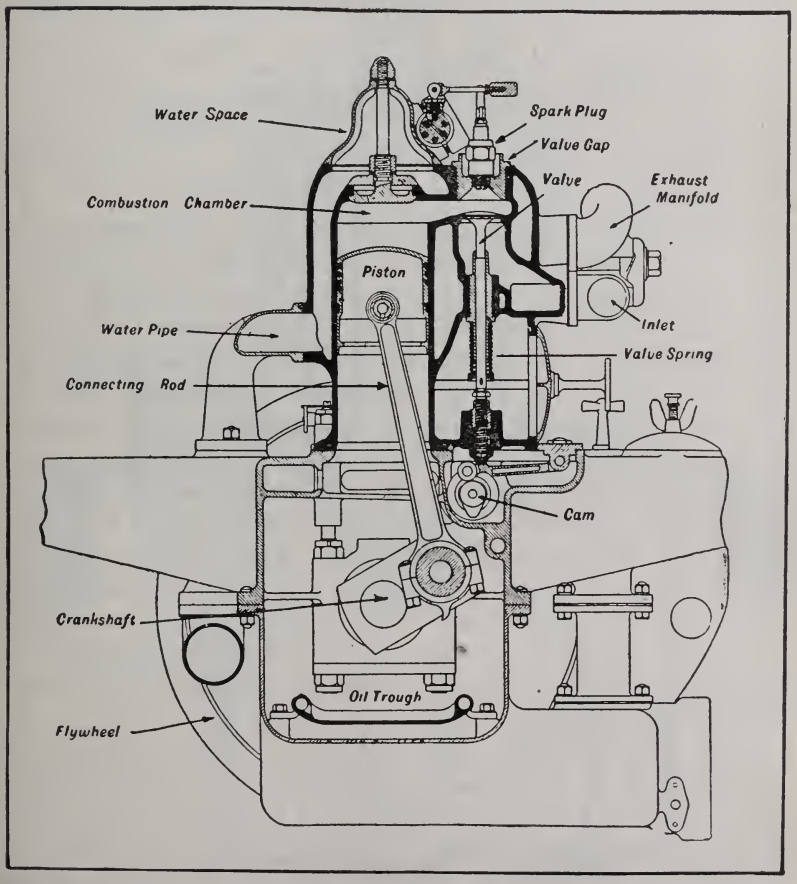


Fig. 166.—Section Through Sheffield Simplex (English) Engine, Presented to Show Excellent Proportions of Water Jacket Spaces and Easy Gas Passages Leading to Valve Chest.

cylinder block motor but two pipes are used; one for the water to enter the cylinder jacket, the other for the cooling liquid to discharge through.

Influence on Crankshaft Design.—The method of casting the cylinders has a material influence on the design of the crank shaft, as will

be shown in proper sequence. When four cylinders are combined in one block it is possible to use a two-bearing crank shaft. Where cylinders are cast in pairs a three-bearing crank shaft is commonly supplied, and when cylinders are cast as individual units it is thought necessary to supply a five-bearing crank shaft, though sometimes shafts having but three journals are used successfully. Obviously the shafts must be stronger and stiffer to withstand the stresses imposed if two supporting bearings are used than if a larger number are employed. In this connection it may be stated that there is less difficulty in securing alignment with a lesser number of bearings and there is also less friction. At the other hand, the greater the number of points of support a crank shaft has the lighter the webs can be made and still have requisite strength.

Combustion Chamber Design.—Another point of importance in the design of the cylinder and one which has considerable influence upon the power developed is the shape of the combustion chamber. The endeavor of designers is to obtain maximum power from a cylinder of certain proportions, and the greater energy obtained without increasing piston displacement or fuel consumption the higher the efficiency of the motor. To prevent troubles due to preignition it is necessary that the combustion chamber be made so that there will be no roughness, sharp corners, or edges of metal which may remain incandescent when heated or which will serve to collect carbon deposits by providing points of anchorage. With the object of providing an absolutely clean combustion chamber some makers use a separable head unit such as shown at Figs. 163 and 165. These permit one to machine the entire interior of the cylinder and combustion chamber. The relation of valve location and combustion chamber design will be considered in proper sequence.

Bore and Stroke Ratio.—A question that has been a vexed one and which has been the subject of considerable controversy is the proper proportion of the bore to the stroke. The early gas engines had a certain well-defined bore to stroke ratio, as it was usual at that time to make the stroke twice as long as the bore was wide, but this cannot be done when high speed is desired. With the development of the present-day motor the stroke or piston travel has been gradually shortened so that the relative proportions of bore and stroke have become nearly equal. Of late there seems to be a tendency among designers to return to the proportions which formerly obtained and the stroke is sometimes one and a half or one and three-quarter times the bore.

Engines designed for high speed should have the stroke not much longer than 1½ times the diameter of the bore. The disadvantage

of short-stroke engines is that they will not pull well at low speeds, though they run with great regularity and smoothness at high velocity. The long-stroke engine is much superior for slow speed work, and it will pull steadily and with increasing power at low speed. It was formerly thought that such engines should never turn more than a

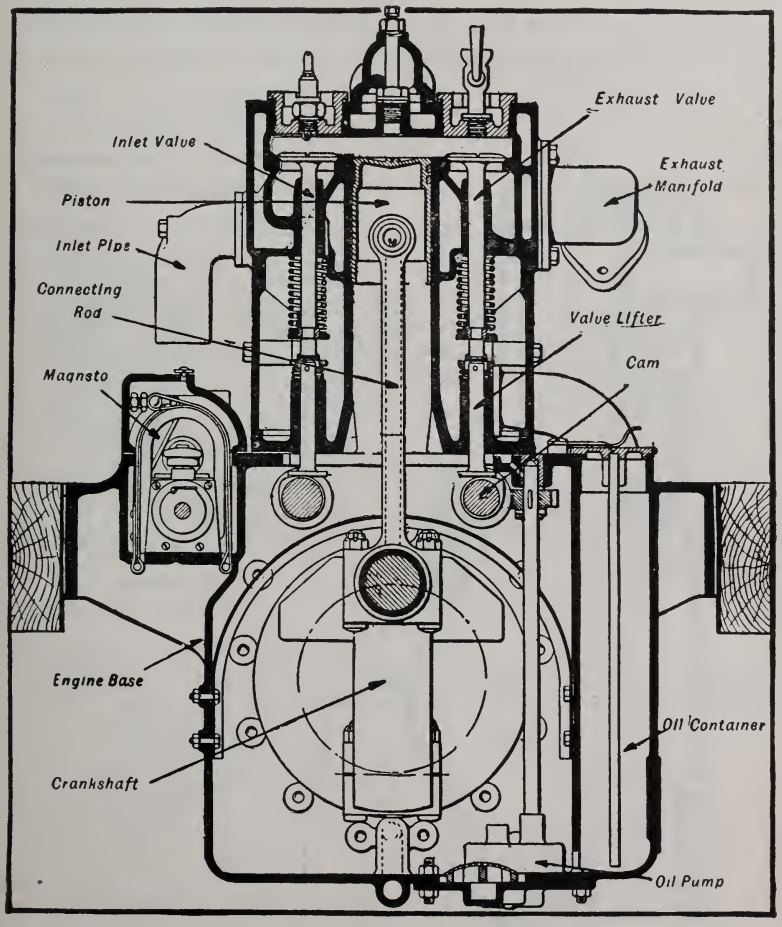


Fig. 167.—Section Through Sizaire-Naudin (French) Motor, Showing a Typical Small Bore, Long-Stroke High-Speed Design.

moderate number of revolutions in order not to exceed the safe piston speed. While both short- and long-stroke motors have their advantages it would seem desirable to average between the two. That is why a proportion of four to five or six seems to be more general than that of four to seven or eight, which would be a long-stroke ratio. At Fig.

167 a section through the cylinder of a Sizaire-Naudin motor is shown. This illustrates a typical small-bore, long-stroke design which has worked very well, even at high speeds. That at Fig. 168 is also a long-stroke type.

Meaning of Piston Speed.—The factor which limits the stroke and makes the speed of rotation so dependent upon the travel of the piston is piston speed. Heretofore, it has been considered desirable not to exceed a speed of one thousand feet per minute, which has been determined to make for greatest efficiency, combined with endurance, by many authorities on design and construction of internal combustion motors. During the past few years there have been instances where engines were giving satisfactory service with piston speed of 1,200 to 1,500 feet per minute. Lubrication is the main factor which determines piston speed, and the higher the rate of piston travel the greater care must be taken to insure proper oiling. Let us fully consider what is meant by piston speed.

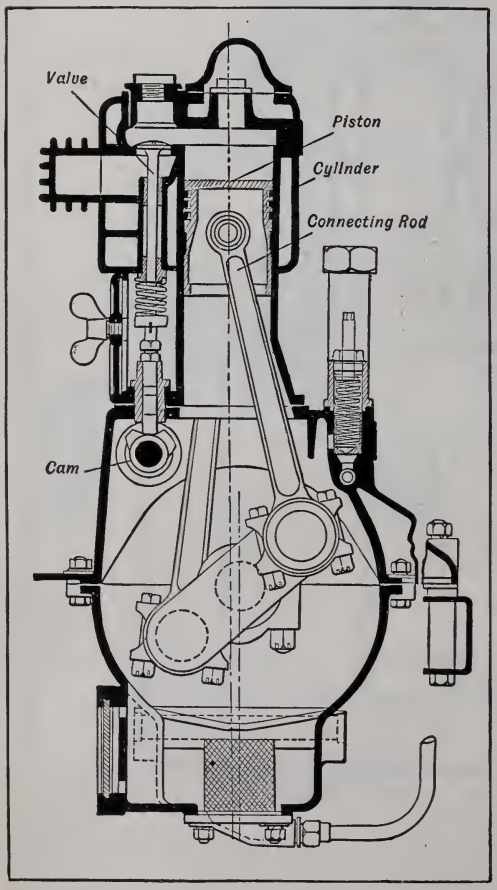


Fig. 168.—End View Humber (English) Motor, Depicting Off-set Cylinder Construction.

Assume that a motor has a piston travel or stroke of six inches, for the sake of illustration. It would take two strokes of the piston to cover one foot, or twelve inches, and as there are two strokes to a revolution it will be seen that this permits of a normal speed of 1,000 revolutions per minute for an engine with a six-inch stroke. If the stroke was only four inches, a normal speed of 1,500 revolutions per

minute would be possible without exceeding the prescribed limit. The crank shaft of a small engine, having three-inch stroke, could turn at a speed of 2,000 revolutions per minute without danger of exceeding the safe speed limit. It will be seen that the longer the stroke the slower the speed of the engine, if one desires to keep the piston speed within the bounds as recommended.

Advantages of Off-set Cylinders.—Another point upon which considerable difference of opinion exists relates to the method of placing the cylinder upon the crank case—i. e., whether its center line should be placed directly over the center of the crank shaft, or to one side of center. The motor shown at Fig. 168 is an off-set type, in that the center line of the cylinder is a little to one side of the center of the

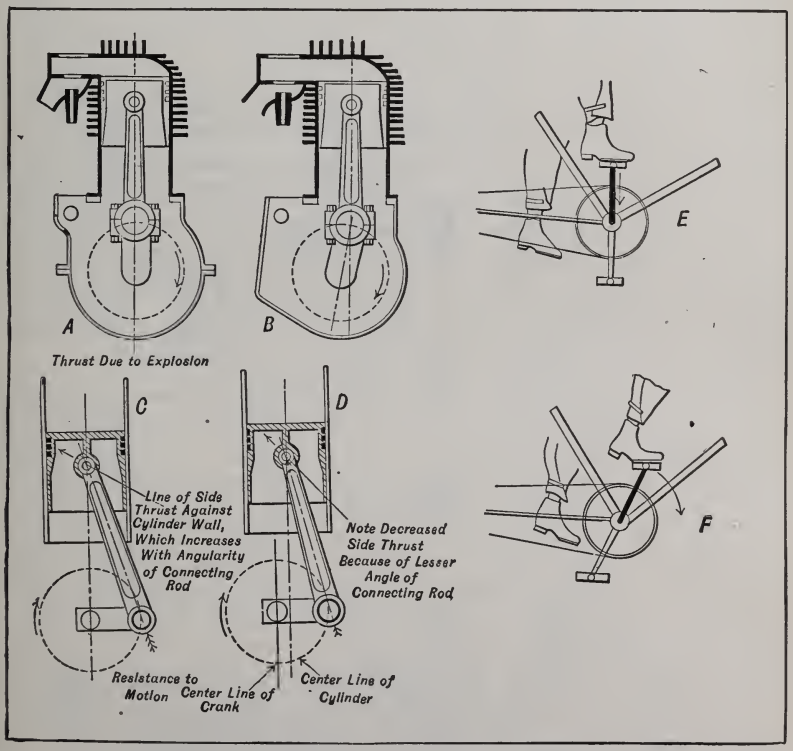


Fig. 169.—Diagrams Demonstrating Advantages of Off-set Crankshaft Construction.

crank shaft. Diagrams are presented at Fig. 169 which show the advantages of off-set crank-shaft construction. The view at A is a section through a simple motor with the conventional cylinder placing, the center line of both crank shaft and cylinder coinciding. The view

at B shows the cylinder placed to one side of center so that its center line is distinct from that of the crank shaft and at some distance from it. The amount of off-set allowed is a point of contention, the usual amount being from fifteen to twenty-five per cent of the stroke. The advantages of the off-set are shown at Fig. 169, C. If the crank turns in direction of the arrow there is a certain resistance to motion which is proportional to the amount of energy exerted by the engine and the resistance offered by the load. There are two thrusts acting against the cylinder wall to be considered, that due to explosion or expansion of the gas and that which resists the motion of the piston. These thrusts may be represented by arrows, one which acts directly in a vertical direction on the piston top, the other along a straight line through the center of the connecting rod. Between these two thrusts one can draw a line representing a resultant force which serves to bring the piston in forcible contact with one side of the cylinder wall, this being known as side thrust. As shown at C, the crank shaft is at 90 degrees or about one-half stroke and the connecting rod is at 20 degrees angle. The shorter connecting rod would increase the diagonal resultant and side thrusts while a longer one would reduce the angle of the connecting rod and the side thrust of the piston would be less. With the off-set construction, as shown at D, it will be noticed that with the same connecting rod length as shown at C and with the crank shaft at 90 degrees of the circle that the connecting rod angle is 14 degrees and the side thrust is reduced proportionately.

Another important advantage is that greater efficiency is obtained from the explosion with an off-set crank shaft, because the crank is already inclined when the piston is at top center and all the energy imparted to the piston by the burning mixture can be exerted directly into producing a useful turning effort. When a cylinder is placed directly on a line with the crank shaft, as shown at A, it will be evident that some of the force produced by the expansion of the gas will be exerted in a direct line and until the crank moves the crank throw and connecting rod are practically a solid member. The pressure which might be employed in obtaining useful turning effort is wasted by causing a direct pressure upon the lower half of the main bearing and the upper half of the crank-pin bushing.

Very good and easily understood illustrations showing advantages of the off-set construction are shown at E and F. This is a bicycle crank hanger. It is advanced that the effort of the rider is not as well applied when the crank is at position E as when it is at position F. Position E corresponds to the position of the parts when the cylinder is placed directly over the crank-shaft center. Position F may be

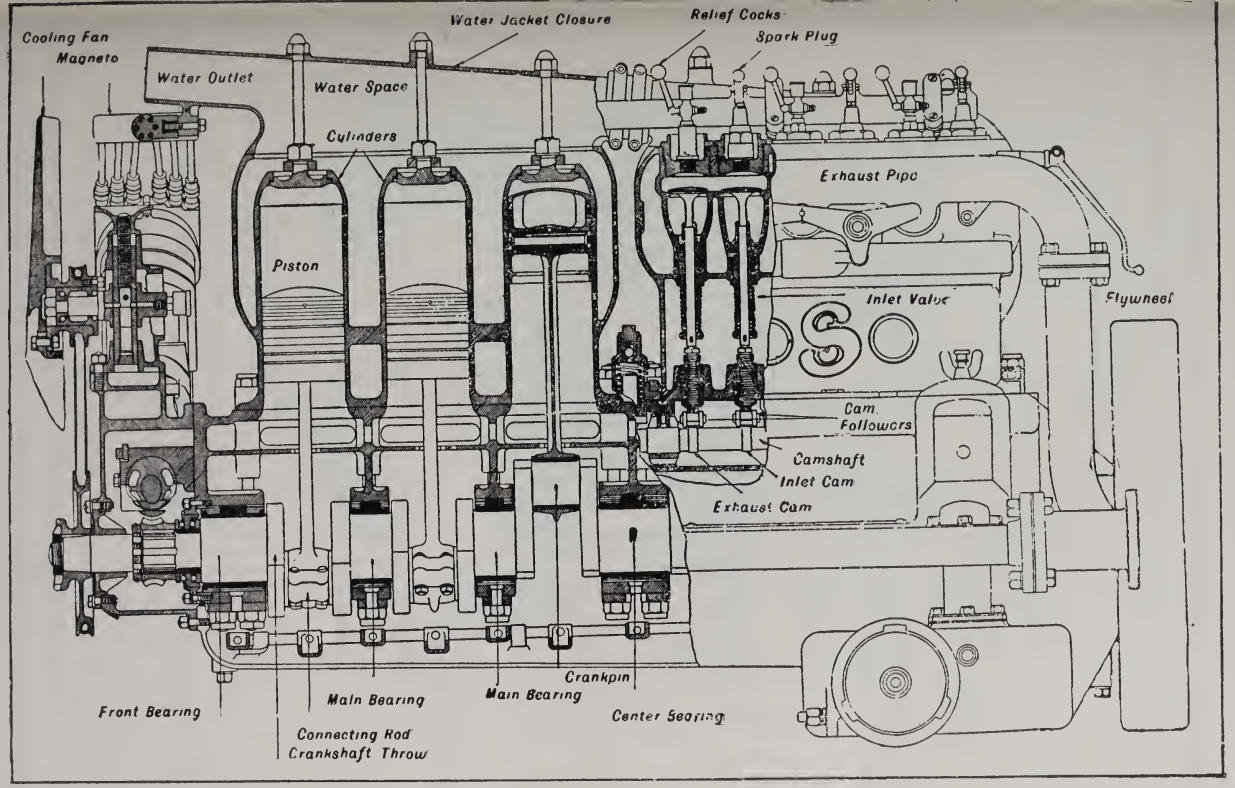


Fig. 170.—Part Sectional View of Sheffield Simplex Six-Cylinder Motor, Showing Use of Three-Cylinder Block Castings, Seven-Bearing Crankshaft and Other Constructional Details. Note Exceptionally Good Water Jacketing of Cylinders.

compared to the condition which is present when the off-set cylinder construction is used.

Influence of Cylinder Construction on Engine Design.—To show the manner in which the various methods of casting cylinders previously defined may alter engine design some views of typical power plants are presented. That at Fig. 170 is a part sectional view of the Sheffield Simplex, an English six-cylinder motor. In this the cylinders are cast in blocks of three, and the motor is composed of two blocks. A seven-bearing crank shaft is used, there being a journal between each pair of cylinders in addition to the two end members. A feature of this power plant that may be commended is the exceptionally good water jacketing of the cylinders. The water spaces are large and all parts of the cylinder are surrounded by cooling liquid.

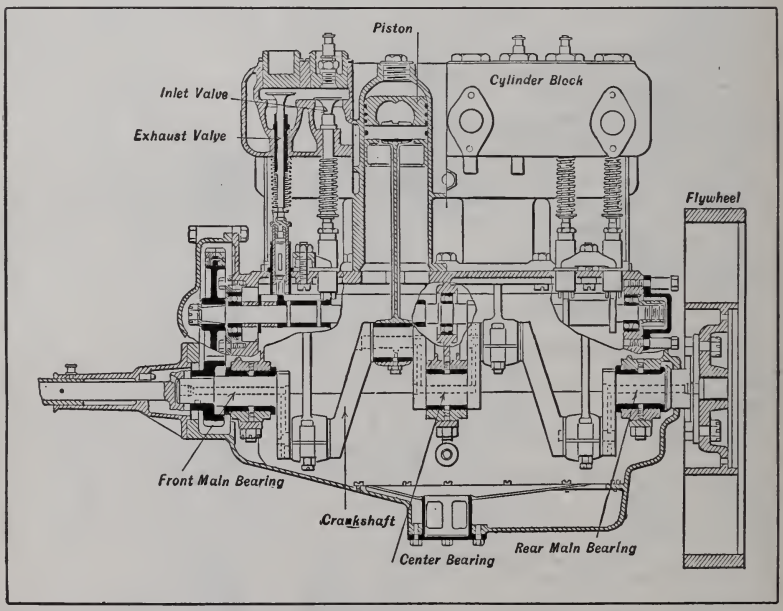


Fig. 171.—Section Through Typical Four-Cylinder Block Motor with Three-Bearing Crankshaft.

At Fig. 171 a section through a typical four-cylinder block motor is given. In this power plant a short crank case is used, but the crank shaft is supported on three bearings instead of two journals as is common practice with four-cylinder motors. To show the use of individual castings the motors shown at Figs. 156 and 172 are valuable. It will be evident that if these are compared to Fig. 171 that the motor

will have a greater overall length than when all cylinders are cast in one block. There are a number of other constructional details dependent upon cylinder design which merit detailed description, such as valve placing and operation, crank case design, etc., but these are of sufficient importance to be discussed in a more comprehensive manner and will be considered separately.

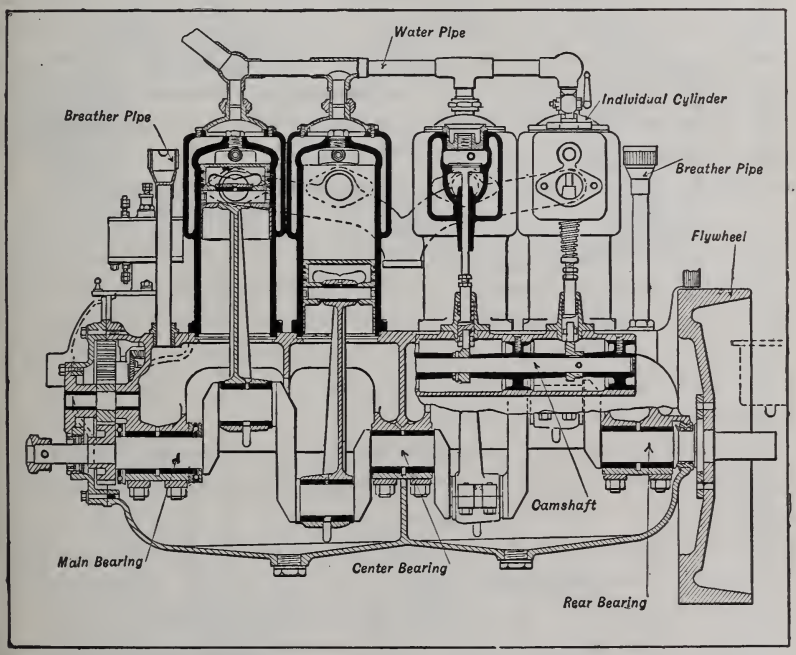


Fig. 172.—Sectional View of Typical Four-Cylinder Motor Using Individual Cylinder Castings with Head Cast Integral. General Design Fair, Excepting that of Off-set Connecting Rod Big Ends.

Valve Location of Vital Import.—It has often been said that a chain is no stronger than its weakest link and this is as true of the explosive motor as it is of any other piece of mechanism. Many motors which appeared to be excellently designed and which were well constructed did not prove satisfactory, because some minor detail or part had not been properly considered by the designer. A factor having material bearing upon the efficiency of the internal combustion motor is the location of the valves and the shape of the combustion chamber which is largely influenced by their placing. The fundamental consideration of valve design is that the gases be admitted and discharged from the cylinder as quickly as possible in order that the speed of gas flow will

not be impeded and produce back pressure. This is imperative in obtaining satisfactory operation in any form of motor. If the inlet passages are constricted the cylinder will not fill with explosive mixture promptly, whereas if the exhaust gases are not fully expelled the parts of the inert products of combustion retained dilute the fresh charge, making it slow burning and causing lost power and overheating. When an engine employs water as a cooling medium this substance will absorb the surplus heat readily, and the effects of overheating are not noticed as quickly as when air-cooled cylinders are employed. Valve sizes have a decided bearing upon the speed of motors and some valve locations permit the use of larger members than do other positions.

While piston velocity is an important factor in determinations of power output it must be considered from the aspect of the wear produced upon the various parts of the motor. It is evident that engines which run very fast, especially of high power, must be under a greater strain than those operating at lower speeds. The valve-operating mechanism is especially susceptible to the influence of rapid movement, and the slower the engine the longer the parts will wear and the more reliable the valve action.

As will be seen by reference to the accompanying illustrations, there are many ways in which valves may be placed in the cylinder. Each method outlined possesses some point of advantage because all of the types illustrated are used by reputable automobile manufacturers. The method outlined at Fig. 173, A, is widely used and because of its shape the cylinder is known as the "T" form. It is approved for several reasons, the most important being that large valves can be employed and a well-balanced and symmetrical cylinder casting obtained. Two independent cam shafts are needed, one operating the inlet valves, the other the exhaust members. The valve-operating mechanism can be very simple in form, consisting of a plunger actuated by the cam which transmits the cam motion to the valve stem, raising the valve as the cam follower rides on the point of the cam. Piping may be placed without crowding, and larger manifolds can be fitted than in some other constructions. This has special value, as it permits the use of an adequate discharge pipe on the exhaust side with its obvious advantages.

At the other hand, if considered from a viewpoint of actual heat efficiency, it is theoretically the worst form of combustion chamber. This disadvantage is probably compensated for by uniformity of expansion of the cylinder because of balanced design. The ignition spark plug may be located directly over the inlet valve in the path of

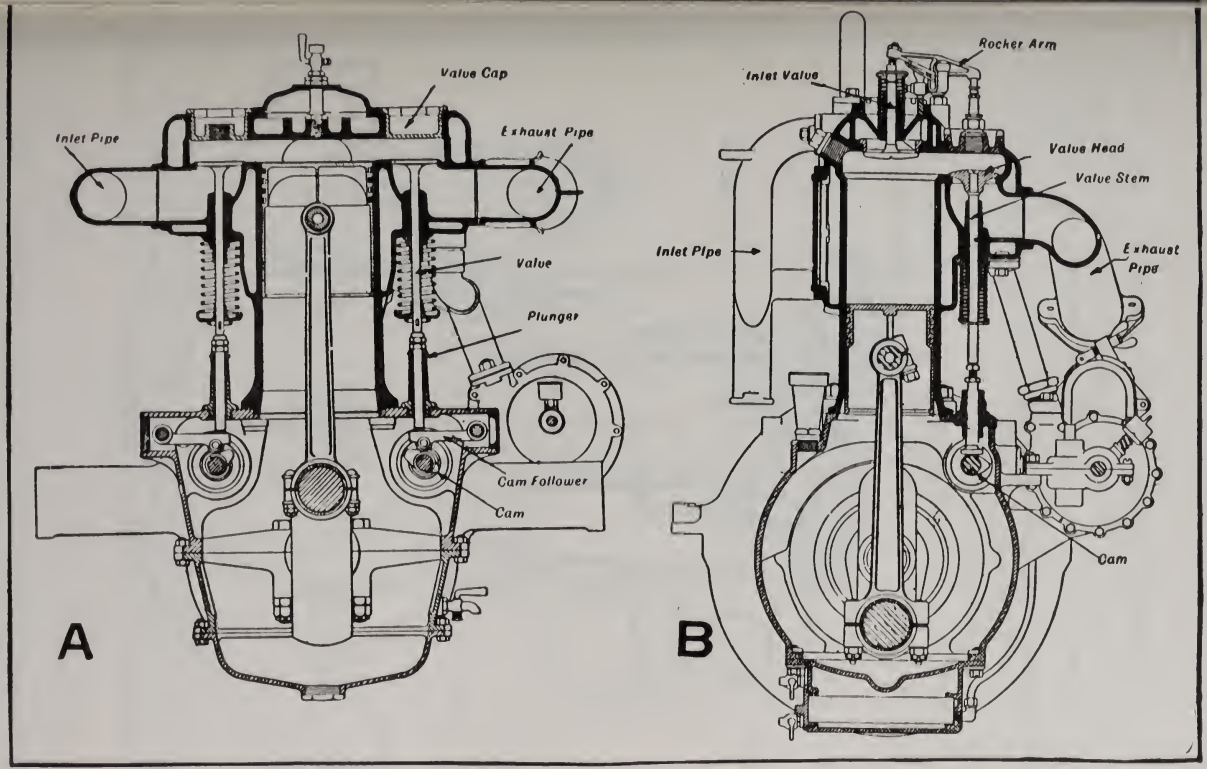


Fig. 173.—Illustrating Typical Methods of Valve Installation in Internal Combustion Motors. A—Valves on Opposite Sides of T-Head Cylinder. B—L-Head Cylinder Having Intake Valve Placed Directly in the Center of the Cylinder Head.

the incoming fresh gases, and both valves may be easily removed and inspected by unscrewing the valve caps without taking off the manifolds.

The valve installation shown at D is somewhat unusual, though it provides for the use of valves of large diameter. Easy charging is insured because of the large inlet valve directly in the top of the cyl-

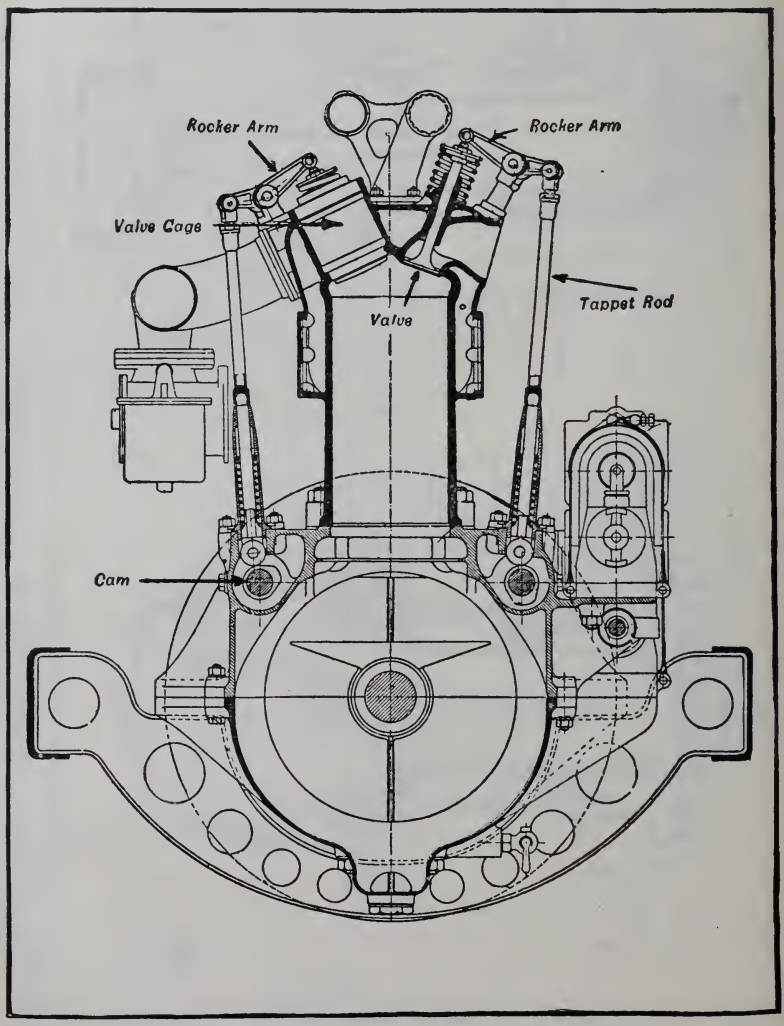


Fig. 174.—Sectional View of Cylinder of Benz Racing Motor, Presented to Show Method of Valve Placing, so These Members Open Directly in the Cylinder Head. Note that Intake Valve is Carried in a Removable Cage, but that Exhaust Valve Seats Directly in Head Casting.

inder. Conditions may be reversed if necessary, and the gases discharged through this large valve. Both methods are used, though it would seem that the free exhaust provided by allowing the gases to escape directly from the combustion chamber through the overhead valve to the exhaust manifold would make for more power. The incoming fresh gas cannot fail to flow into the cylinder easily, because it is drawn into the cylinder by the pumping action of the piston, whereas if the inert gas is not expelled promptly the factor of back pressure is of some importance. The method outlined at Figs. 174

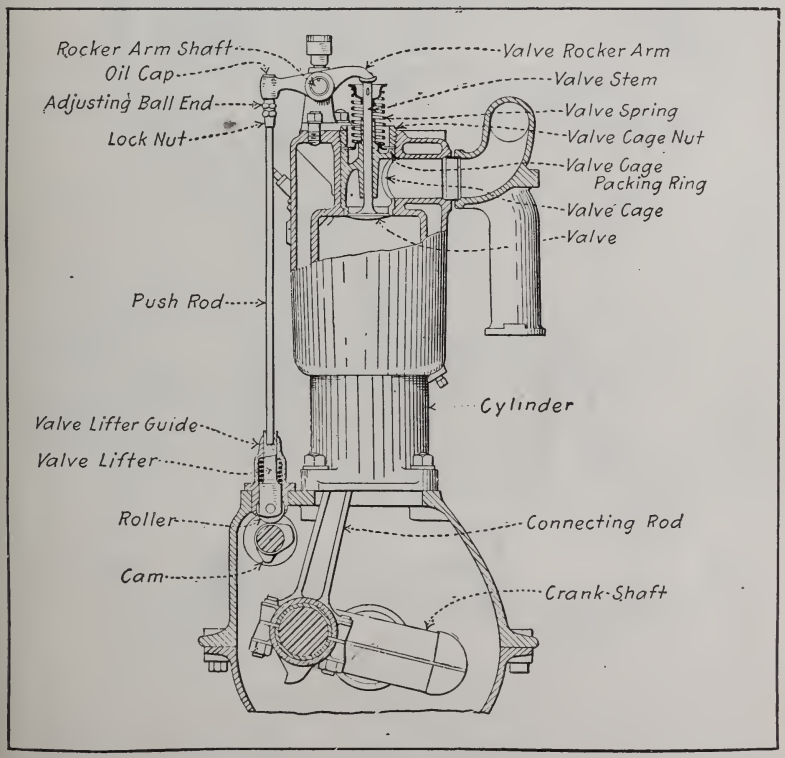


Fig. 175.—Part Sectional View of Buick Cylinder, Showing Method of Installing Valve in Removable Cage and also Necessary Valve Actuating Mechanism.

and 175 is one that has been widely employed on large racing motors where extreme power is required as well as in engines constructed for regular service. The inclination of the valve cages permits the use of large valves and these open directly into the combustion chamber. There are no pockets to retain heat or dead gas, and free intake and outlet of gas is obtained. This form is quite satisfactory from a the-

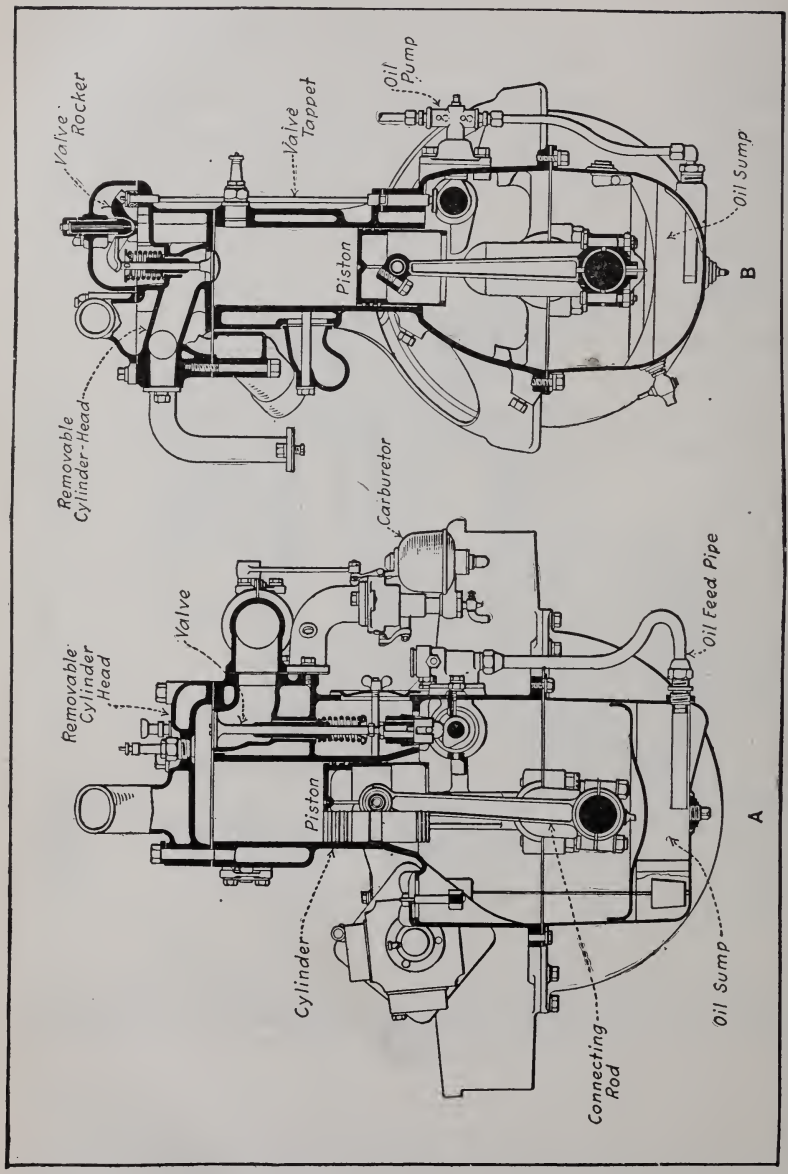


Fig. 176.—Part Sectional View Showing Typical Light Car Engine Utilizing Removable Cylinder Head. A—The Regal 3½"x4¾" Engine. B—Brush Overhead Valve Design.

oretical point of view because of the almost ideal combustion-chamber form. Some difficulty is experienced, however, in properly water-jacketing the valve chamber which experience has shown to be necessary if the engine is to have high power.

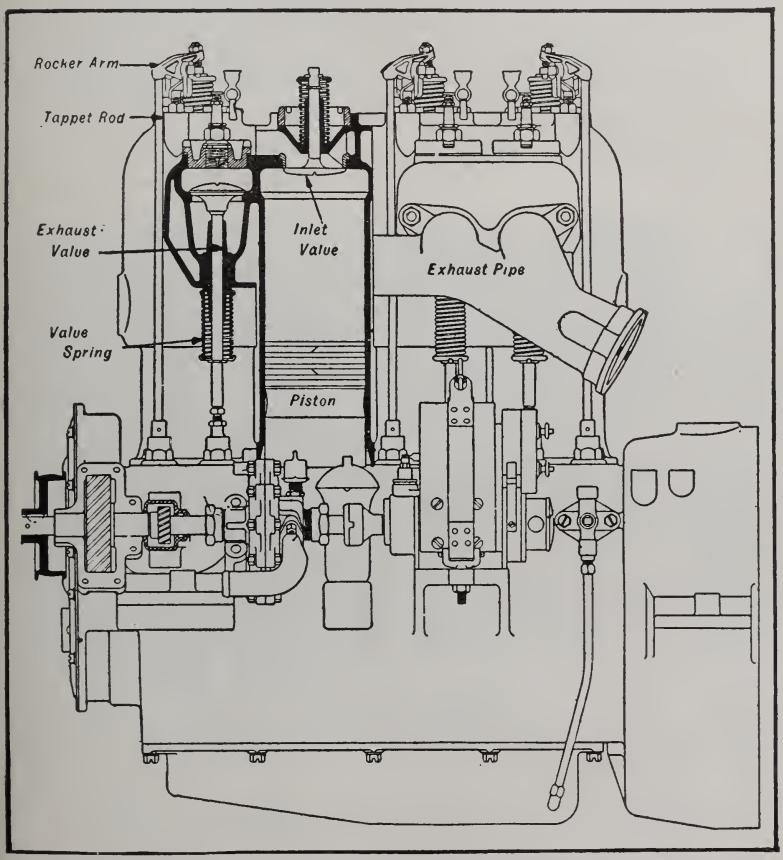


Fig. 177.—Part Sectional View of Four-Cylinder Motor, Showing Unconventional Valve Placing. The Exhaust Valve is Placed in a Side Pocket of the L-Head Cylinder. The Inlet Valve is Placed Directly in the Center of the Combustion Chamber.

The motor shown at Fig. 176, A, employs a cylinder of the "L" type. Both valves are placed in a common extension from the combustion chamber, and being located side by side both are actuated from a common cam shaft. The inlet and exhaust pipes are placed on the same side of the engine and a very compact assemblage is obtained. The valves may be easily removed if desired, and the construction is fairly

good from the viewpoint of both foundry man and machinist. The chief disadvantage is the limited area of the valves and the loss of heat efficiency due to the pocket. This form of combustion chamber, however, is more efficient than the "T" head construction, though with the latter the use of larger valves probably compensates for the greater heat loss. It has been stated as an advantage of this construction that both manifolds can be placed at the same side of the engine and a compact assembly secured. At the other hand, the disadvantage may be cited that in order to put both pipes on the same side they must be of smaller size than can be used when the valves are oppositely placed. The "L" form cylinder may be made more efficient if

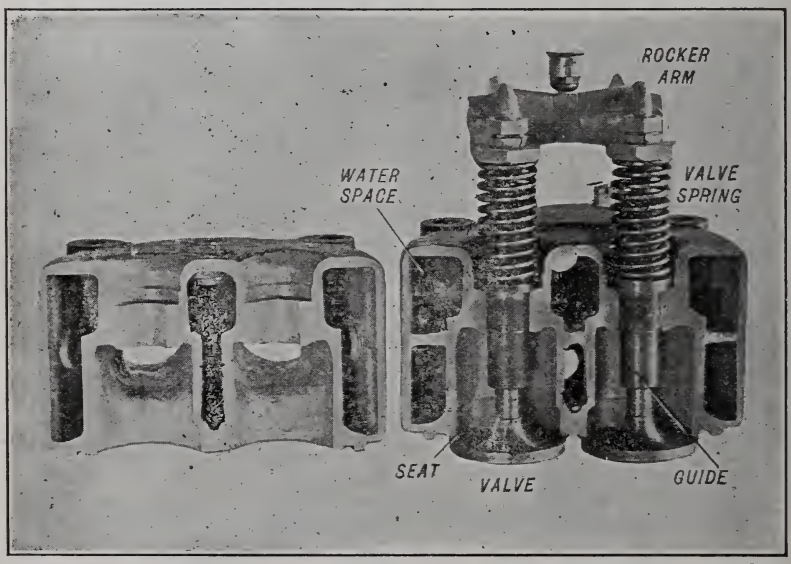


Fig. 178.—Cylinder Head of Knox Engine Cut in Two to Show Method of Valve Placing and How They Seat Directly in the Separately Cast Member. The Valves are Operated by Rocker Arms. Note Exceptionally Good Water Spaces Around Valve Seats.

but one valve is placed in the pocket while the other is placed in the cylinder head. This construction is well shown at Fig. 177, which is a side sectional view of the same motor depicted in end section at Fig. 173, B. The large valves one can use are well emphasized in this illustration.

The method of valve application shown at Figs. 176, B, and 178 is an ingenious method of overcoming some of the disadvantages inherent with valve-in-the-head motors. In the first place it is possible to water-jacket the valves thoroughly, which is difficult to accomplish

when they are mounted in cages. The water circulates directly around the walls of the valve chambers, which is superior to a construction where separate cages are used, as there are two thicknesses of metal with the latter, that of the valve cage proper and the wall of the cylinder. The cooling medium is in contact only with the outer wall, and as there is always a loss of heat conductivity at a joint it is practically impossible to keep the exhaust valves and their seats at a uniform temperature. The valves may be of larger size without the use

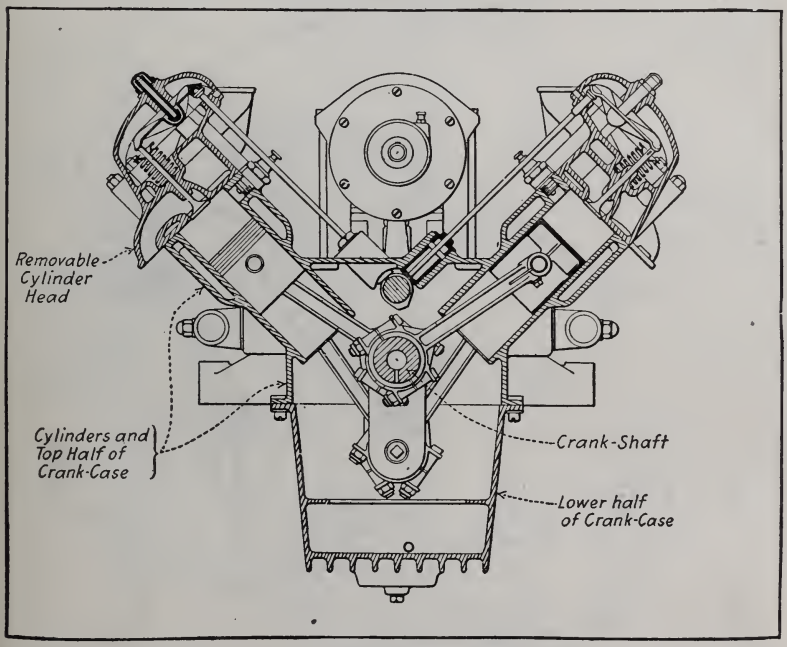


Fig. 179.—Part Sectional View of Eight-Cylinder Brush Motor Design, Showing Method of Valve Placing and Type of Operating Mechanism.

of pockets when seating directly in the head. In fact, they could be equal in diameter to almost half the bore of the cylinder, which provides an ideal condition of charge placement and exhaust.

When valve grinding is necessary the entire head is easily removed by taking off a number of nuts and loosening inlet and exhaust manifold connections, which operation would be necessary even if cages were employed. The cylinder used with the design at Fig. 178 is easily cast and machined, and as the head is separately water-jacketed there is no water joint between the head and cylinder, which must be made tight with a packing capable of resisting both water and hot gas.

The sole function of the copper-asbestos washer which fits in the annular groove in the cylinder head is to prevent escape of gas. The ease with which the head and cylinder may be machined and smooth combustion chamber obtained has been previously dealt with. The application of the valve in the head idea to V type motors is clearly shown

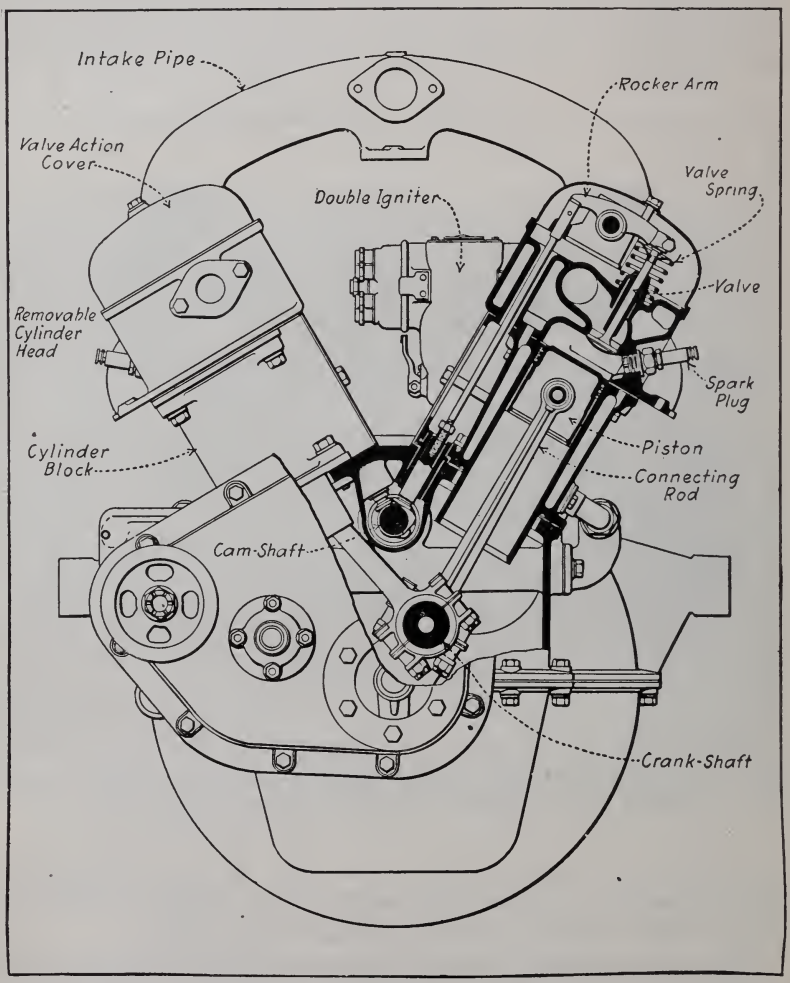


Fig. 180.—Part Sectional End View of the Weidely Twelve-Cylinder Valve-in-the-Head Motor.

in Figs. 179 and 180. The heads are easily detachable from the cylinder blocks and a gas-tight and water-retaining joint is obtained by a copper-asbestos gasket or packing between the head and cylinder

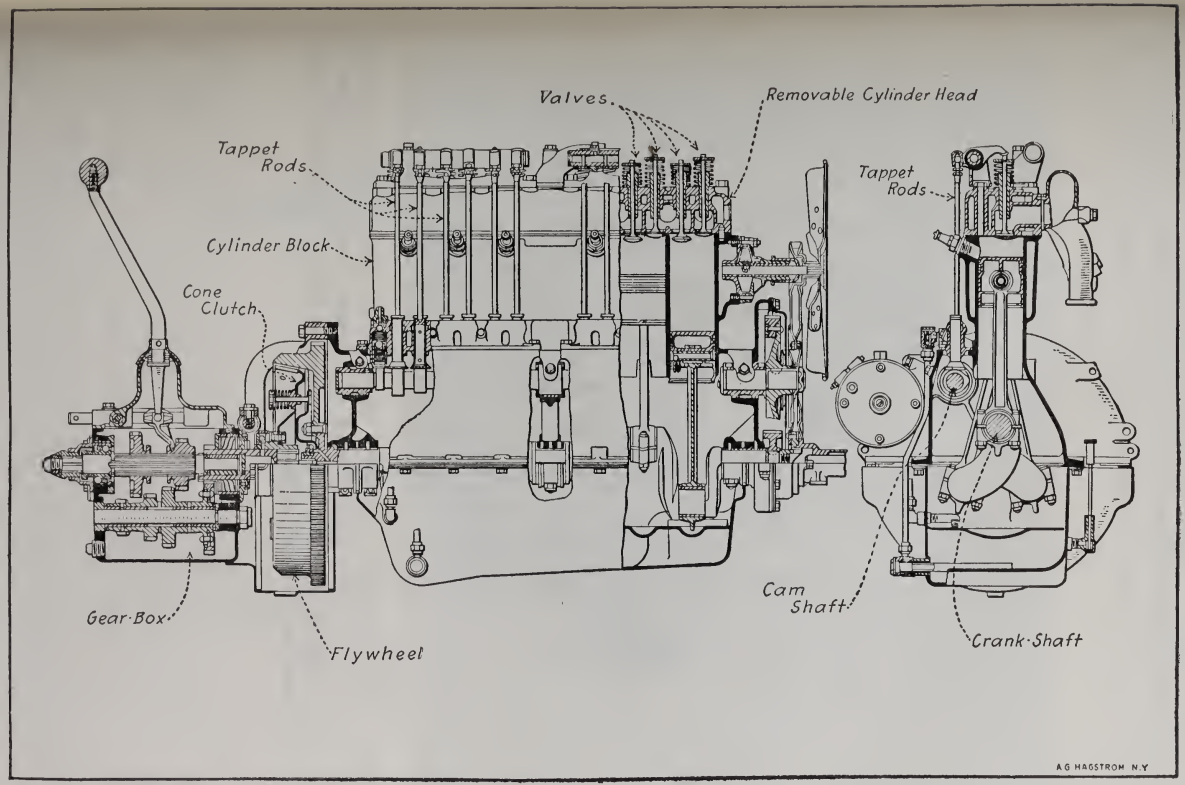


Fig. 181.—Part Sectional View of the Oakland Light Six-Unit Power Plant Having Removable Cylinder Head which Carries the Valves.

castings as previously described. The sections at Fig. 181 show a very popular light six engine using this construction.

Concentric Valves.—The form at Fig. 182 shows an ingenious application of the valve-in-the-head idea which permits one to obtain

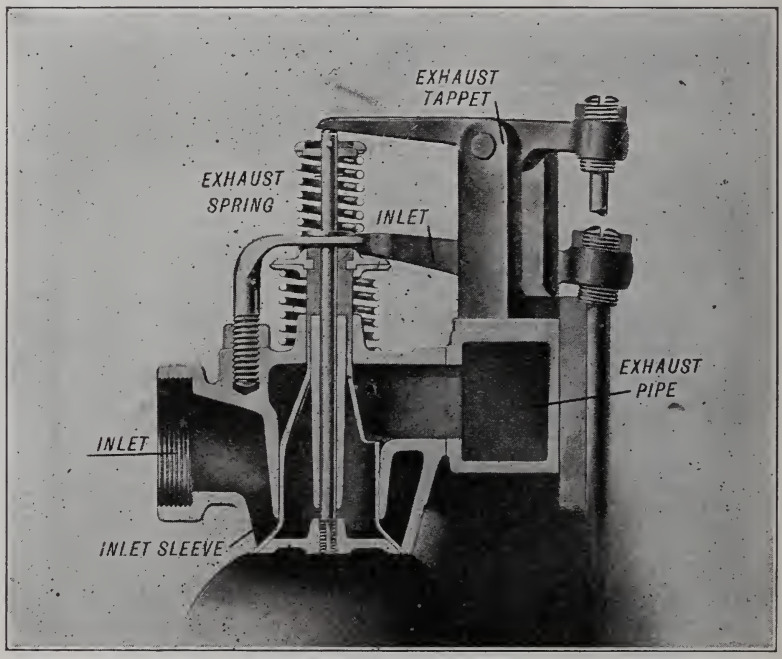


Fig. 182.—Section Through Concentric Valve Used on Some Early Franklin Models. The Exhaust Valve, which is a Regular Poppet Type, Seats in the Inlet Member, which is a Hollow Shell of Metal. Both Valves Open Directly into the Combustion Chamber.

large valves. It has been used on some of the Franklin air-cooled cars. The inlet passage is controlled by the sliding sleeve which is hollow and slotted so as to permit the exhaust gases to leave the cylinder and out through the regular type poppet valve which seats in the inlet sleeve. When the inlet sleeve is operated by the tappet rod and rocker arm the exhaust valve is also carried down with it. The exhaust gas passage is closed, however, and the fresh gases are taken in through the large annular passage surrounding the inlet sleeve. When the inlet valve leaves its seat in the cylinder the passage of cool gas around the sleeve keeps the temperature of both valves to a low point and the danger of warping is minimized. A dome-shaped com-

bustion chamber may be used, which is an ideal form in conserving heat efficiency and as large valves may be installed the flow of both fresh and exhaust gases may be obtained with minimum resistance.

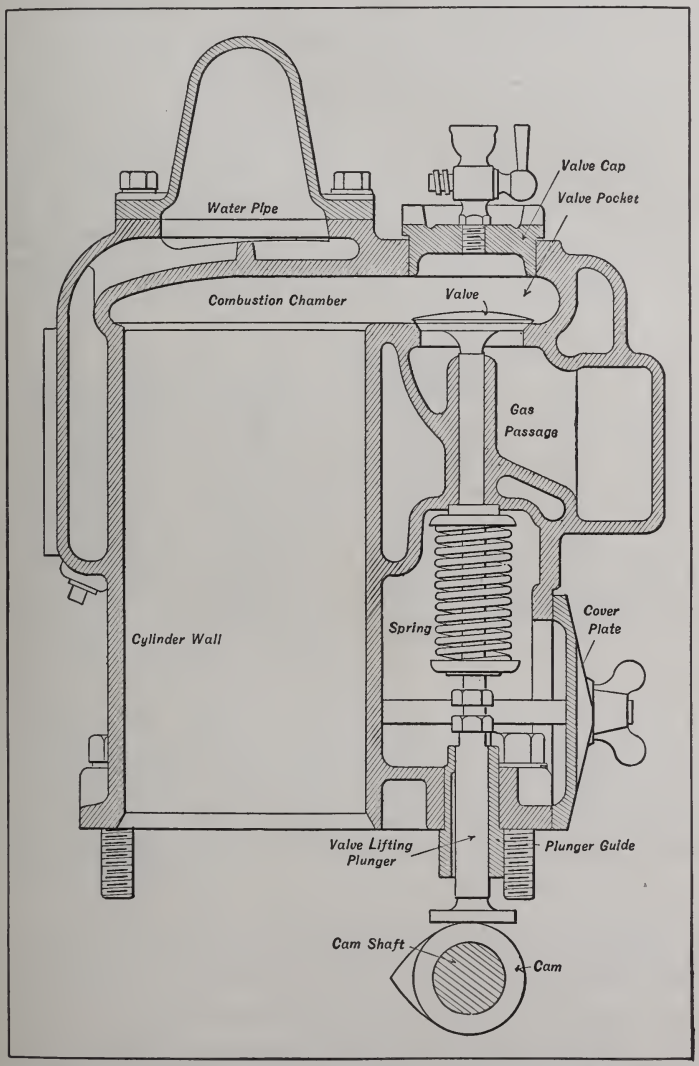


Fig. 183.—Sectional View Through L-Head Cylinder, Showing Method of Operating the Valve and Plate Utilized to Enclose Valve Springs.

At Fig. 183 a section through a typical "L"-shaped cylinder is depicted. It will be evident that where a pocket construction is employed, in addition to its faculty for absorbing heat, the passage of

gas would be impeded. For example, the inlet gas rushing in through the open valve would impinge sharply upon the valve cap directly over the valve and then must turn at a sharp angle to enter the combustion chamber and then at another sharp angle to fill the cylinders. The same conditions apply to the exhaust gases, though they are reversed. When the valve-in-the-head type of cylinder is employed the only resistance offered the gas is in the manifold. As far as the passage of the gases in and out of the cylinder is concerned ideal conditions obtain. It is claimed that valve-in-the-head motors are more flexible and responsive than other forms, but the construction has the disadvantage in that the valves must be opened in most designs through a rather complicated system of push rods and rocker arms instead of the simpler and direct plunger which can be used with either the "T" or "L" head cylinders.

Valve Design and Construction.—Valve dimensions are an important detail to be considered and can be determined by several conditions, among which may be cited method of installation, operating mechanism, material employed, engine speed desired, manner of cylinder cooling, and degree of lift desired. A review of various methods of valve location has shown that when the valves are placed directly in the head, we can obtain the ideal cylinder form though larger valves may be used if housed in a separate pocket, as afforded by the "T" head construction. The method of operation has much to do with the size of the valves. For example, if an automatic inlet valve is employed it is good practice to limit the lift and obtain the required area of port opening by augmenting the diameter. Because of this a valve of the automatic type is usually made twenty per cent larger than one mechanically operated. When both are actuated by cam mechanism, as is now common practice, they are usually made the same size and are interchangeable, which greatly simplifies manufacture. The relation of valve diameter to cylinder bore is one that has been discussed for some time by engineers. The writer's experience would indicate that they should be at least half the bore, if possible. The larger the area of the valve the less lift required, and this is an important factor where high rotative speeds are desired. A valve with a small lift will reach its maximum opening sooner and close quicker than one with a high lift and small diameter. This will produce less wear on the parts and tend to more silent operation.

At the other hand, a large diameter valve is more apt to warp than a narrower one, and greater care is needed in securing positive cooling when large diameter members are used. While the mushroom type or poppet valve has become standard and is the most widely used form at

the present time, there is some difference of opinion among designers as to the materials employed and the angle of the seat. Most valves have a bevel seat, though some have a flat seating, as shown at Fig. 184, D. The flat seat valve has the distinctive advantage of providing a clear opening with lesser lift, this conducing to free gas flow. It also has value because it is silent in operation, but the disadvantage is present that best material and workmanship must be used in their construction to obtain satisfactory results. As it can be made very light it is particularly well adapted for use as an automatic inlet valve. Among other disadvantages cited is the claim that it is more susceptible to derangement owing to the particles of foreign matter getting under the seat. With a bevel seat valve it is argued that the

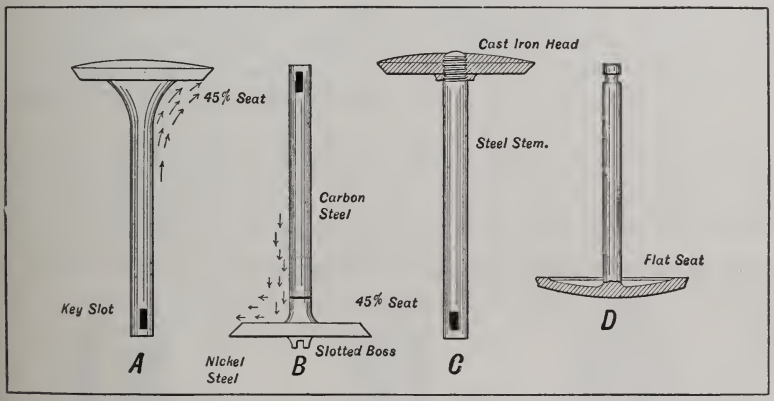


Fig. 184.—Types of Valves in Common Use. A—One-Piece Alloy Steel Valve of Good Design, which Permits Easy Gas Flow. B—Steel Valve Made by Electrically Welding a Nickel Steel Head to a Carbon Steel Stem. C—A Construction Often Employed for Exhaust Valves. A Cast-Iron Head Screwed and Riveted to a Steel Stem. D—Valve with Flat Seat, Formerly Used as an Inlet Valve.

foreign matter would be more easily dislodged by the gas flow, and that the valve would close tighter because it is drawn positively against the bevel seat.

Several methods of valve construction are the vogue, the most popular form being the one-piece type; though those which are composed of a head of one material and stem of another are often used. If the built-up construction is favored the head is usually of high nickel steel, Monel metal, or cast iron, which metals possess good heat resisting qualities. Heads made of these materials are not likely to warp, scale, or pit, as is sometimes the case when ordinary grades of machinery steel are used. The cast-iron head construction is not

popular because it is often difficult to keep the head tight on the stem. There is a slight difference in expansion ratio between the head and the stem, and as the stem is either screwed or riveted to the cast-iron head the constant hammering of the valve against its seat may loosen the joint. As soon as the head is loose on the stem the action of the valve becomes erratic.

The valve shown at Fig. 184, A, is made from a forging of thirty-five-per-cent nickel steel or of a special Tungsten alloy having great resistance to heat in the large sizes, and is often machined from the alloy steel bar by automatic machinery in making the smaller sizes. Among the factors considered in design are to make the stems of ample size so that they will not be likely to bend, and to leave enough metal between the stem and the head so that the gases may be directed toward the periphery of the head. This has a tendency to make a slightly heavier valve than that shown at Fig. 184, B. It is also considered good practice to use a domed or arched head instead of one that is perfectly flat, and it is advisable to leave the head smooth and without a slotted boss, which is often left on so that a screw-driver blade can be used to turn the valve when grinding it. When the arched head construction is used two small holes may be drilled into it. These have the advantage of leaving no sharp edges exposed to retain heat and cause too early explosion of gas. If desired, a slot may be cut directly in the head and the valve turned with a screw-driver.

The form of valve shown at B is a common one, and its only advantage is that the design permits of light construction. The slotted boss is not desirable for the reason previously outlined, the valve head is not as strong as that shown at A and it will warp sooner. The point of weakness where the stem joins the head may cause trouble. As the gases strike the under surface and are sharply deflected at a sharp angle instead of having an easy flow the passage is somewhat impeded. The form of construction is an alloy steel head electrically welded to a machinery steel stem. The former material is a better heat-resisting substance while the softer steel makes a better bearing. The joint is indistinguishable because the metals are fused together, and that point is as strong as any other part of the stem. The valve shown at C is composed of a cast-iron head member screwed on to a steel stem. The construction at D is a good example of flat seat inlet valve.

Valve Operation.—The methods of valve operation commonly used vary according to the type of cylinder construction employed. In all cases the valves are lifted from their seats by cam actuated mechan-

ism. Various forms of valve-lifting cams are shown at Fig. 185. As will be seen, a cam consists of a circle to which a raised, approximately triangular member has been added at one point. When the cam fol-

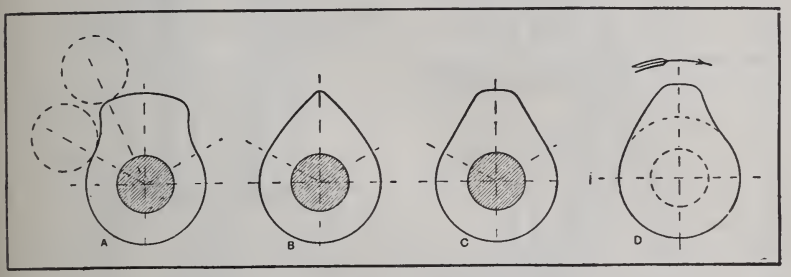


Fig. 185.—Forms of Valve Lifting Cams Generally Employed. A—Cam Profile for Long Dwell and Quick Lift. B—Typical Inlet Cam Used with Mushroom Type Follower. C—Average Form of Cam. D—Design to Give Quick Lift and Gradual Closing.

lower rides on the circle, as shown at Figs. 186 and 187, there is no difference in height between the cam center and its periphery and there is no movement of the plunger. As soon as the raised portion

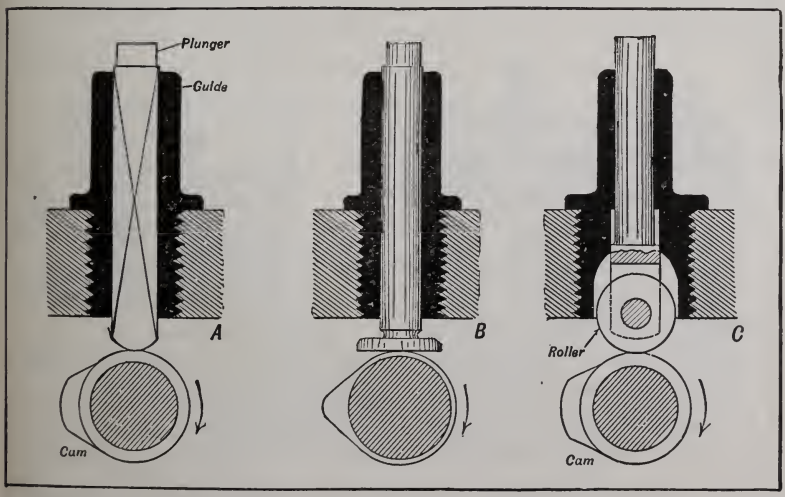


Fig. 186.—Showing Principal Types of Cam Followers which Have Received General Application.

of the cam strikes the plunger it will lift it, and this reciprocating movement is transmitted to the valve stem by suitable mechanical connections.

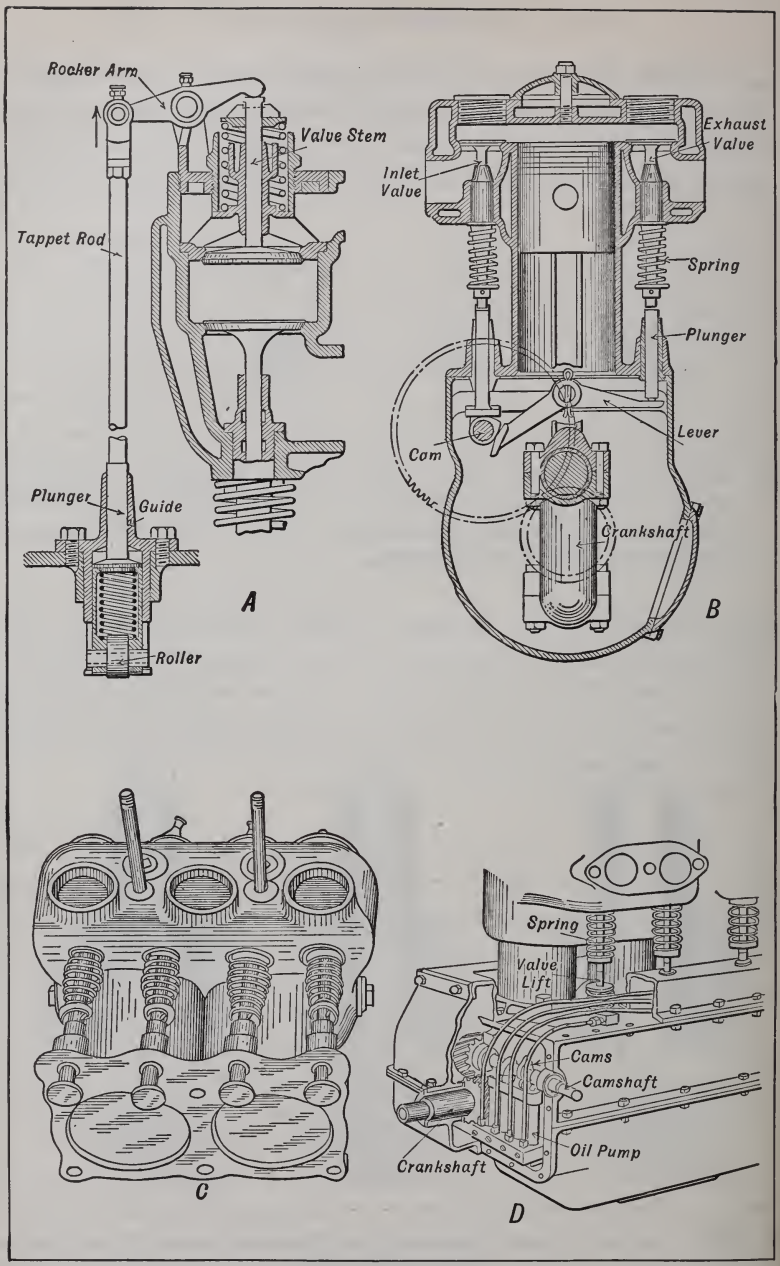


Fig. 187.—Defining Different Possible Methods of Valve Operation. A—Overhead Valve Actuated by Rocker Arm, Tappet Rod and Roller Type Cam Follower. B—How Both Valves May Be Operated from One Cam Using a T-Head Cylinder. C—Valves in an L-Type Twin Cylinder Casting Operated by Mushroom Type Cam Followers. D—A Suggested Method of Indirect Valve Operation Never Used in Practice.

Cam Forms.—The cam forms outlined at Fig. 185 are those commonly used. That at A is used on engines where it is desired to obtain a quick lift and to keep the valve fully opened as long as possible. It is a noisy form, however, and is not very widely employed. That at B is utilized more often as an inlet cam while the profile shown at C is generally depended on to operate exhaust valves. The cam shown at D is a composite form which has some of the features of the other three types. It will give the quick opening of form A, the gradual closing of form B, and the time of maximum valve opening provided by cam profile C.

Valve Lift Plungers.—The various types of valve plungers used are shown at Fig. 186. That shown at A is the simplest form, consisting of a simple cylindrical member having a rounded end which follows the cam profile. These are sometimes made of square stock or kept from rotating by means of a key or pin. A line contact is possible when the plunger is kept from turning, whereas but a single point bearing is obtained when the plunger is cylindrical and free to revolve. The plunger shown at A will follow only cam profiles which have gradual lifts. The plunger shown at B is left free to revolve in the guide bushing and is provided with a flat mushroom head which serves as a cam follower. The type shown at C carries a roller at its lower end and may follow very irregular cam profiles if abrupt lifts are desired. While forms A and B are the simplest, that outlined at C in its various forms is more widely used.

Valve Operating Means.—The illustrations at Figs. 187 and 188 show some of the different possible methods of valve operation. At A the application of a rocker arm and tappet rod to operate an overhead valve is clearly depicted. The rocker arm is interposed in order that the upward movement of the tappet rod will produce a down movement of the valve stem. The method of valve operation shown at B is possible when it is desired to operate both valves of a "T" head cylinder from a common cam shaft. One of the valves is lifted directly by the usual cam actuated plunger, while the other member is raised from its seat by a plunger operated from the cam through a centrally pivoted simple lever. At C the simplest method of valve operation is shown. The cylinder casting is a twin "L" form, and the valves are placed side by side in the pocket at one side of center. They are operated directly by means of simple mushroom head plungers guided in bushings secured in bosses formed integrally with the cylinder base. These plungers bear against the lower end of the valve stems.

All the methods in which levers are used to operate valves are more

or less noisy because clearance must be left between the valve stem and the top of the plunger. The space must be taken up before the valve will leave its seat, and when the engine is operated at high speeds the forcible contact between the plunger and valve stem produces a pronounced hammering sound. At D a method of indirect valve operation is shown. The main purpose is to obtain silent working and to permit the valves being arranged in any convenient position. Instead of using direct cam action against the end of the valves, the valves are lifted from their seats by a liquid under pressure. The cams are

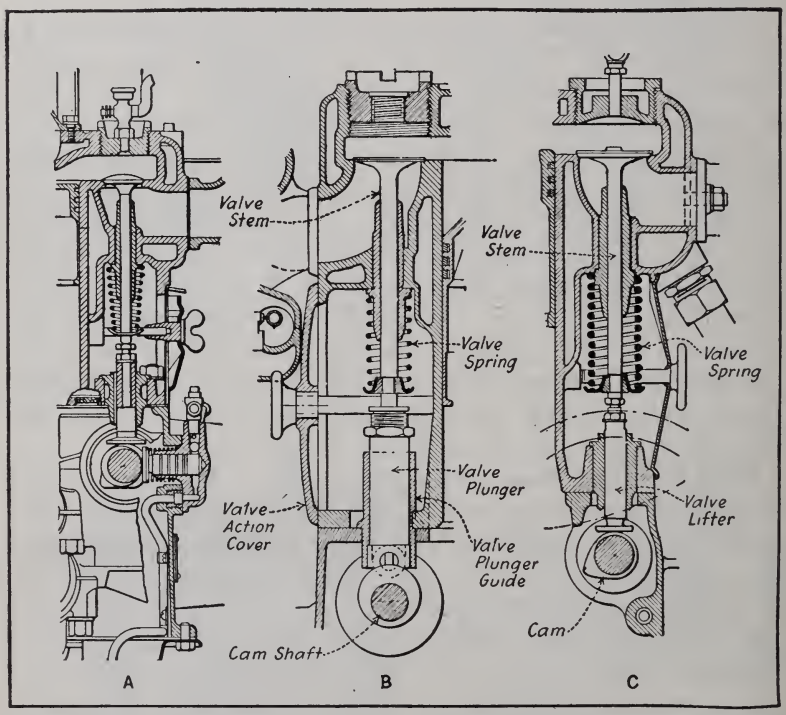


Fig. 188.—Showing Various Types of Valve Lift Plungers and Methods of Adjusting Clearance Between Plunger and Stem. A—Continental Motor. B—Waukesha Valve Arrangement. C—Wisconsin Valve Actuation.

placed across the front of the engine, though they could be placed at any other point so long as they could be conveniently driven from the crank shaft.

There are eight cams, one for each valve, and under each cam an oil force pump is placed. This is connected by a tube to a plunger under the valve stem. Each pipe is filled with oil, and when the cam

operates its particular pump the incompressible liquid in the pipe is forced against the plunger under the valve and the valve is lifted. Instead of the cam pushing the tappet and the plunger pushing the

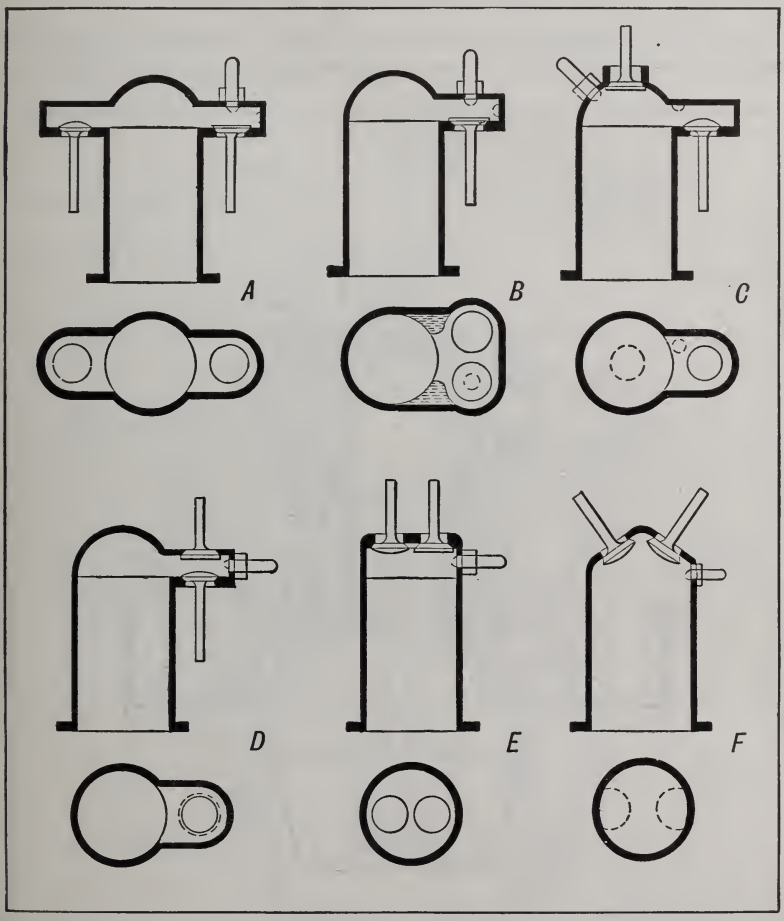


Fig. 189.—Diagram Showing Forms of Cylinders Demanded by Different Valve Placings. A—T-Head Type, Valves on Opposite Sides. B—L-Head Cylinder, Valves Side by Side. C—L-Head Cylinder, One Valve in Head, the Other in Pocket. D—Inlet Valve Over Exhaust Member, Both in Side Pockets. E—Valve-in-the-Head Type with Vertical Valves. F—Inclined Valve Placed to Open Directly in Combustion Chamber.

valve, as in other constructions described, the cam works a pump and this in turn a tappet. The return of the valve stem is effected by the valve springs in the usual way. Each oil pump is also provided with a return spring which keeps the roller on top of the pump plunger

bearing against the cam. The whole of the cam action is in an oil bath and any leakage of liquid from the pipes is automatically compensated for through a simple form of ball valve. Each pipe is always full of oil as long as there is any in the bath.

As it is not possible to compress the liquid, it may be stated broadly that the driving effect is the same as though the oil pipes were filled

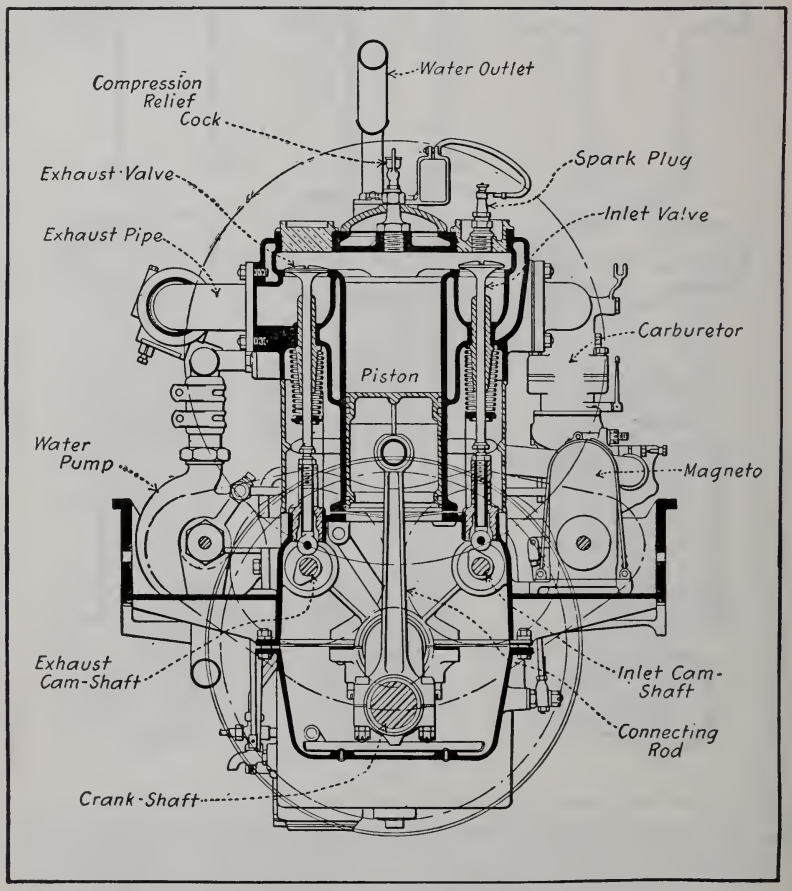


Fig. 190.—End Sectional View of 1917 Locomobile T-Head Engine.

with steel balls. The simile is not a correct one, because the fluid pressure provides a softness and silence of action which could not be very well obtained by direct operation. It is also expected that clearance between the valve stem and operating plungers will not be necessary because the slight leakage of working fluid will compensate for any expansion of the valves and the resulting lengthening of the stems

automatically. It is not expected that this method of valve operation will be used to any extent because the mechanism is more complicated than when simple direct lift plungers are employed. With modern forms of plungers which are provided with suitable adjusting features which make it possible to maintain a minimum clearance between valve stem and lifting member, the valve action is silent enough so that it would not pay to introduce a complicated hydraulic system as that described. This has been presented mainly to show that valves may be operated by other means than direct cam and plunger action.

Valve Placing Reviewed.—We have seen that the method of valve placing has material bearing on the system of valve-actuating mechanism employed. At Fig. 189 the various methods of valve installation are presented in diagrammatic form and will assist the reader in obtaining a clear idea of the valve placings most commonly used. With the "T" head cylinder as shown at A and at Fig. 190 separate cam shafts are usually employed and the valves are raised by direct lift plungers. The "L" head cylinder as depicted at B calls for but one cam shaft, and as is true of the previous case the valves may be lifted directly from their seats by a simple cam follower. At C the valve location demands the use of an overhead rocker arm which may be actuated from the same cam shaft which is employed to raise the exhaust valve from its seat. At D a method of valve placing is shown which is very popular on small motors used for motorcycle propulsion. The inlet valve is placed directly over the exhaust member and may be automatically operated or may be depressed by the conventional form of rocker arm. When overhead valves are used, as shown at E, two rocker arm assemblies are needed and both valves are operated from a common cam shaft. With the form shown at F having inclined valves two sets of rocker arms may be used actuated by two cam shafts, one on each side of the motor. Sometimes a single rocker arm is fulcrumed at the center, having one extremity bearing on each valve stem. The lever is rocked by a special form of cam provided with a depression as well as a raised portion. When the tappet rod is raised it may depress one of the valves, whereas when the cam follower drops in the depression of the cam the other end of the rocker arm will fall and open the other valve.

A cam case assembly, such as used on the early four-cylinder Hupp motor, is shown at Fig. 191. This is bolted to the side of the engine base and the large gear attached to the cam shaft is driven from a suitable gear on the crank shaft at half the engine speed. The cam followers are the simple form shown at Fig. 86, A. They are provided with a fiber inset at their top end which comes into

contact with the valve stem. The use of this material tends to reduce noise which would be present if two metals came in contact.

Methods of Driving Cam Shaft.—Two conventional systems of cam shaft operation are used. The most common of these is by means of gearing of some form. If the cam shaft is at right angles to the crank shaft it may be driven by worm, spiral, or bevel gearing. If the cam shaft is parallel to the crank shaft, simple spur gear or chain connection may be used to turn it. At Fig. 191 a conventional system

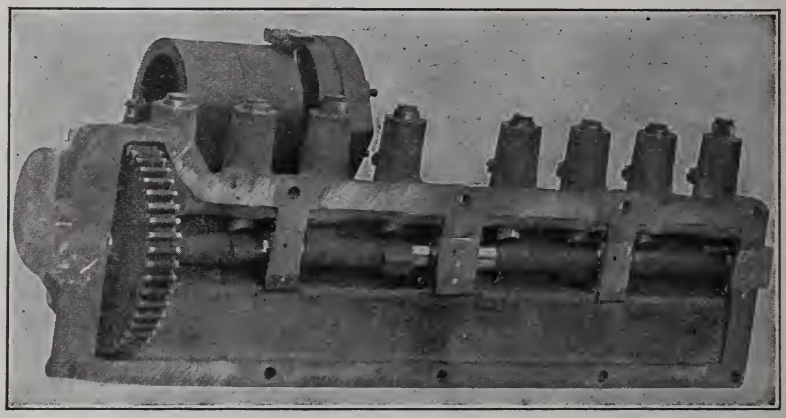


Fig. 191.—Camshaft and Valve Operating Plunger Case of Early Motor Design. A Separate Member that is Now Quite Common on Overhead Valve Types. Note Simple Type of Cam Follower.

of cam gears is shown. The front of the gear case has been removed, this exposing the gear train which drives the cam shaft and accessory mechanism. A small gear having thirty-two teeth is placed on the crank shaft. This engages a larger member having sixty-four teeth, turning it at one-half speed. This large gear is securely fastened to a flange on the cam shaft by three bolts. At the right an idler gear meshes with the crank-shaft gear and serves to transmit motion from that member to the small gear at the extreme right which is utilized to drive the circulating pump shaft and the magneto employed for ignition.

While gearing is more commonly used, considerable attention has been directed of late to silent chains for cam shaft operation. The ordinary forms of block or roller chain have not proven successful in this application, but the silent chain, which is in reality a link belt operating over toothed pulleys, has demonstrated its worth. The tendency to its use was noted on more foreign motors than those of American design, but it is now very popular. It first came to public

notice when employed on the Daimler-Knight engine for driving the small auxiliary crank shafts which reciprocated the sleeve valves.

At Fig. 192 two efficient cam shaft drives are illustrated. That at A is furnished on the Woolsey (English) motors. It will be observed

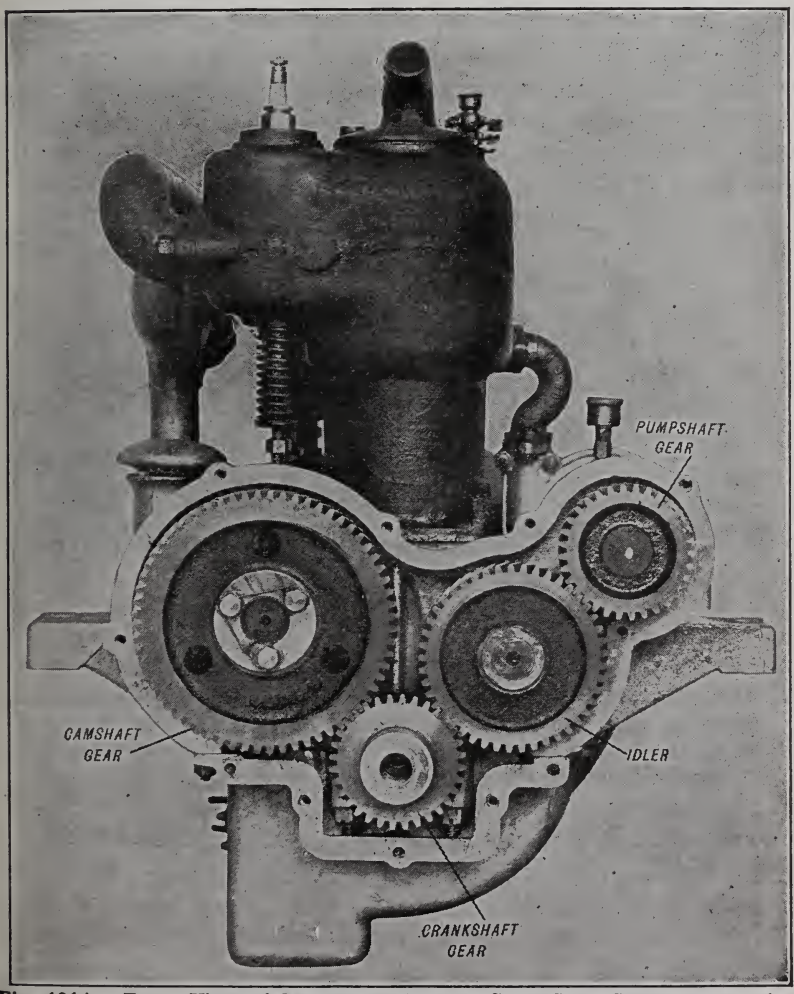


Fig. 191A.—Front View of Motor with Timing Gear Case Cover Removed to Show Arrangement of Camshaft and Water Pump Driving Gear.

that the small gear on the crank shaft is coupled to a larger gear on the cam shaft by one chain, while a separate gear wheel and chain drives the magneto from the cam shaft. The sprockets are so proportioned that the cam shaft revolves at half the engine speed, while

the magneto is speeded up so it will have the same speed as the crank shaft.

At Fig. 192, B, the silent chain drive on the White & Poppe engines is shown. This installation is similar in the main to that previously described, and further description is not needed. The advantages cited for the application of chains are, first, silent operation which obtains even after the chains have worn considerably; second, in designing it is not necessary to figure on maintaining certain absolute center distances between the crank shaft and cam shaft sprockets, as would be the case if conventional forms of gearing were used. On some forms of motor employing gears, three and even four members

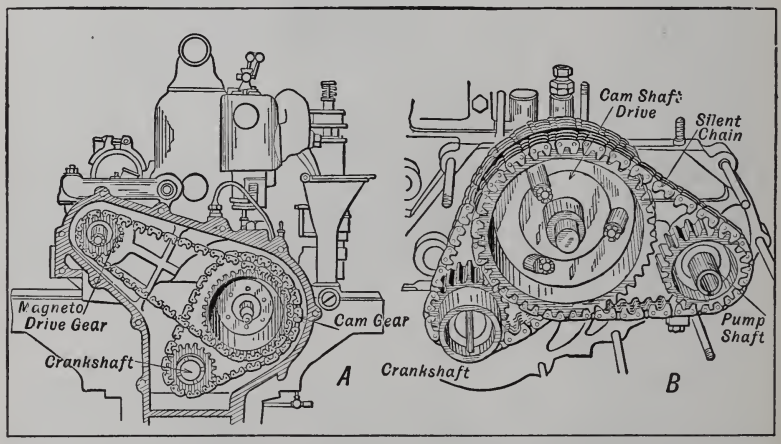


Fig. 192.—Showing Use of Silent Chain Connection Between Crankshaft and Camshaft, and also for Driving Water Pump and Magneto Shafts. A—Chain Drive on Woolsey (English) Motor. B—Method of Using Silent Chains on White and Pope (English) Power Plant.

are needed to turn the cam shaft. With a chain drive but two sprockets are necessary, the chain forming a flexible connection which permits the driving and driven members to be placed at any distance apart that the exigencies of the design demand. When chains are used it is advised that some means for compensating chain slack be provided, or the valve timing will lag when chains are worn. Many combination drives may be worked out with chains that would not be possible with other forms of gearing.

New Valve Operating Systems.—There is a growing tendency on the part of designers to use the detachable cylinder head construction that was first introduced in a commercial way on multiple cylinder automobile engines by Henry Ford. A new design which is shown at Fig.

193 incorporates not only the detachable head feature having valves directly in the head, but also includes an overhead cam shaft with practically direct actuation of the valve stem. The construction of the valve operating member can be clearly understood by referring to the illustration at the top of Fig. 193. As the engine outlined is a six cyl-

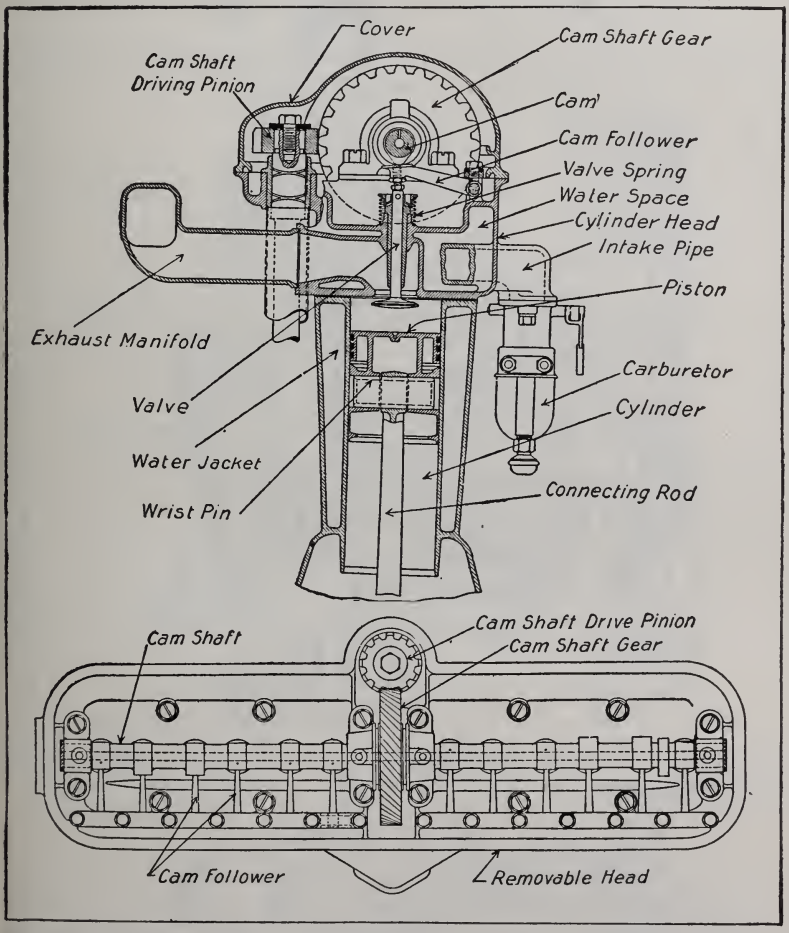


Fig. 193.—Sectional View of Weidely Motor Cylinder, Showing Method of Operating Valves by Overhead Camshaft.

inder form, twelve valves are carried in the removable head member, which means that the cam shaft must have twelve cams. The cam shaft is driven at the central point by means of a worm or spiral pinion which drives a larger spiral gear attached to the cam shaft. In order to relieve the valve stem of side thrust, a cam follower is interposed

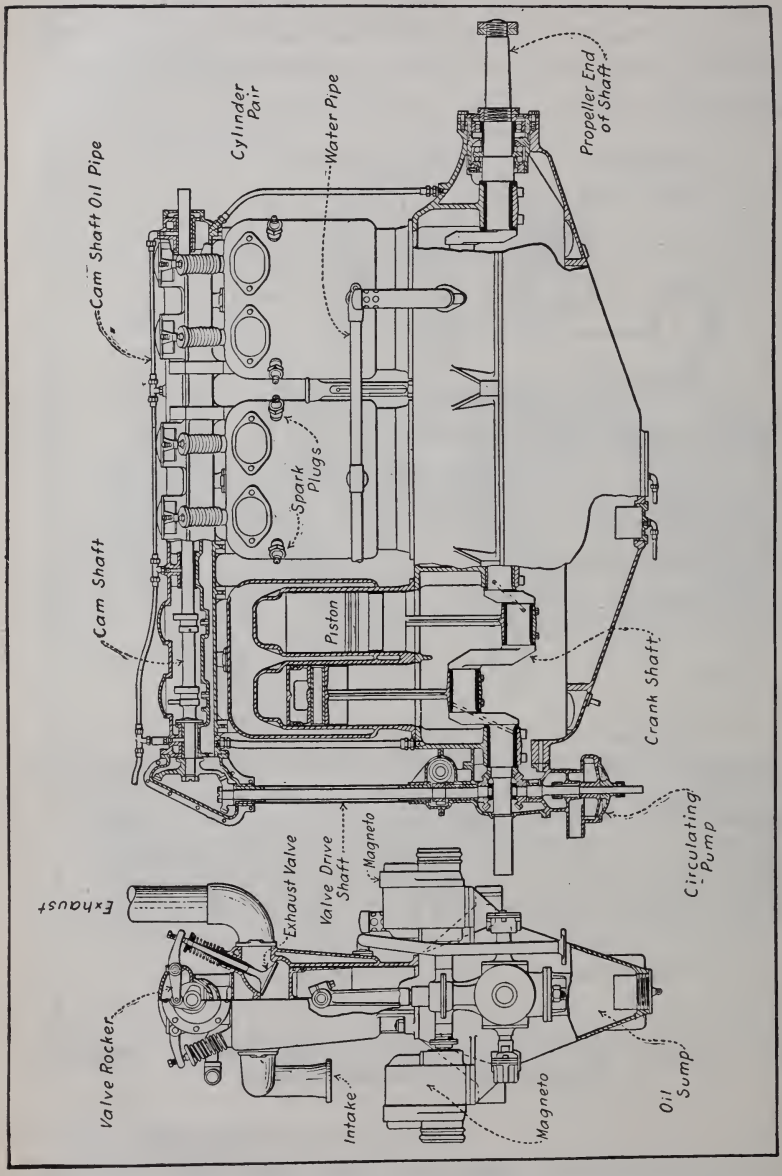


Fig. 194.—Part Sectional View of Wisconsin Aviation Motor, Showing Overhead Camshaft and Valves Set at an Angle in the Cylinder Heads.

between the cam and the top of the valve stem. In the Wisconsin aviation engine shown at Fig. 194 the overhead cam shaft is driven by bevel gears and the valves seat into the cylinder heads which are cast integrally with the cylinders. In the Drexel 1917 engine at Fig. 195 the valves seat in the head and are actuated by an overhead cam shaft driven by a pair of silent chains as indicated.

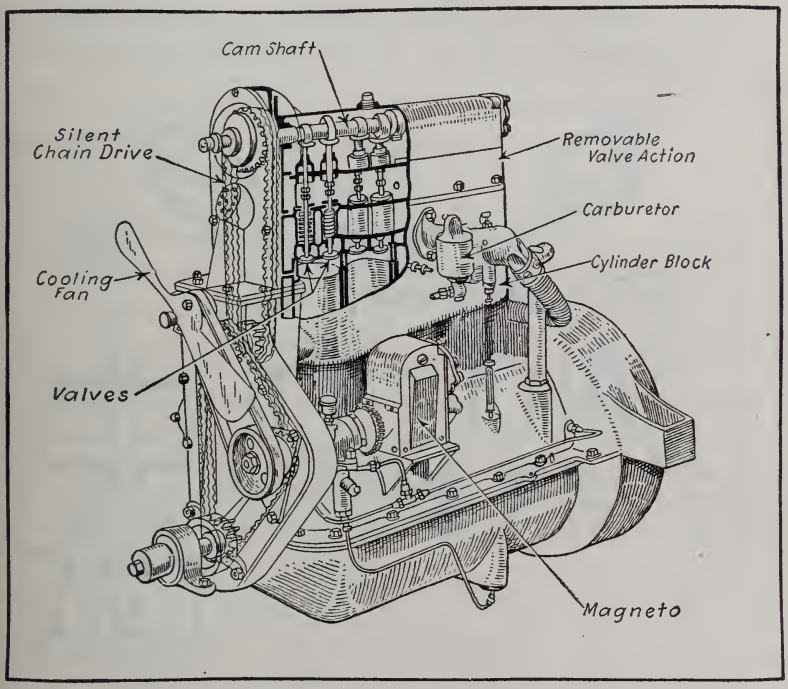


Fig. 195.—Part Sectional View of Drexel 1917 Four-Cylinder Valve-in-the-Head Motor, Showing Method of Driving Overhead Camshaft by Double Silent Chain Arrangement.

Springless valves are the latest development on French racing cars and it is possible that the positively operated types will be introduced on pleasure cars also. Two makes of positively actuated valves are shown at Fig. 196. The positive valve motor differs from the conventional form by having no necessity for valve springs, as a cam not only assures the opening of the valve, but also causes it to return to the valve seat. In this respect it is much like the sleeve valve motor where the uncovering of the ports is absolutely positive. The cars equipped with these valves were a success in long-distance auto races. Claims made for this type of valve mechanism include the

possibility of a higher number of revolutions and consequently greater engine power. With the spring controlled, single cam operated valve a point is reached where the spring is not capable of returning the valve to its seat before the cam has again begun its opening movement. It is possible to extend the limits considerably by using a light valve on a strong spring, but the valve still remains a limiting factor in the speed of the motor.

A part sectional view through a cylinder of an engine designed by G. Michaux is shown at Fig. 196, A. There are two valves per cylinder

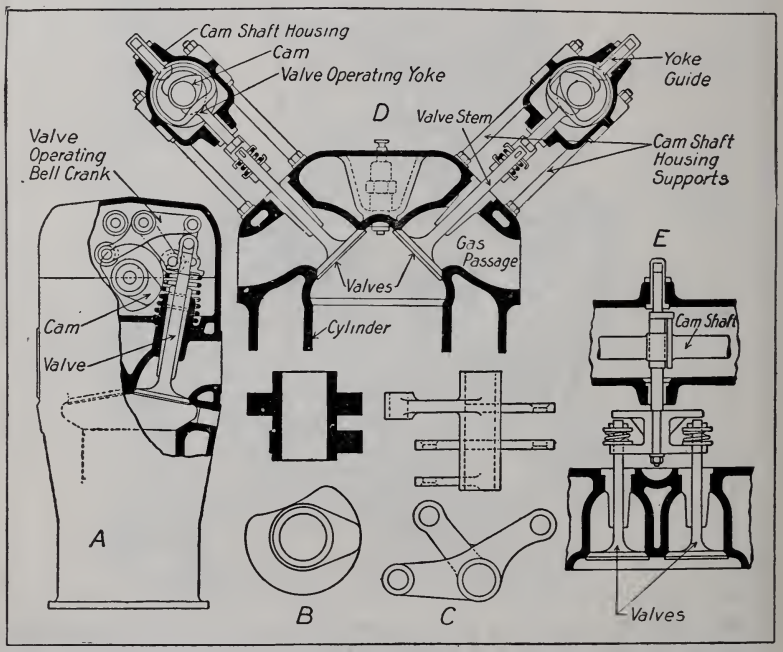


Fig. 196.—Two Methods of Operating Valves by Positive Cam Mechanism, which Closes as Well as Opens Them.

inclined at about ten degrees from the vertical. The valve stems are of large diameter, as owing to positive control, there is no necessity of lightening this part in an unusual degree. A single overhead cam shaft has eight pairs of cams, which are shown in detail at B. For each valve there is a three-armed rocker, one arm of which is connected to the stem of the valve and the two others are in contact respectively with the opening and closing cams. The connection to the end of the valve stem is made by a short connecting link which is screwed on to the end of the valve stem and locked in position. This allows some adjustment to be made between the valves and the ac-

tuating rocker. It will be evident that one cam and one rocker arm produce the opening of the valve and that the corresponding rocker arm and cam result in the closing of the valve. If the opening cam has the usual convex profile the closing cam has a correspondingly concave profile. It will be noticed that a light valve spring is shown in drawing. This is provided to give a final seating to its valve after it has been closed by the cam. This is not absolutely necessary, as an engine has been run successfully without these springs. The whole mechanism is contained within an overhead aluminum cover.

The positive valve system used on the De Lage motor is shown at D. In this the valves are actuated as shown in sectional views D and E. The valve system is unique in that four valves are provided per cylinder, two for exhaust and two for intake. The valves are mounted side by side, as shown at E, so the double actuator member may be operated by a single set of cams. The valve operating member consists of a yoke having guide bars at the top and bottom. The actuating cam works inside of this yoke. The usual form of cam acts on the lower portion of the yoke to open the valve, while the concave cam acts on the upper part to close the valves. In this design provision is made for expansion of the valve stems due to heat, and these are not positively connected to the actuating member. As shown at E, the valves are held against the seat by short coil springs at the upper end of the stem. These are very stiff and are only intended to provide for expansion. A slight space is left between the top of the valve stem and the portion of the operating member that bears against them when the regular profile cam exerts its pressure on the bottom of the valve operating mechanism. Another novelty in this motor design is that the cam shafts and the valve operating members are carried in casings attached above the motor by housing supports in the form of small steel pillars. The overhead cam shafts are operated by means of bevel gearing.

Valves Operated by Drum Cams.—The illustrations at Fig. 197 show the novel mechanically opened and closed valves used in the 1917 Amalgamated Light Six engine. The top view shows the cam and valve rocker, the lower ones depict the detachable cylinder head. The valves are ordinary poppet valves and are set vertically in a detachable cylinder head. They are arranged in two rows, the intakes on one side and the exhausts on the other, and down the center of the head is the cam shaft, this lying between the valve stems. Between each pair of cylinders is a short rocker shaft which is placed transversely across the cylinder head, and there are fore and aft rockers to operate the valves. Each rocker is "L" shaped, one end

being attached to the valve and the other carrying a roller, and the roller fits in a groove cut in a block attached to the cam shaft. This groove is of such formation that the cam shaft turns the roller, and so the rocker is caused to move to and fro in accordance with timing requirements.

It would, of course, not be possible to make this positive action close the valve and hold it closed without having a slightly elastic

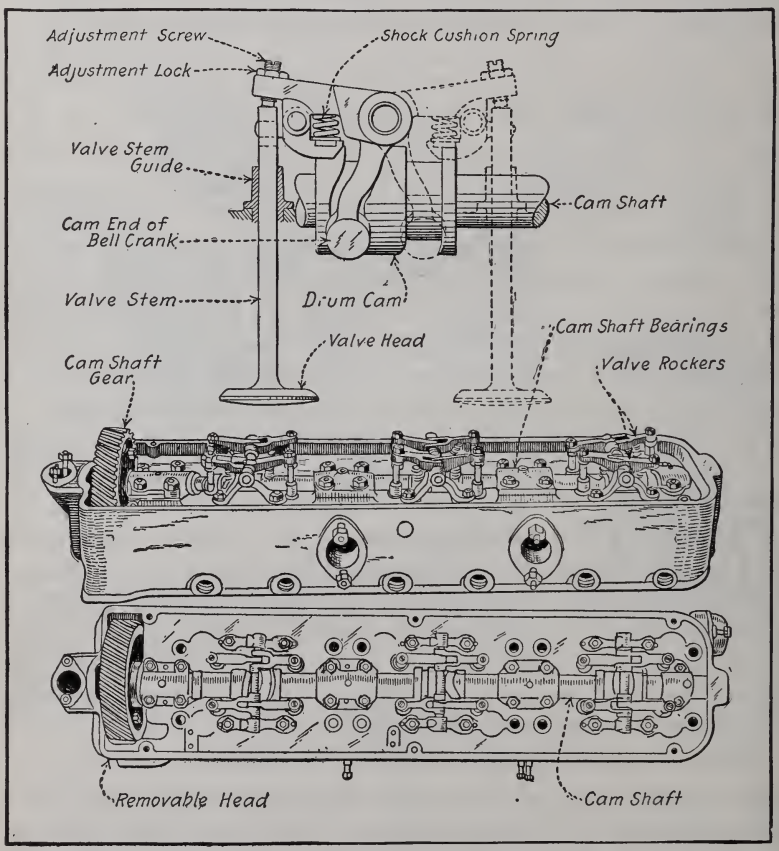


Fig. 197.—Unconventional Valve Action in the 1917 Amalgamated Light Six Engine. Valves are Actuated by Drum Cam and Bell Crank.

member secured between the cam and the valve itself. For this purpose there is a small spring which is said to have a compressibility of about 1/64 in., and in closing the valve the roller pulls the rocker about this amount further after the valve is on its seat. This holds it down firmly, but the amount of movement is so slight

that it does not delay the rapidity of opening, and the mechanism ought not to be liable to suffer from fatigue of any kind.

For each pair of inlets and each pair of exhausts only one cam groove is required, the way in which the rockers operate being shown in the photographs. It will be noticed that the cam shaft lies in a trough, and this is kept filled with oil, so that all the rocker mechanism is continually bathed with lubricant. Oil is supplied from the pump and can overflow, after reaching a certain level, at either end. The front end takes it down to the timing gears and the other returns straight to the sump.

Why Four Valves Per Cylinder Give More Power.—In a very thorough analysis of racing motor design as relates to valve arrangements, A. Ludlow Clayden, writing in *The Automobile,* explains the reason for the higher power output of engines having twice the usual number of valves. Portions of this discussion follow:

"To say that the engineer responsible for a modern racing engine first designs the valve gear and then fits the rest of the engine to it is hardly too strong a statement. There is but one limitation imposed that is outside the control of the engineer, this being the 300 cu. in. piston displacement. Every two revolutions the engine may burn 300 cu. in. of gas if the designer can manage to persuade this amount to enter the cylinders.

"Now the total power that can be developed by a gasoline engine depends upon the amount of gas it can burn, since each cubic foot of good mixture contains just about the same amount of heat. Therefore the engineer wants to get as many revolutions as possible per minute together with the largest possible percentage of charge into the cylinder on each suction stroke. It is no good to increase the speed if the valve area restricts the amount of gas that can pass in a given time. All other things being equal, the larger the valve area the faster can the engine be run without wire-drawing the charge, and this is why racing motor valves are the most important part of the design.

"There is one other limitation in actual fact, as well as the 300 cu. in., this being the volume of the combustion space. To get the best compression ratio the total volume of the charge when compressed must not exceed about one-fifth of its uncompressed volume, which means that the total area into which valves can be put is definitely limited.

"Up to 1912 most of the European racing engines had the conventional two valves per cylinder, but that year and in the years following two-valve construction gave way to the four-valve design now most usual. This is not so much because four valves can provide a

greater *total* area than two, but because four light, small valves can be opened and closed more rapidly than two of equivalent area which are essentially much heavier.

"The weight of a valve head varies roughly in proportion with its area, and the area varies with the square of the diameter. Since the small valve does not require the same thickness of head as the large one, the weight increases actually more rapidly than the diameter squared. With a doubled diameter the weight is multiplied by four and then increased again by a substantial addition to the thickness of the head.

"To appreciate the forces acting on a valve assume the crank shaft speed is 3000 r.p.m., which, of course, means 1500 r.p.m. for the cam shaft. Suppose the inlet valve starts to open 10 deg. after top dead center and remains open 25 deg. after bottom dead center, then it will be open for a total angular movement of the cam shaft of 105 deg. During the first part of the opening, the valve is being accelerated from its seat. It is then decelerated, pauses for a tiny fraction of time, accelerates towards its seat and finally decelerates till it comes to rest on the seat.

"With our assumed timing the acceleration period lasts for about a quarter of 105 deg., namely, 26.5 deg., during which travel it will have been lifted half its total lift. At 1500 r.p.m. of the cam shaft the angular speed is 900 deg. per second, so the acceleration period for the valve is 0.00294 sec.

"Suppose half the lift is 0.2 in. and the weight of the valve 4 oz., then the force necessary to produce the acceleration, neglecting the spring pressure and the weight of the tappet, is 15.5 lb. in round figures. Add the weight of the tappet and half the weight of the spring plus the spring pressure and it will be at least doubled.

"Furthermore, the spring has to do just the same work during the first half of the closing movement of the valve that the cam has to do in the first half of opening movement; thus a four-ounce valve, if it is to follow the cam accurately at 3000 r.p.m. of the crank shaft, may easily need a spring of considerable power.

"Now assume the valve is double the diameter, which means four times the weight and more. Take the weight as being just 1 lb. and the force required increases to 62 lb., considering only the valve and neglecting the tappet, etc. Add the other masses and a spring giving a pressure of 120 lb. or so is the least that will be required.

"Suppose the bore and stroke are 4 in. by 5 in., which is about right for a 300 cu. in. four-cylinder engine; and suppose that we allow a mean velosity of 200 ft. per second through the inlet valve,

which is a normal velocity, then the area of inlet opening needed is approximately 3.15 sq. in. Allowing for the fact that the valve cannot be fully open for more than a small part of its period, we shall need at least 3.5 sq. in. of valve area.

"Now a single valve of 3.5 sq. in. area will be 2.12 in. in diameter. Two valves to have the same total area, 3.5 sq. in., will have to be a shade under 1.5 in. in diameter each. The strength of spring required will be in proportion to the diameters squared as explained before, namely, in the proportion 449 to 225, which means that the pressure throughout the valve mechanism will only be half the amount for the small valve that is necessary for the large one.

"There is still another advantage in the lighter units. A very strong spring needs heavy wire and the rapidity of spring action is

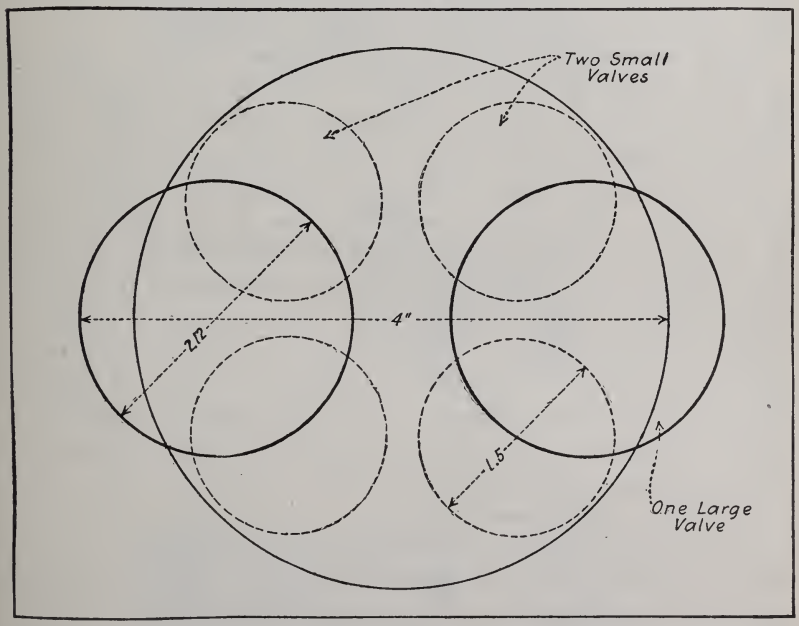


Fig. 198.—Diagram Comparing Space Occupied by Large and Small Valves in Overhead Valve Engines.

dependent upon the section to some extent. A heavy spring is bad, first, because of its weight, and second, because it is more sluggish in action than a spring of lighter section. Incidentally, it has been found that where a spring pressure of 80 lb. is required, faster action may be obtained by using two 40-lb. springs, one within the other, than by employing one spring of full 80-lb. strength.

"The arguments applying to the inlet valves also apply to the exhausts, of course, though the need for size is a trifle less important.

"Taking another aspect of the case; suppose we start with a circle 4 in. in diameter, as shown at Fig. 198, and imagine this to be the top of the piston. On top of this draw two circles of 2.12 in. and also four circles each 1.5. This makes obvious the fact that two valves will necessitate a combustion head with a bulge on each side, while the four valves will practically locate within the four-inch circle.

"Instead of placing the valves with the stems vertical they are usually put at an angle of something near 45 deg. and this allows good water space all around each valve seat, while giving the necessary small combustion space. Also the combustion space thus becomes of a shape which approximates to a hemisphere, and that is the best shape from the viewpoint of thermal efficiency."

Novel Sixteen-Valve Four-Cylinder Engine.—For the last few months there has been considerable talk of sixteen-valve four-cylinder cars, and the latest of these to be mentioned is the Aland, the engine of which is shown at Fig. 199.

While rated at 14 hp., according to formula, the manufacturers state that the engine will develop more than 65 hp. at 3200 r.p.m. The cylinders are cast in a single block and made with the crank case as an integral part. This is an aluminum casting, and the cylinder walls are provided with cast-iron sleeves which are pressed into place. The bore of the engine is 3 in. and the stroke 5½, giving a piston displacement of 155.5 cu. in. and, acording to the maker, 1 hp. from every 2.39 cu. in. of displacement. This high efficiency is explained by careful attention to balance and to the high volumetric efficiency due to the extra large valve areas and the fact that there are four valves per cylinder. Each of these valves is 1 7/16 in. and opens directly into the combustion chamber, being operated by an overhead cam shaft which is located in the alley between the valves. One cam operates two valves through double rocker arms which are provided with roller followers at both ends to minimize friction. The rockers are offset 2 to 1, so that, while the cam lifts the rocker but 9/64 in., the valve is lifted 9/32 in.

An aluminum alloy casting is also used for the cylinder heads. It is held in place on the cylinder block with twelve 7/16 in. nickel-steel studs placed in such a position as not to interfere with water circulation and to be accessible. This cylinder head casting contains the valves, springs, guides, brackets, cam shaft, etc., and forms a separate unit which can be removed without disturbing any adjustment.

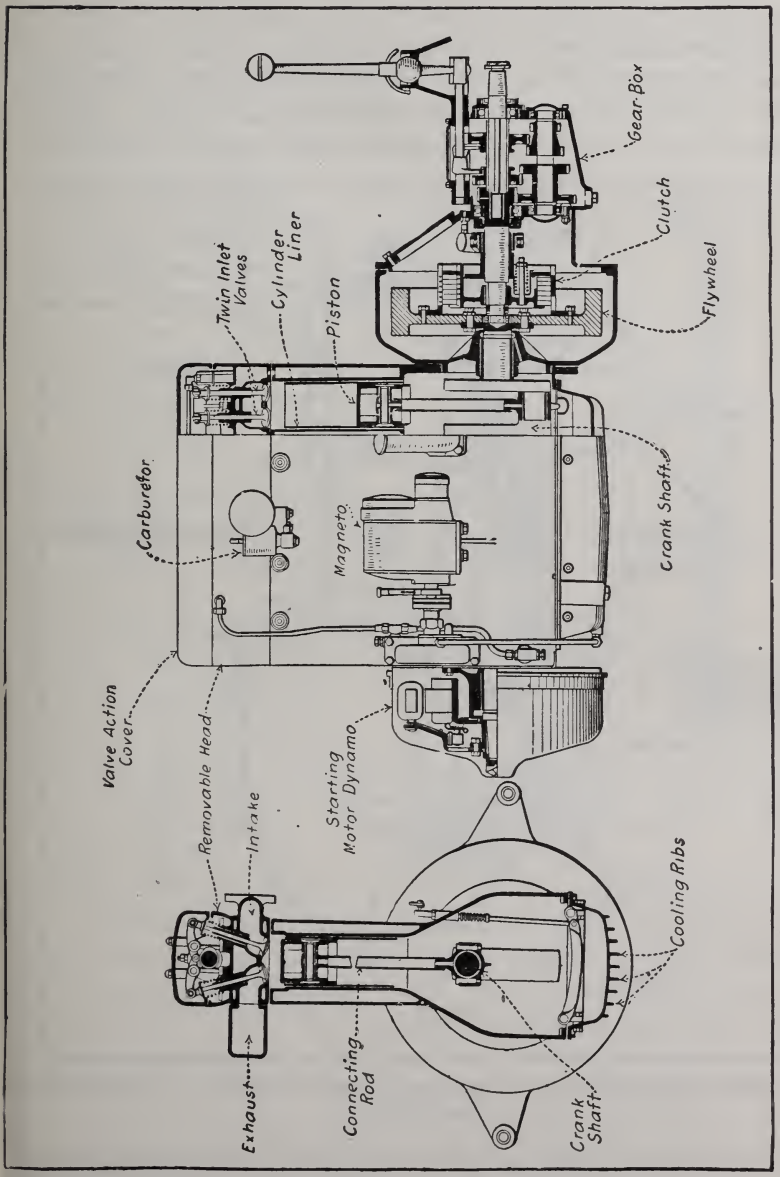


Fig. 199.—Part Sectional Views of Four-Cylinder, Sixteen-Valve Engine of Recent Design.

A feature of importance is that the entire valve mechanism runs in a bath of oil and is protected from dust by means of an aluminum cover which fits over the entire top of the engine block.

Unconventional Poppet Valve Arrangement.—While practically all motors of the L-head form have the valves arranged in the same plane, i. e., one behind the other, efforts have been made to arrange the valves in a different manner in the Julian motor, shown at Fig.

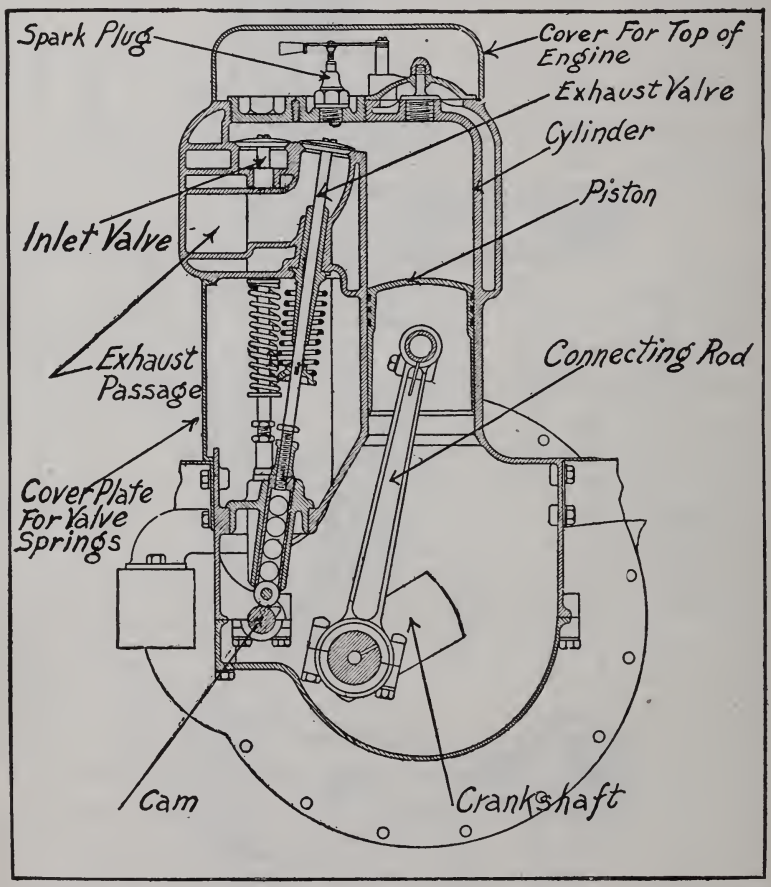


Fig. 200.—Sectional View of Julian Engine, which Employs a Peculiar Valve Arrangement.

200. In this the valves are placed side by side, both being approximately in a line with the center line of the cylinder. It is contended by the designer that this method of placing makes for a better combustion-chamber form than the usual system, though it is difficult to see how this claim is justified, because while the pocket is not as long

as those in which the valves are placed one to each side of the cylinder center line, it is wider and probably has the same amount of space that would be present in the conventional form. The inlet valve is inclined and is the one immediately under the spark plug, while the exhaust valve or outer one is placed vertically, as in conventional construction. The inlet and exhaust manifolds are cast integral with the cylinder block and the arrangement permits of ample water cooling of the exhaust manifold. This form of engine has not been generally applied and is presented simply to show one of many possible valve arrangements.

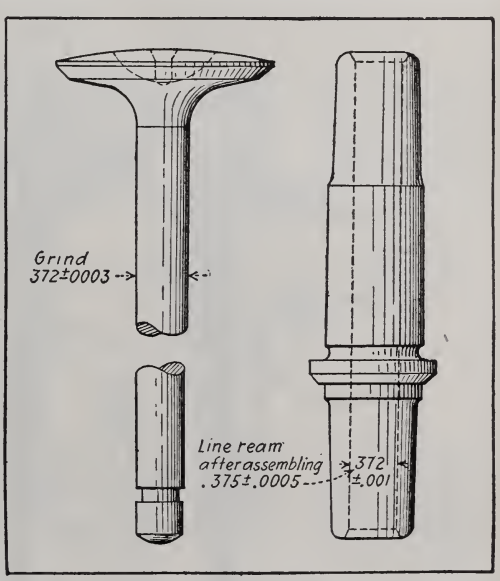


Fig. 201.—Drawing Showing Amount of Clearance Allowed Between Valve Stem and Valve Stem Guide on Continental Motor.

Valve Springs. — Another consideration of importance is the use of proper valve springs, and particular care should be taken with those of automatic valves. The spring must be weak enough to allow the valve to open when the suction is light and must be of sufficient strength to close it in time at high speeds. It should be made as large as possible in diameter and with a large number of convolutions, in order that fatigue of the metal be obviated, and it is imperative that all springs be of the same strength when used on a multiple-cylinder engine. On the exhaust valve the spring must be strong enough so that the valve will not be sucked in on the inlet stroke. It should be borne in mind that if the spring is too strong a strain will be imposed on the valve-operating mechanism and a hammering action produced which may cause deformation of the valve seat. Only pressure enough to insure that the operating mechanism will follow the cam is required. It is common practice to make the inlet and exhaust valve springs of the same tension when the valves are of the same size and both mechanically operated. This is done merely to simplify manufacture and not because it is necessary for the inlet valve spring to be as strong as the other.

Piston and Rotary Valve Motors.—Mention has been previously made of the interest obtaining in various forms of valves which permit more silent operation than the conventional poppet type. The main features of the Knight engine and its advantages have been considered, but a more complete description of the valve action may be timely. The sectional view through the cylinder at Fig. 202 shows the Knight

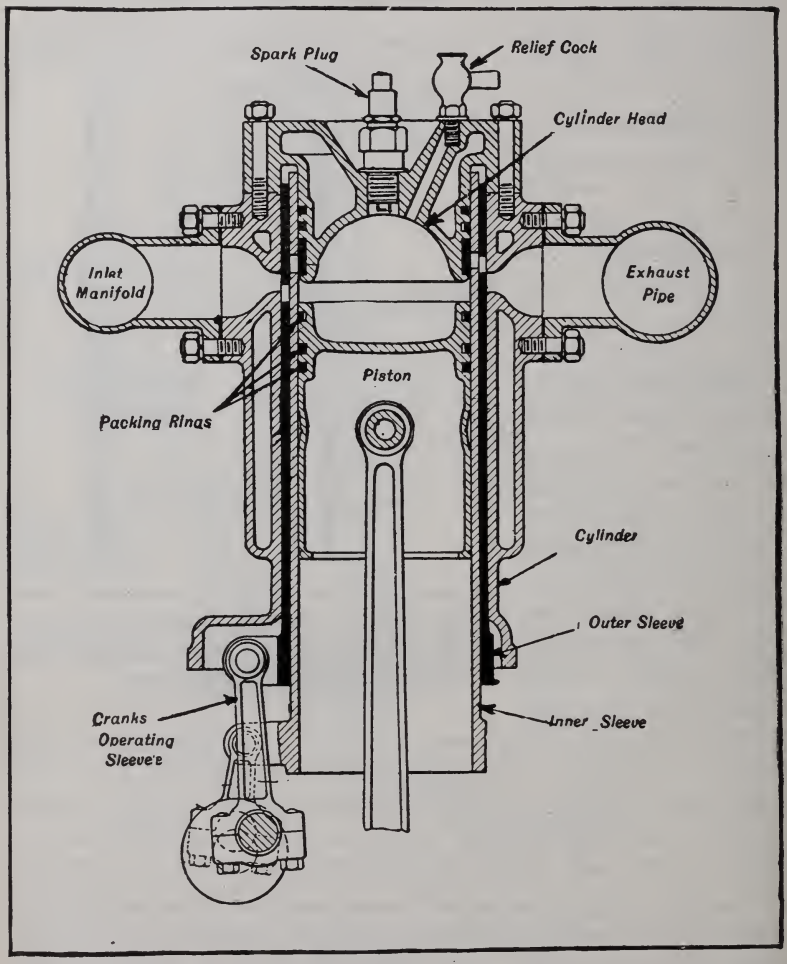


Fig. 202.—Section Through Motor Cylinder, Showing Important Parts of Sleeve Valve Action.

sliding sleeves and their actuating means very clearly. The diagrams at Fig. 203 show graphically the sleeve movements and their relation to the crank shaft and piston travel. At A the piston has reached the

top of the exhaust stroke and the exhaust port is barely open. The inlet port is just beginning to open. At B the piston is about two-thirds down on the inlet stroke and the inner sleeve has moved down, this bringing the two ports in alignment. This movement of the sleeve has closed off the exhaust port. At C the position of the sleeves at the end of the intake stroke is shown. The inner sleeve continues to go up, the outer sleeve is still moving down. Here we see the inlet

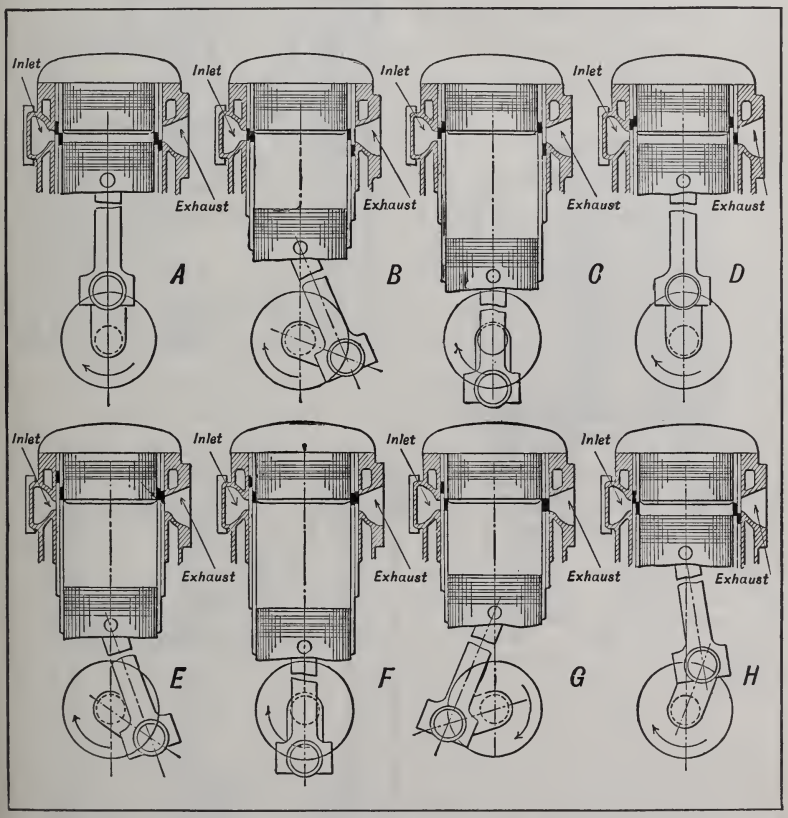


Fig. 203.—Diagrams Showing Relative Movement of Sleeves and Crankshaft of Knight Type Motor. Note Port Opening at Various Positions. Dark Portions of Sleeves Represent Ports.

port is almost closed; the exhaust port entirely so. D represents the position assumed by the sleeves at the end of the compression stroke, both ports are closed and the compressed charge is ready for ignition. At E the piston has covered about three-quarters of the power stroke and the exhaust port begins to open. Both sleeves are now traveling down. At F the piston has reached the bottom of the power stroke

and the exhaust port is almost fully opened. At G the piston is moving upward and the burned gas is being discharged through the fully opened exhaust port. At H the piston has started down on the intake stroke. The exhaust port is fully closed and the inlet port is just be-

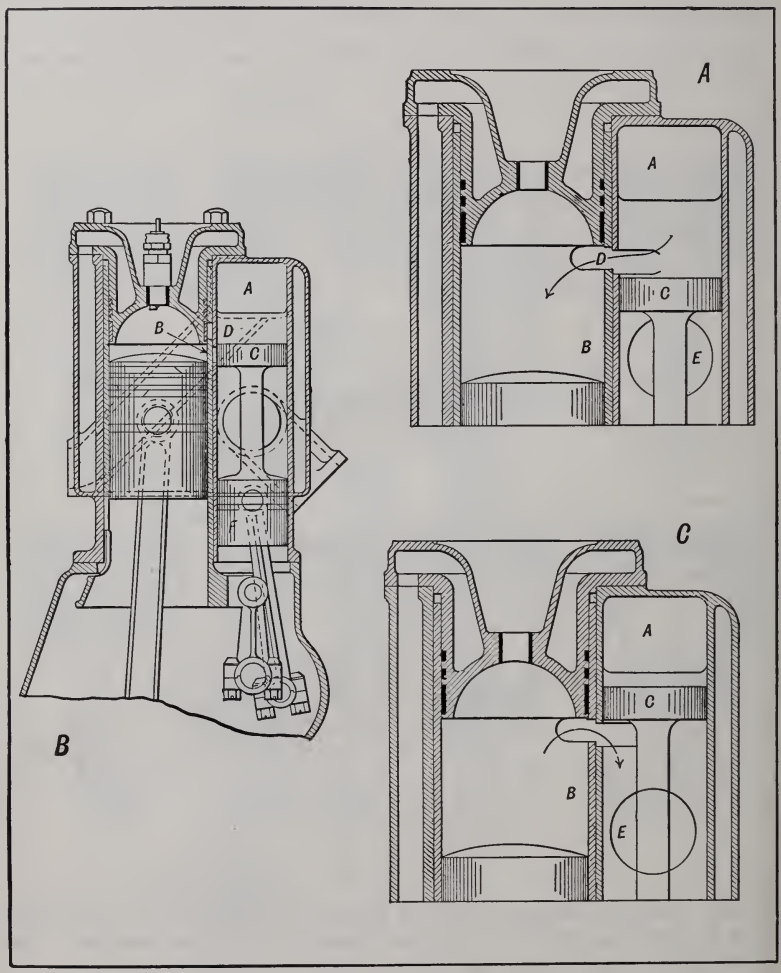


Fig. 204.—Sectional View Showing Action of Miesse Combination Sleeve and Piston Valve at Different Points in Cycle of Engine Operation.

ginning to open. The action may be summed up as follows: The inlet port begins to open when the lower edge of the opening of the outside sleeve which is moving down passes the top of the slot in the inner member also moving downwardly. The inlet port is closed when the

lower edge of the slot in the inner sleeve which is moving up passes the top edge of the port in the outer sleeve which is also moving toward the top of the cylinder. The inlet opening extends over two hundred degrees of crank motion. The exhaust port is uncovered slightly when the lower edge of the port in the inner sleeve which is moving down passes the lower edge of the portion of the cylinder head which protrudes in the cylinder. When the top of the port in the outer sleeve traveling toward the bottom of the cylinder passes the lower edge of the slot in the cylinder wall the exhaust passage is closed. The exhaust opening extends over a period corresponding to about two hundred and forty degrees of crank motion.

The Miesse Engine.—As a glance at the illustration Fig. 204 will show, it is a combination of the single sleeve and piston valve forms. In the views presented, B is the single sleeve in which the port D is formed; A is the inlet and E the exhaust opening. The part designated by C is termed the "distribution" piston. Both the inlet and exhaust passages open into and lead from the small cylinder in which the piston C reciprocates. This, as well as the sleeve B, derives its motion from the cam or valve shaft through connecting rods. But little explanation is necessary to describe the operation of the valves and their effect. At A the relative positions of the sleeve and piston valve during the induction stroke are shown. It will be seen that the port D in the sleeve coincides with the slot in the cylinder proper, and the piston valve C is in such position that while the mixture has free access from A to the cylinder the exhaust port E is cut off therefrom. At B the relative positions of the sleeve and piston valve during the explosion stroke are shown. The port D in the sleeve has moved up above the opening in the cylinder wall while the latter is there closed against any possible escape of gas by the cylindrical head of the piston valve C. The position of the parts on the exhaust stroke are shown at C. The piston valve has risen still further, closing the induction passage A which leads the fresh gases to the cylinder and at the same time has made it possible for the exhaust products to be discharged beneath it through the opening E which is in connection with the exhaust manifold.

The advantages claimed for this design are the use of a single sleeve, cooling of the sleeve cylinder ports and piston valve by the incoming mixture on the induction stroke and the protection of the piston valve from contact with the exploded charge during the power stroke. It is said that the exhaust gases are discharged through the lower orifice rather than the upper one in order that no pressure be exerted upon the head of the piston and upon its connecting rod and

crank pin bearings. By passing the exhaust gases which have considerable pressure between the upper and lower portions of the piston valve the latter is balanced during exhaust period by the products of

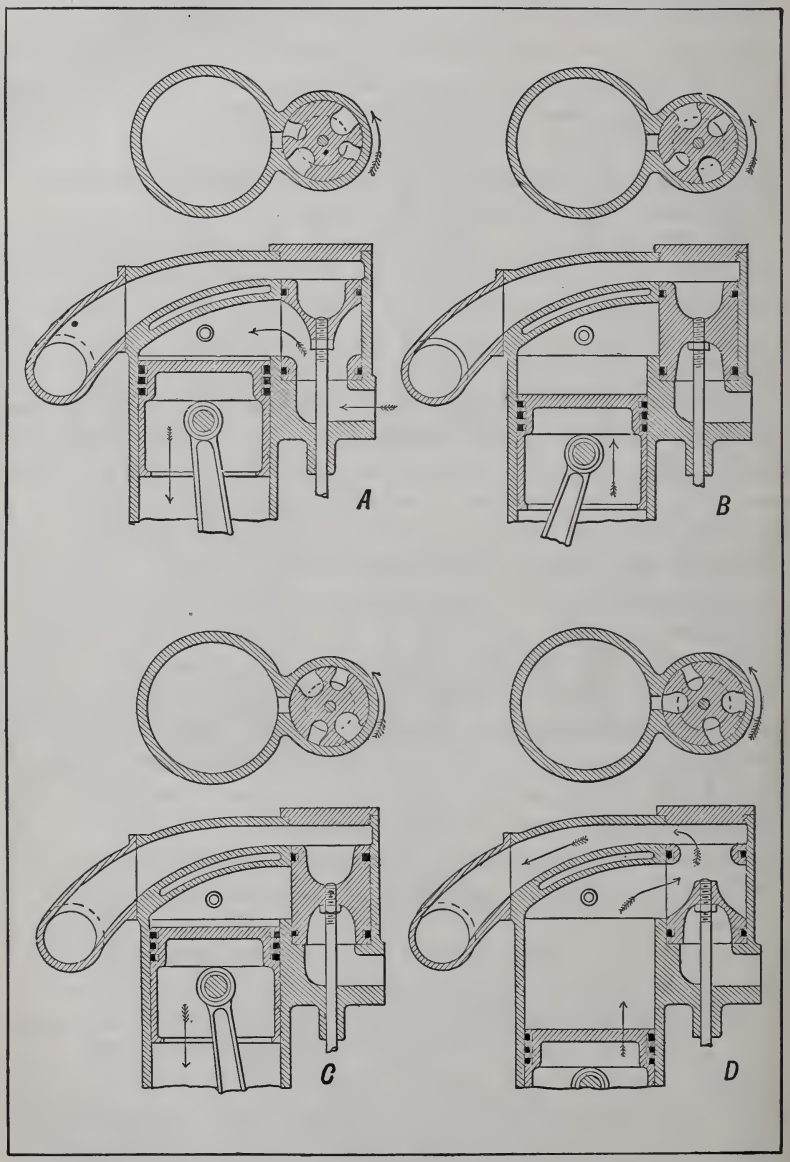


Fig. 205.—Defining Action of Peculiar Rotary Valve Used in Itala (Italian) Engine.

the combustion under pressure. The valve shaft, which is the small auxiliary crank shaft reciprocating the sleeve and piston, is supported on five bearings and is driven by a silent chain connection from the main crank shaft. This engine has not received very wide application and it is presented here solely to show an ingenious valve action.

The Itala Rotary Valve Motor.—A type of rotary valve which is said to be efficient is depicted at Fig. 205. This is used in the Itala engine and has features of merit. This motor does not differ much in appearance from the ordinary poppet valve type. The cylinders are cast in pairs with a projection at one side which acts as a cylinder for the valve. Provision is made for water circulation around this chamber and the valve is also formed in such a way that water may be circulated through it. But two valves are employed, one for each pair of cylinders, and these two members take the place of the eight valves used on the poppet engine. The valve driving shaft, which is placed similar to the conventional cam shaft, turns the vertical shaft to which the valves are attached by helical gears. There is but one port in each cylinder which provides the means of communication between the valves and combustion chamber, this alternately serving the purpose of inlet and exhaust port. The manifolds are on opposite sides of the engine. The gas enters the base of each valve chest and the inert products pass from the top of the valve chamber by a peculiar cored passage in the cylinder casting. The rotary valve is made of cast iron and carries a number of packing rings. Each valve has four vertical openings: two for the fresh gases, the others for the burned product. These openings are arranged so that there is one inlet and one exhaust port registering with the openings in the respective cylinders. The exhaust ports are wider than the inlet openings, because a longer period of opening is required for the exhaust.

The views at Fig. 205 show the operation of the valve clearly. A depicts its position at the beginning of the intake stroke, the fresh gas entering from the bottom passes through the interior of the valve and into the combustion chamber. The smaller sectional views show a plan of the cylinder and valve chest. Referring to these it will be seen that the valve which is rotating in the direction of the arrow is just beginning to uncover the port in the cylinder. At B conditions during the compression stroke are shown. The port in the cylinder is closed by the solid wall of the valve. At C the position of the valve during the power stroke is shown. It will be observed that the opening in the cylinder is still closed by the valve wall. At D the conditions during the exhaust stroke are outlined. The valve has revolved so that the exhaust port therein is in communication with the exhaust

pipe at the top of the cylinder and the port of the combustion chamber. This permits the inert gases to leave the cylinder freely. Careful study of the drawings will show that the gas flow is easy and that there are no sharp corners to impede the gases as they enter or leave the cylinders.

The Reynolds Rotary Valve Motor.—The Reynolds motor, a sectional view through one of its cylinders being shown at Fig. 206, has

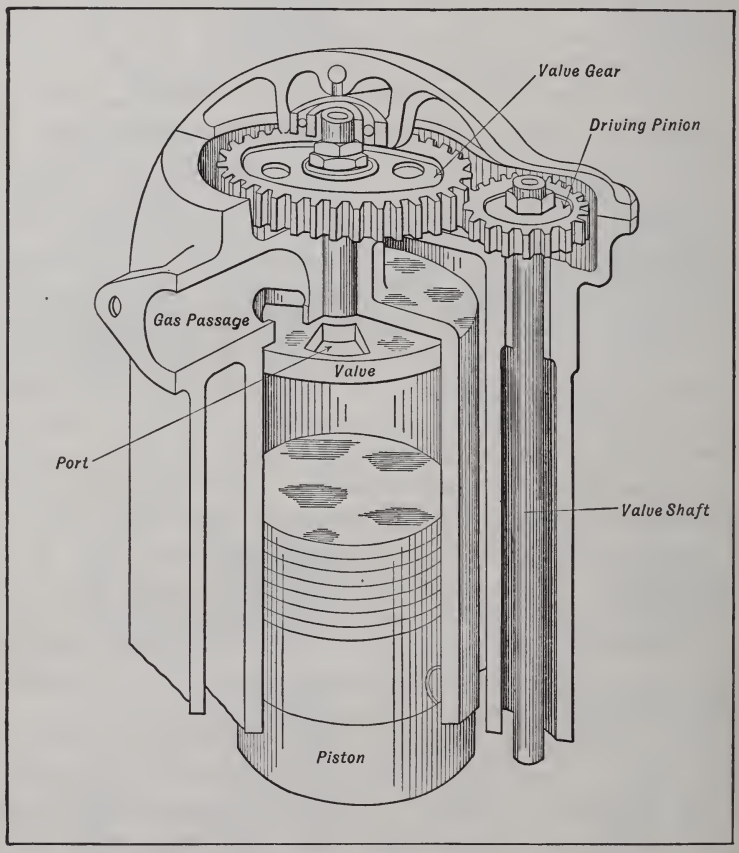


Fig. 206.—Partial Section of Reynolds Rotary Valve Motor Cylinder, Showing Method of Rotating Simple Disk Valves and Ports in the Cylinder Head.

not been used to any extent in automobile service, but has been tried out in marine applications. The valve consists of a flat disk seating directly against the top of the combustion chamber. It is turned by a shaft which extends through a boss on top of the cylinder head and which is driven direct from the crank shaft by gearing at half the

motor speed. The valve has a port cut into it of the keystone shape, clearly shown in illustration, this registering successively with openings in the cylinder head. The valve mechanism is said to be very quiet, and, as will be seen at Fig. 207, the motor is a very compact de-

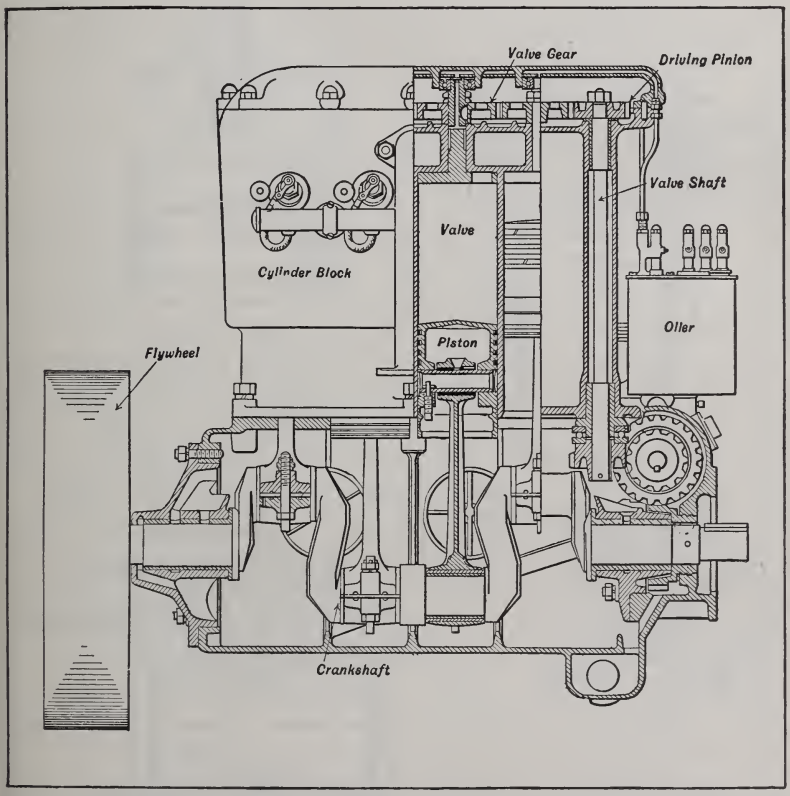


Fig. 207.—Part Section of Reynolds Rotary Valve Motor, Showing Practical Application of Ported Disk in Controlling Gas Passages.

sign. A disadvantage is cited that the force of the explosion keeps the valve disk tight against the seat, this tending to cause considerable resistance to its motion. It is claimed that no difficulty is experienced from this source, and that an oil film is maintained positively between the valve disk and its seat so that it turns with minimum friction.

Other Rotary Valve Types.—Various other forms employing rotary valves have been devised, and some of these which are said to have been used in a practical way are shown at Fig. 208. That at A is known as the Mead. This is a four-cylinder motor with two long cylindrical valves extending along opposite sides of the cylinders in

close connection with the combustion chamber. These cylinders have ports cut through them at distances equal to the center line of the

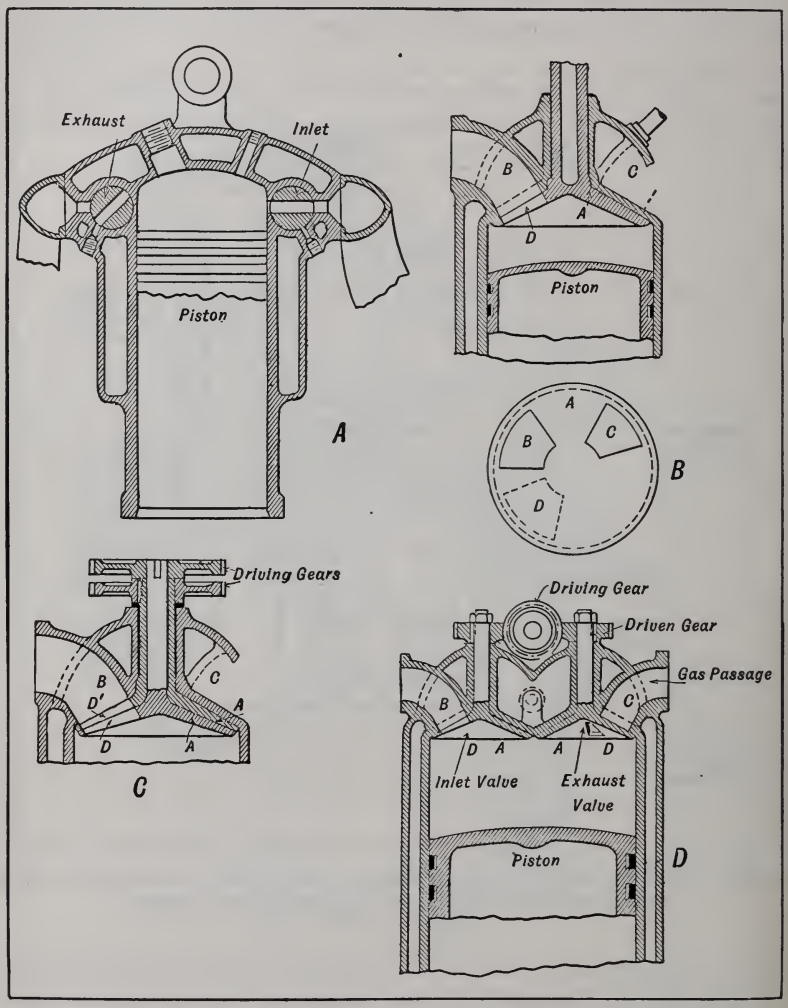


Fig. 208.—Experimental Forms of Rotary Valve Motors Designed to Meet the Present Day Demand for Silent Valve Action. A—Mead Motor Using Two Revolving Cylindrical Valves, One at Each Side of Cylinder. B—Single Ported Cone Valve. C—Application of Two Single Ported Cone Valves, One Carried Above the Other. D—Use of Two Cone Valves, One for Inlet Port, the Other to Govern Exhaust Passage.

cylinders and are suitably spaced so that the ports in the cylinders are uncovered in proper succession. One of the drums serves to control

the inlet ports; the other regulates the exhaust openings. The valves are driven at one-quarter crank-shaft speed by suitable gearing.

The type shown at B is a French design which differs from the Reynolds motor previously described only in the shape of the rotary valve member which is conical instead of flat. The parts are shown as follows: A is the rotary valve member; B is the gas passage, and D is a port in the valve member. The small view presented below the vertical section is a plan showing the disposition of the ports. The same lettering applies as above. If the cone turns in the direction of the arrow, B is the exhaust port and C the intake port, while D represents the opening in the valve. The form shown at C is a modification of that depicted at B. Two conical valves are used instead of one, these being turned in opposite directions by suitable gears. It is claimed that this gives a more rapid port opening than when a single valve is employed. Sometimes when two conical valve members are used they are placed side by side, as shown at D, one of these serving exclusively for the exhaust; the other for the inlet. The objection to this construction is that owing to the smaller size of the cone the ports are more limited in area than when a single valve member is employed.

Rotary Cone Valve of Carbon.—Designed to eliminate poppet valves from the conventional motor truck or passenger car gasoline motor, a new type of rotary valve patented and recently tested by Edward and Frank W. Heymann, Boston, Mass., and described and illustrated in the "Commercial Vehicle," is made of pure carbon. The valve is in the shape of a truncated cone and is revolved in a steel seat. As the coefficient of expansion of the carbon valve is slightly less that of the steel seat any tendency of the valve to swell and stick in its seat due to the difference in temperature between the center of the valve and the exterior of the seat is practically eliminated. As the valve is made of commercially pure carbon, one of the best lubricants known, it is self-lubricating. Carbon is also a material of great heat-resisting qualities, so that the heat of the hot exhaust gases does not burn out the valve or warp it. This property of carbon, together with its anti-friction characteristic, insure a tight fit between the valve and its seat, notwithstanding the high degrees of heat to which both parts are subjected. The inventors claim that their test engine has run for the equivalent of 40,000 miles of travel without the valves showing any signs of wear and without leaking.

Other claimed advantages of the valve are that it can be made at one-tenth the cost of the present-day iron poppet valve and that when worn out it can be replaced by another at much less than the cost of regrinding necessary on a poppet valve of the same life. It is also

claimed that the tightness of the carbon valve in its seat throughout its period of usefulness will save a considerable amount of gasoline which is wasted with the conventional poppet valve as soon as it begins to become pitted and permits gasoline to leak past it when imperfectly closed. The use of such a valve would eliminate all grinding operations, and the necessity for spring adjustment as in the poppet type of today. One carbon valve may serve to admit and discharge the gases from one or two cylinders or from three or more arranged concentrically about it. This is accomplished by the number of ports cut in the valve and its speed of rotation.

As shown in the cross-sectional sketch, Fig. 209, the valve has two rectangular ports cut in its curved sides and placed approximately

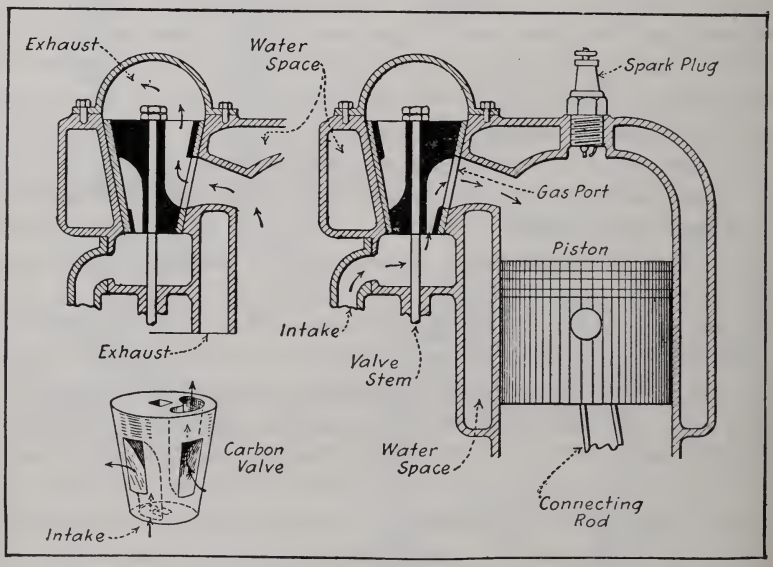


Fig. 209.—Revolving Cone Valve of Carbon, an Unconventional Development.

90 deg. apart. A passage-way is cut from one of these ports to the large top of the valve, terminating in a crescent-shaped opening. A second passage is cut from the other port to a similar crescent-shaped opening in the bottom of the valve. Each port and its communicating crescent-shaped opening are on the same side. The opening in the top serves as the exhaust port, and that in the bottom as the intake port. The valve itself is placed in the space between the curvature of two adjacent cylinders and, in the case of the two-port valve described, revolves at one-half the motor speed. In case four instead of two ports are employed they are spaced opposite, but the valve is

rotated at one-fourth the engine speed instead of one-half, as is the case in the two-port design. Each cylinder, therefore, uses opposite ports of the same nature alternately. Duration of opening depends on the port shape.

Another characteristic of the carbon valve is that only one passage is used from each cylinder to the valve seat and that this passage serves to both admit the incoming fuel and discharge the burnt exhaust gases. This is shown graphically in the sketch in Fig. 209, which gives the location of the exhaust manifold directly above the intake passage, with the valve seat situated between the two and the top of the valve in the exhaust manifold and the bottom in the intake passage. At the beginning of and during the suction stroke the valve is rotated in its seat by conventional means or otherwise from the main crank shaft, so that the port in the valve is made to coincide with the port in the valve seat leading to one of the cylinders. The gas passes up through the bottom of the valve, through the coinciding ports in the valve and seat and into the passage leading to the cylinder. Then as the valve is rotated at half the speed of the motor, the latter has its compression and firing stroke before the valve has made one-half revolution and the exhaust port of the latter is brought opposite the valve seat port to permit the exhaust gases to pass through the valve and up into the exhaust manifold. A further one-half revolution of the valve similarly takes care of the intake and exhaust of the second cylinder of the unit. The valve is carried on a vertical rod with a squared shank to keep it from turning in relation to the rod which is threaded at the extreme top for a hold-down nut which may be screwed down to take up any slight wear which might occur during the life of the valve.

The Sphinx Ring Valve Motor.—One of the designs which has been used successfully and which employs a ring valve in place of the usual poppet valves is called the Sphinx motor. It is claimed that all the advantages of the sliding sleeve types are obtained with much less complication. In this motor a split ring reciprocated by a bell crank serves to uncover the intake and exhaust ports. The construction of this member, as well as the actuating bell crank, return spring and cam shaft are clearly shown at Fig. 210. In the cylinder walls, and near the head, two annular chambers are provided, these forming the intake and exhaust ports. Within the cylinder is a split ring having sufficient face depth to cover both the intake and exhaust ports, but having the necessary reciprocating motion to allow it to uncover either one or the other of the ports as required to insure the admission of the fuel and the discharge of the spent gases. In its central position,

shown at Fig. 210, B and C, the split ring covers the two ports, providing a gas-tight chamber; on being moved down, as depicted at A, it uncovers the intake port and closes the exhaust, and on being raised, as outlined at D, it opens the exhaust and closes the intake.

Being split, its extensibility assures gas-tightness, the degree of tightness being in proportion to the pressure in the cylinder, while leakage around the ports is impossible at any time. Its movement is

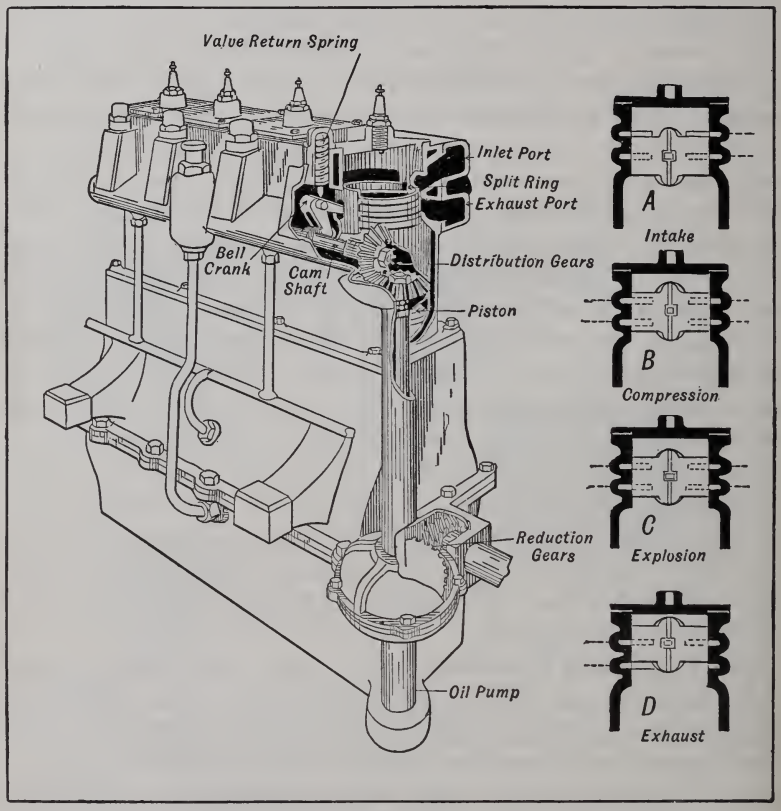


Fig. 210.—Part Section of Sphinx Valveless Motor, in which Poppet Valves are Replaced by a Split Ring which Reciprocates in the Cylinder Head, Opening and Closing the Gas Ports as it Moves Up and Down. A—Inlet Port Opened. B and C—All Ports Closed. D—Exhaust Ports Opened.

slight, being less than one inch for a motor of 3.9-inch by 5.5-inch bore and stroke, and the intake port being above the ring, this latter is swept by the fresh, cool gases at every induction stroke and consequently maintained at a moderate temperature.

This design particularly lends itself to an easily produced and clean monobloc casting, and has the further advantage of giving a compact combustion chamber without pockets and with unusually large valve area. On the ordinary type of motor with valves on one or both sides any increase in the valve diameter involves a proportional increase in the size of the pocket with a decrease of thermal efficiency.

The split sliding ring, or sleeve, which in the "Sphinx" replaces the pair of poppet valves of the ordinary motor, and the costly concentric sleeves in motors of the sliding valve type, is shown in Fig. 210. It is a gray iron casting, having a face depth of one and a half inches for a motor of 3.9-inch by 5.5-inch bore and stroke, and provided with a hollow spindle or bearing block for the rocker arm. As will be seen from the illustration, the depth of the ring is greater around the hollow spindle than at any other point, this increased depth being necessary to cover the port through which the rocker arm is passed from the outside to the inside of the cylinder. The face depth as the point is sufficient to assure the covering of this port whatever the position of the split ring; in other words, this slot in the cylinder wall is never uncovered.

By means of a bell crank, the long arm of which operates in the socket of the ring valve, and an ordinary type of cam shaft the necessary reciprocating motion of the ring is obtained to allow the different phases of a four-cycle motor. One of the most valuable features of this motor is the large valve area obtainable without the complication attending the use of large diameter poppet valves and without the big pockets necessary with motors of the "L" or "T" type.

The poppet valve spring must be of sufficient strength to correctly seat the valve at high motor speeds. If a weak spring is used it will not have time to return the valve to its seating before it will be again lifted by the cam and there is loss of power. The spring used on the "Sphinx" motor need only be strong enough to balance the weight of the split ring, for it is only responsible for its return and in no way for its proper seating. Further, as each upward movement of the ring is followed by the induction stroke of the motor, the work of the spring is relieved by the inrushing of the gases. In other words, the suction of the gas around the ring tends to draw it down, just as an automatic intake valve is drawn down on the suction stroke of the motor. The spring, then, need only be sufficiently strong to keep the roller in contact with the face of the cam, and as it is carried in an independent housing and not subjected to a high temperature, its life is practically indefinite.

Darracq Rotary Distributor Motor.—In the Darracq power plant which is shown at Fig. 211, the gases enter through a rotary member of D section, which is placed horizontally along the side of the cylinder

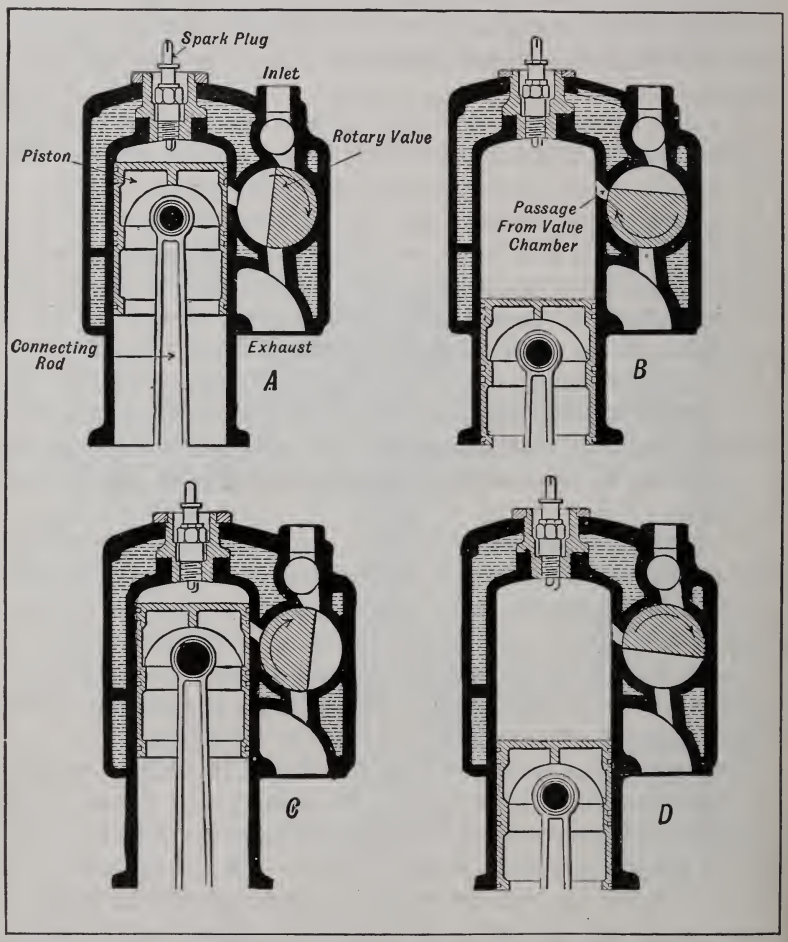


Fig. 211.—Diagram Illustrating Action of Darracq (French) D-Form Rotary Valve Motor. A—Piston at Beginning Stroke. B—Piston at Inception of Compression Stroke. C—Piston in Position for Receiving Explosion Impact. D—Valve Position at Start of Exhaust Period.

head and parallel with the crank shaft. This distributor is approximately two-thirds the diameter of the cylinder and revolves on large annular ball bearings, one placed at each end. One member serves to control both intake and exhaust openings. This is accomplished by

providing the barrel-shaped chamber in which the valve revolves with three ports for each cylinder. One of these provides communication between the valve case and the combustion chamber, the others serve for intake and exhaust passages.

As the valve rotates the cylinder is placed in communication with either the intake or exhaust passages and the valve is driven by suitable gearing at one-half the engine speed, as is the case with the conventional cam shaft. The various valve positions are clearly shown at Fig. 211. A corresponds to the suction stroke; and the piston is shown starting to uncover the port leading from the valve chamber into the cylinder. The rotary valve is also uncovering the intake port. By the time the top of the piston reaches the bottom of the passage communicating between combustion and valve chambers, the inlet opening is uncovered and the gas rushes into the cylinder. At B it will be seen that the valve has closed the passage leading from the cylinder, and as the piston rises, the gas previously inspired is compressed. The position of the piston when it has reached the end of the compression stroke is shown at C. At this position the compressed charge is ignited. It will be noted that the piston covers the port leading into the valve chamber, and that the valve is thus protected from the direct heat of combustion. At D the position of the valve at the inception of the exhaust stroke is shown, and it is about to uncover the port leading from the cylinder to the valve chamber and permit the exhaust gases to flow out through suitable openings. The heat evolved during the first intervals of the explosion, at which point the maximum temperature obtains, is kept from the valve and simplifies the problem of lubrication. It will be evident that with this construction a small portion of the inert gases are retained in the combustion chamber, but it is claimed by those favoring this construction that this does not constitute as serious a defect in practice as theoretical consideration might indicate.

The Hewitt Piston Valve Motor.—A type of motor in which true piston valves are used successfully is shown in section at Fig. 211. This is the Hewitt, a pioneer form of English derivation. Two piston valves are provided for each cylinder; one for the intake, the other to regulate the exhaust passage. They are placed adjacent to each other on the same side of the motor, and are inclined toward the top. A small crank shaft revolving at one-half the speed of the main crank shaft is employed to operate the piston. All of these piston valves are simply smaller trunk pistons similar in type to those used in the cylinder proper, reciprocating in their distinct small water-cooled cylinder. Piston rings of the conventional pattern are used to maintain

a gas-tight joint, as is the case with the main piston. The fresh gas manifold is coupled to the side of one valve cylinder and the exhaust piping with the side of the other valve chamber. The timing of both intake and exhaust valves is such that they receive a portion of the explosive impulse, which drives them downward and tends to make them partially self - operating. When the explosion occurs, both valve pistons are at the top of their cylinders and receive part of the impact. On the compression stroke both pistons move up, the exhaust member moving ahead of the other. The piston valves are lubricated by splash just as the main piston chamber. These pistons have comparatively long stroke, about two-thirds that of the working piston. The various piston positions during the cycle of operation are clearly shown in diagrams at Fig. 213, the valves being shown at opposite sides of the cylinder to make their action clearer. At A the main piston is part way down on the intake stroke, and the inlet piston has uncovered the slots leading from the gas manifold to the combustion chamber. The exhaust is fully closed. At B the main piston is starting to go up on the compression stroke and both inlet and exhaust ports are fully closed by their respective pistons. At C the explosion has taken place and the three pistons are being driven down in the directions indicated by the arrow. At D the exhaust piston has uncovered the series of holes which provide communication between the combustion chamber and the manifold, while the inlet piston covers fully the slots it controls. It is claimed that this four-cylinder piston valve motor has superior torque to that obtained from a similar power plant using poppet valves.

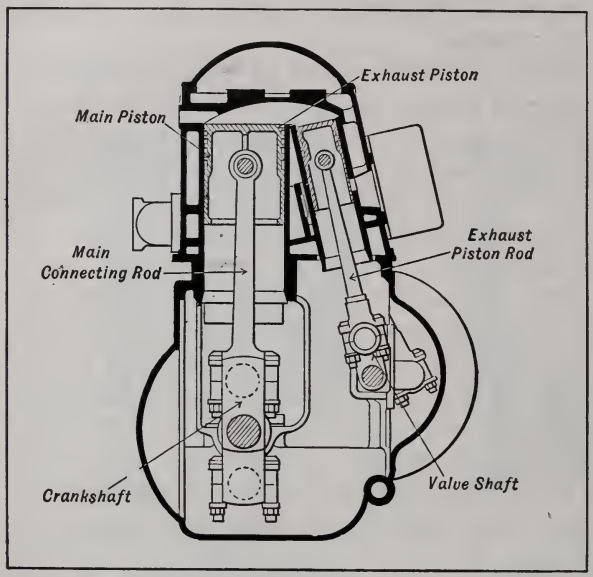


Fig. 212.—Sectional of Hewitt Piston Valve Motor Cylinder and Valve Chest.

The Fischer Slide-Valve Motor.—The Fischer slide-valve motor employs a very peculiar form of reciprocating member to control the flow of gases in and out of the cylinder. These valves, which are crescent shape in cross section, operate in suitably formed recesses in the opposite sides of the cylinder bore, which is not a circle, as in the usual construction, but an irregular figure composed of approximately two semi-circular parts connected by two crescent-shaped parts. The slide valves occupy approximately 69 degrees of the cylinder-wall circumference. They are of cast iron and extend the entire length of the cylinder and approximately two inches below it. At their lower extremities they carry slots for the engagement of the operating bell-crank mechanism worked by box cams, mounted on shafts which are driven by silent chains from the crank shafts.

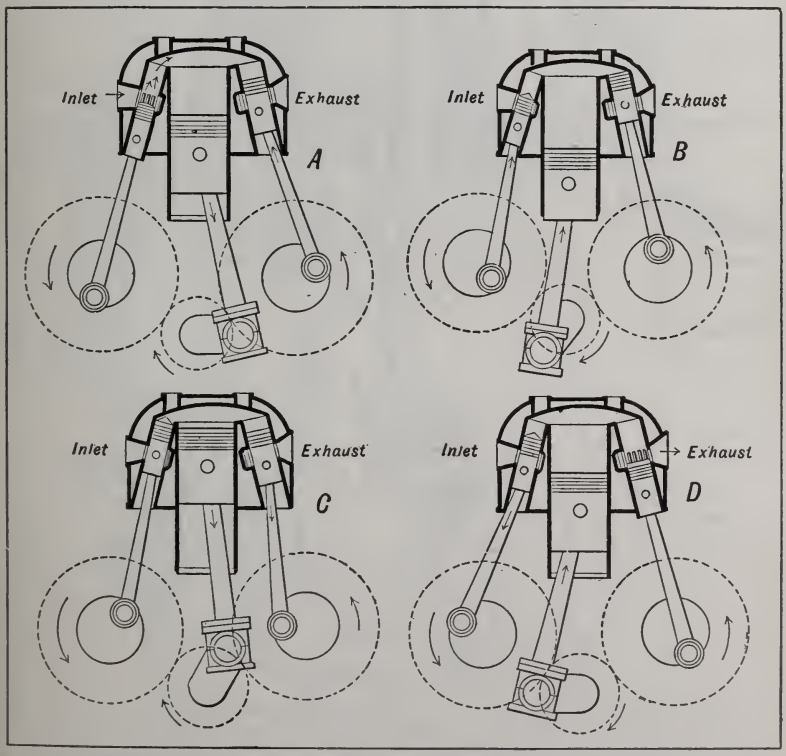


Fig. 213.—Hewitt Piston Valve Motor Action Graphically Outlined. A—Suction Stroke. B—Compression. C—Explosion. D—Exhaust.

The sleeves are reciprocated by bell cranks, one end being attached to the sleeve, the other arm carrying a roller which fits the depression

in the cam. This form of cam insures positive movement in both directions and makes it possible to entirely dispense with the use of springs.

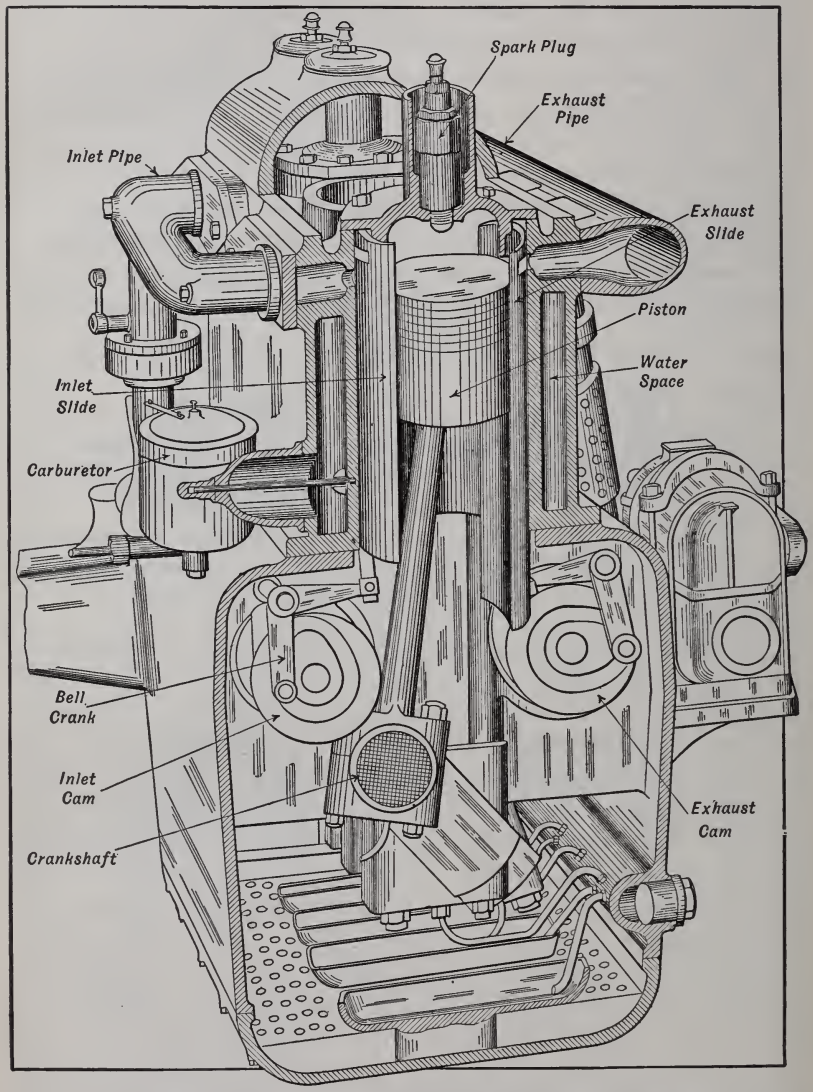


Fig. 214.—Part Sectional View of Fischer Slide Valve Motor.

The slides are provided with suitable slots or ports which register with openings in the cylinder walls communicating with the inlet and exhaust passages respectively. The arrangement of the cams is such

that the reciprocation of the sleeves gives the following timing: The inlet has a lag of 11 degrees after the upper dead center and closes 71 degrees after lower dead center. The exhaust opens 63 degrees before lower dead center and closes 19.75 degrees late, or after the piston reaches the top of its exhaust stroke. This means that the intake and exhaust overlap approximately 8 degrees, which is claimed to give additional power. Owing to the peculiar box-cam construction the slide valves are not in motion during the compression and power strokes. The Fischer motor is a four-cylinder monobloc type with a bore of 3⅝ inches and a stroke of 4¾ inches. The pistons reciprocate up and down in a cylinder which is composed of two fixed portions and two movable sleeves. After the sleeves are in place the interior of the cylinder bore is a true circle and the piston has an even bearing on all portions of the cylinder wall and sleeves. The general features of construction and the arrangement of the sliding sleeves and their actuating mechanism are clearly shown at Fig. 214.

Valve Timing.—It is in valve timing that the greatest difference of opinion prevails among engineers and it is rare that one will see the same formula in different motors. It is true that the same timing could not be used with motors of different construction, as there are many factors which determine the amount of lead to be given to the valves. The most important of these is the relative size of the valve to the cylinder bore, the speed of rotation it is desired to obtain, the fuel efficiency, the location of the valves, and other factors too numerous to mention.

Most of the readers should be familiar with the cycle of operation of the internal combustion motor of the four-stroke type, and it seems unnecessary to go into detail except to present a review. The first stroke of the piston is one in which a charge of gas is taken into the motor; the second stroke which is in reverse direction to the first is a compression stroke, at the end of which the spark takes place, exploding the charge and driving the piston down on the third or expansion stroke, which is in the same direction as the intake stroke, and finally, after the piston has nearly reached the end of this stroke, another valve opens to allow the burned gases to escape, and remains open until the piston has reached the end of the fourth stroke and is in a position to begin the series over again. The ends of the strokes are reached when the piston comes to a stop at either top or bottom of the cylinder and reverses its motion. That point is known as a center and there are two for each cylinder, top and bottom centers, respectively.

All circles may be divided into 360 parts, each of which is known

as a degree, and in turn each of these degrees may be again divided into minutes and seconds, though we need not concern ourselves with anything less than the degree. Each stroke of the piston represents 180 degrees travel of the crank, because two strokes represent one complete revolution or three hundred and sixty degrees. The top and bottom centers are therefore separated by 180 degrees. Theoretically each phase of a four-cycle engine begins and ends at a center, though in actual practice the inertia or movement of the gases makes it necessary to allow a lead or lag to the valve, as the case may be. If a valve opens before a center, the distance is called "lead"; if it closes after a center, this distance is known as "lag." The profile of the cams ordinarily used to open or close the valves represents a considerable time in relation to the 180 degrees of the crank-shaft travel, and the area of the passages through which the gases are admitted or exhausted is quite small owing to the necessity of having to open or close the valves at stated times; therefore, to open an adequately large passage for the gases it is necessary to open the valves earlier and close them later than at centers.

That advancing the opening of the exhaust valve was of value was discovered on the early motors and is explained by the necessity of releasing a large amount of gas, the volume of which has been greatly raised by the heat of combustion. When the inlet valves were mechanically operated it was found that allowing them to lag at closing enabled the inspiration of a greater volume of gas. Disregarding the inertia or flow of the gases, opening the exhaust at center would enable one to obtain full value of the expanding gases the entire length of the piston stroke, and it would not be necessary to keep the valve open after the top center, as the reverse stroke would produce a suction effect which might draw some of the inert charge back into the cylinder. On the other hand, giving full consideration to the inertia of the gas, opening the valve before center is reached will provide for quick expulsion of the gases, which have sufficient velocity at the end of the stroke, so that if the valve is allowed to remain open a little longer, the amount of lag varying with the opinions of the designer, the cylinder is cleared in a more thorough manner.

Blowing Back.—When the factor of retarded opening is considered without reckoning the inertia of the gases it would appear that, if the valve were allowed to remain open after center had passed, say, on the closing of the inlet, the piston, having reversed its motion, would have the effect of expelling part of the fresh charge through the still open valve as it passed inward at its compression stroke. This effect is called blowing back and is often noted with motors where the valve

settings are not absolutely correct, or where the valve springs or seats are defective and prevent proper closing.

This factor is not of as much import as might appear, as on closer consideration it will be seen that the movement of the piston as the crank reaches either end of the stroke is less per degree of angular movement than it is when the angle of the connecting rod is greater. Then again a certain length of time is required for the reversal of motion of the piston, during which time the crank is in motion but the piston practically at a standstill. If the valves are allowed to remain open during this period, the passage of the gas in or out of the cylinder will be by its own momentum.

Lead Given Exhaust Valve.—The faster a motor runs, all other things being equal, the greater the amount of lead or advance it is necessary to give the opening of the exhaust valve. It is self-evident truth that if the speed of a motor is doubled, it travels twice as many degrees in the time necessary to lower the pressure. As most designers are cognizant of this fact the valves are proportioned accordingly. It is well to consider in this respect that the cam profile has much to do with the manner in which the valve is opened, that is, the lift may be abrupt and the gas allowed to escape in a body, or the opening may be gradual, the gas issuing from the cylinder in thin streams. An analogy may be made with the opening of any bottle which contains liquid highly carbonated. If the cork is removed suddenly the gas escapes with a loud pop, but on the other hand, if the bottle is uncorked gradually, the gas escapes from the receptacle in thin streams around the cork, and passage of the gases to the air is accomplished without noise. While the second plan is not harsh, it is slower than the former, as must be evident.

Exhaust Closing, Inlet Opening.—A point which has been much discussed by engineers is the proper relation of the closing of the exhaust valve and the opening of the inlet. Theoretically they should succeed each other, the exhaust closing at upper dead center and the inlet opening immediately afterward. The reason why a certain amount of lag is given the exhaust closing in practice is that the piston cannot drive the gases out of the cylinder unless they are compressed to a degree in excess of that existing in the manifold or passages, and while toward the end of the stroke this pressure may be feeble, it is nevertheless indispensable. At the end of the piston's stroke, as marked by the upper dead center, this compression still exists, no matter how little it may be, so that if the exhaust valve is closed and the inlet opened immediately afterward, the pressure which exists in the cylinder may retard the entrance of the fresh gas and a certain por-

tion of the inert gas may penetrate into the manifold. As the piston immediately begins to aspirate this may not be serious, but as these gases are drawn back into the cylinder the fresh charge will be diluted and weakened in value. If the spark plug is in a pocket the points may be surrounded by this weak gas, and the explosion will not be nearly as energetic as when the ignition spark takes place in pure mixture.

It is a well-known fact that the exhaust valve should close after dead center and that a certain amount of lag should be given to opening of the inlet. The lag given the closing of the exhaust valve should not be as great as that given the closing of the inlet valve. Assuming that the excess pressure of the exhaust will equal the depression during aspiration, the time necessary to complete the emptying of the cylinder will be proportional to the volume of the gas within it. At the end of the suction stroke the volume of gas contained in the cylinder is equal to the cylindrical volume plus the space of the combustion chamber. At the end of the exhaust stroke the volume is but that of the dead space, and from one-third to one-fifth its volume before compression. While it is natural to assume that this excess of burned gas will escape faster than the fresh gas will enter the cylinder, it will be seen that if the inlet valve were allowed to lag twenty degrees, the exhaust valve lag need not be more than five degrees, providing that the capacity of the combustion chamber was such that the gases occupied one-quarter of their former volume.

It is evident that no absolute rule can be given, as back pressure will vary with the design of the valve passages, the manifolds, and the construction of the muffler. The more direct the opening, the sooner the valve can be closed and the better the cylinder cleared. Ten degrees represent an appreciable angle of the crank and the time required for the crank to cover this angular motion is not inconsiderable and an important quantity of the exhaust may escape, but the piston is still very close to the dead center after the distance has been covered.

Before the inlet valve opens there should be a certain depression in the cylinder, and considerable lag may be allowed before the depression is appreciable. So far as the volume of fresh gas introduced during the admission stroke is concerned, this is determined by the displacement of the piston between the point where the inlet valve opens and the point of closing, assuming that sufficient gas has been inspired so that an equilibrium of pressure has been established between the interior of the cylinder and the outer air. The point of inlet opening varies with different motors. It would appear that a fair amount of lag would be fifteen degrees past top center for the inlet opening, as a certain depression will exist in the cylinder, assum-

ing that the exhaust valve has closed five or ten degrees after center, and at the same time the piston has not gone down far enough on its stroke to materially decrease the amount of gas which will be taken into the cylinder.

Closing the Inlet Valve.—As is the case with the other points of opening and closing, there is a wide diversity of practice as relates to closing the inlet valve. Some of the designers close this exactly at bottom center, but this practice cannot be commended, as there is a considerable portion of time, at least ten or fifteen degrees angular motion of the crank, before the piston will commence to travel any extent on its compression stroke. The gases rushing into the cylinder have considerable velocity, and unless an equilibrium is obtained between the pressure inside and that of the atmosphere outside, they will continue to rush into the cylinder even after the piston ceases to exert any suction effect.

For this reason, if the valve is closed exactly on center, a full charge may not be inspired into the cylinder, though if the time of closing is delayed, this momentum or inertia of the gas will be enough to insure that a maximum charge is taken into the cylinder. The writer considers that nothing will be gained if the valve is allowed to remain open longer than thirty degrees, and an analysis of practice in this respect would seem to confirm this opinion. From that point in the crank movement the piston travel increases and the compressive effect is appreciable, and it would appear that a considerable proportion of the charge might be exhausted into the manifold and carburetor if the valve were allowed to remain open beyond a point corresponding to thirty degrees angular movement of the crank.

Time of Ignition.—In this country engineers unite in providing a variable time of ignition, though abroad some difference of opinion is noted on this point. The practice of advancing the time of ignition, when affected electrically, was severely condemned by early makers, these maintaining that it was necessary because of insufficient heat and volume of the spark, and it was thought that advancing ignition was injurious. The engineers of to-day appreciate the fact that the heat of the electric spark, especially when from a mechanical generator of electrical energy, is the only means by which we can obtain practically instantaneous explosion, as required by the operation of motors at high speeds, and for the combustion of large volumes of gas.

It is apparent that a motor with a fixed point of ignition is not as desirable, in every way, as one in which the ignition can be advanced to best meet different requirements, and the writer does not readily perceive any advantage outside of simplicity of control in

establishing a fixed point of ignition. In fact, there seems to be some difference of opinion among those designers who favor fixed ignition, and in one case this is located forty-three degrees ahead of center, and in another motor the point is fixed at twenty degrees, so that it may be said that this will vary as much as one hundred per cent in various forms. This point will vary with different methods of ignition, as well as the location of the spark plug or igniter. The writer favors a variable point of ignition, as this offers advantages which cannot be obtained with fixed ignition, and enables one to best gauge the requirements of the time of firing the charge by conditions of operation from time to time. The range may be as desired, varying from a point after center for starting to one forty-five degrees advanced for maximum speed. Then again, flexibility of control is greatly increased when spark time may be varied to suit requirements.

It is obvious by consideration of the foregoing that there can be no arbitrary rules established for timing, because of the many conditions which determine the best times for opening and closing the valves. It is customary to try various settings when a new motor is designed until the most satisfactory points are determined, and the setting which will be very suitable for one motor is not always right for one of different design.

Typical Timing.—A series of valve-timing diagrams are presented at Fig. 215, these showing the timing employed on four different engines of about the same size. In that outlined at A the inlet valve begins to open eight degrees after center and closes exactly on the bottom center. The exhaust opens thirty degrees before bottom center and closes five degrees after top center. This motor employs large valves placed in the head and does not need much lead of the exhaust opening. In the diagram shown at B the inlet valve has a lag of fourteen degrees on the opening and closes six degrees after bottom center. The exhaust valve opens forty-one degrees before bottom center. The timing method outlined at C gives a greater lead to the exhaust than any of the others shown. The exhaust valve starting to open forty-seven degrees before center and closing twelve degrees after top center. The inlet valve begins to open nine degrees after top center and lags seventeen degrees after bottom center. It will be noticed that the exhaust valve is just closing while the inlet is opening, the closing of one member being coincident with the opening of the other. This is not very often followed, because there is danger of the admixture of gases should anything interfere with prompt valve action.

The diagram shown at D does not differ very much from that

shown at B, except in the lag of the inlet valve. This opens at thirteen degrees after top center and does not close until twenty-two degrees after bottom center. The exhaust valve opens thirty-nine degrees before bottom center and closes ten degrees after top center. It will be seen that at A there is a lapse of three degrees between exhaust

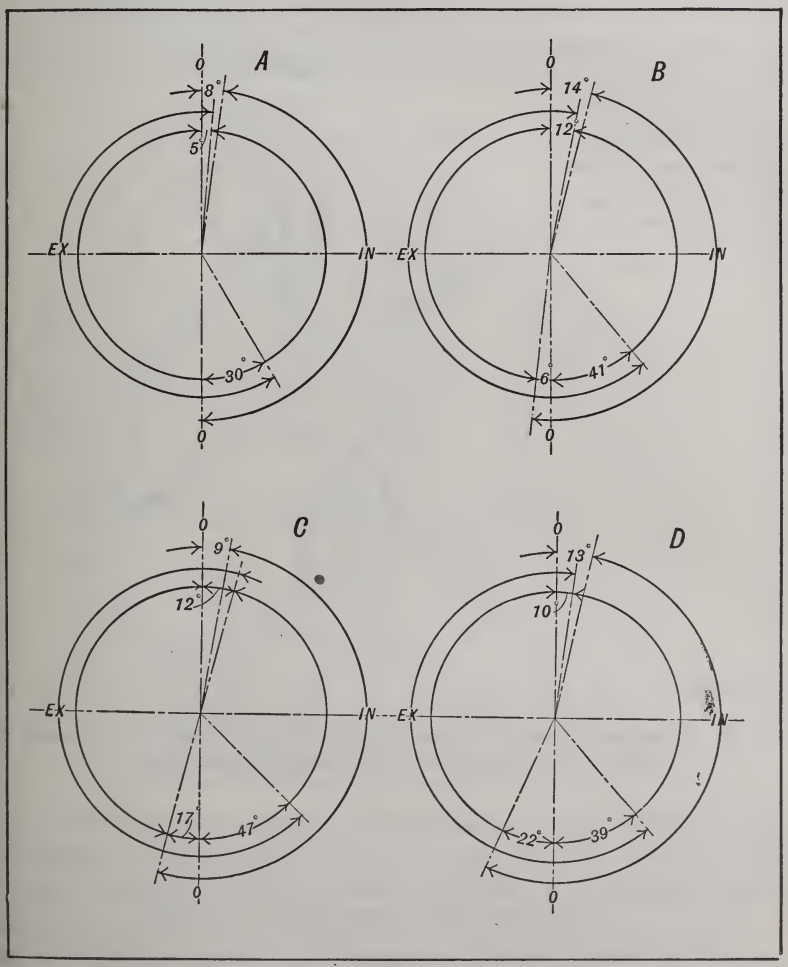


Fig. 215.—Diagram Showing Different Valve Timing Methods.

valve closing and inlet valve opening. At B the lapse is two degrees. At C the timing arrangement is such that there is no lapse between exhaust closing and inlet opening. Practically as soon as the exhaust valve is closed fully the inlet valve has opened materially. At D the lapse between exhaust valve closing and inlet opening is three degrees.

These methods of timing may be considered representative, though almost every designer follows his own preferences. Sometimes considerable experimenting is necessary before the point is reached where the motor runs with the maximum power and without noise.

The diagram at Fig. 216 shows clearly the method utilized in marking the fly wheel of a typical four-cylinder engine so that the valves

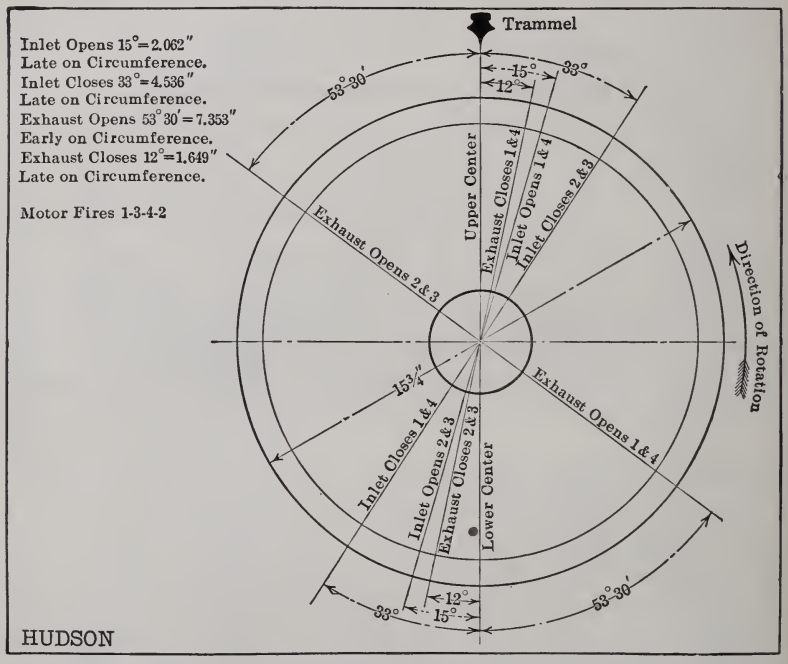


Fig. 216.—Diagram Showing Method of Marking Fly-wheel Circumference to Obtain Proper Timing of Typical Four-Cylinder Motor.

may be properly timed without following piston or crank-shaft movement directly. The fly wheel, which is 15¾ inches in diameter, has been marked off as indicated. As this is a four-cylinder engine, the marks on the fly wheel enable one to time all cylinders, as one of two will fire when one mark corresponding to upper center coincides with the fixed indicating device on the center line of the crank case. The others explode in turn when the mark indicating the lower center registers with the trammel point, as the little indicating device on the crank case is called. When the diameter of a fly-wheel is 15¾ inches, 2.062 inches measured from one of the center lines indicate the crank-pin travel of fifteen degrees. The lag of inlet closing which in this motor is thirty-three degrees is represented by a distance of 4.536

inches on the circumference of the fly wheel. The exhaust valve lead which is fifty-three degrees and thirty minutes is determined by measuring 7.353 inches ahead of the center lines. The point where the exhaust valve closes which is twelve degrees after center is represented by a distance of 1.649 inches on the fly wheel. It will be noted that in this case there is a lapse of three degrees between the exhaust closing and the inlet opening. The inlet valve is kept open considerably longer than is usually the case, as it lags thirty-three degrees after the

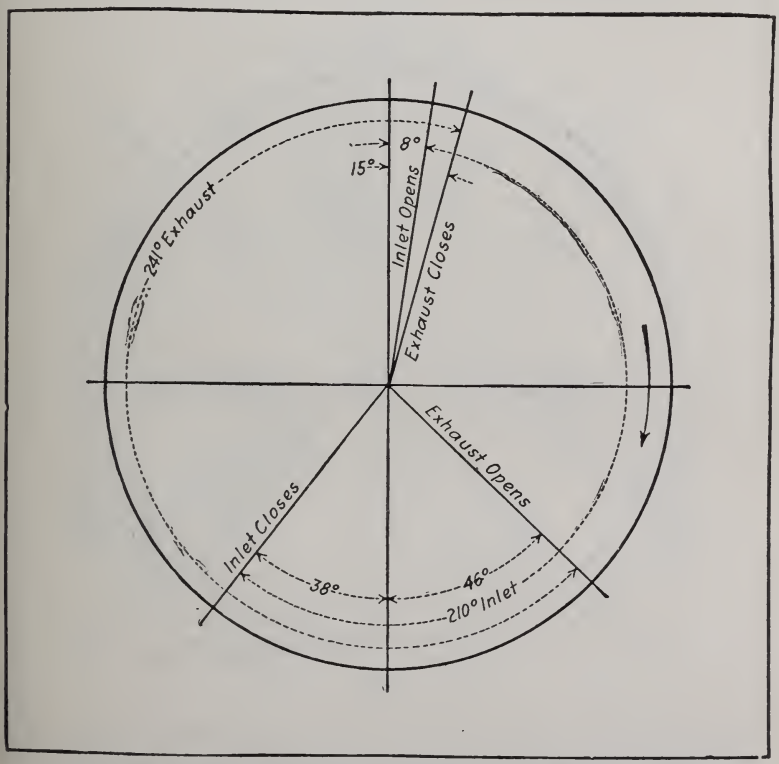


Fig. 217.—Timing Diagram of Overland Motor.

piston is started to go up on its compression stroke. The exhaust valve opens much earlier, i. e., it is given a greater lead than an analysis of common practice shows to be desirable. The exhaust valve is opened considerably longer than is usually the case, as the average lead given to exhaust is about forty degrees.

In timing a motor from the marks on the fly-wheel rim it is necessary to regulate the valves of but one cylinder at a time. Assuming

that the fly wheel is revolving in the direction of the arrow and that the firing order of the cylinders is 1-3-4-2, the operation of timing would be carried on as follows: The fly wheel would be revolved until the line marked "Exhaust opens 1 and 4" registered with the trammel on the motor bed. At this point the exhaust valve of either cylinder No. 1 or No. 4 should begin to open. This can be easily determined by noting which of these cylinders holds the compressed charge ready

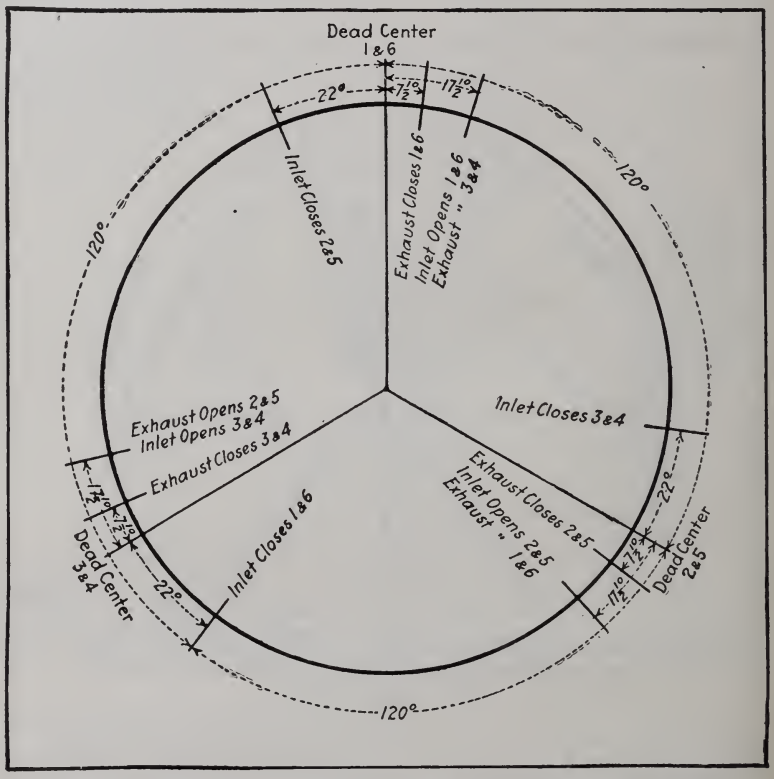


Fig. 218.—Valve Timing Diagram of 1917 Oakland Light Six Engine.

for ignition when the fly wheel is in the position shown in drawing. Assuming that the spark has occurred in cylinder No. 1, then when the fly wheel is turned from the position shown in the sketch to that in which the line marked "Exhaust opens 1 to 4" coincides with the trammel point, the valve plunger under the exhaust valve of cylinder No. 1 should be adjusted in such a way that there is no clearance between it and the valve stem. Further movement of the wheel in the same direction should produce a lift of the exhaust valve. The

fly wheel is turned about two hundred and forty-five degrees or about three-quarters of a revolution; then the line marked "Exhaust closes 1 and 4" will register with the trammel point. At this period the valve plunger and the valve stem should separate and a certain amount of clearance be obtained between them. The next cylinder to time would be No. 3. The fly wheel is rotated until mark "Exhaust opens 2 and 3" comes in line with the trammel. At this point the exhaust valve of cylinder No. 3 should be just about opening. The closing is deter-

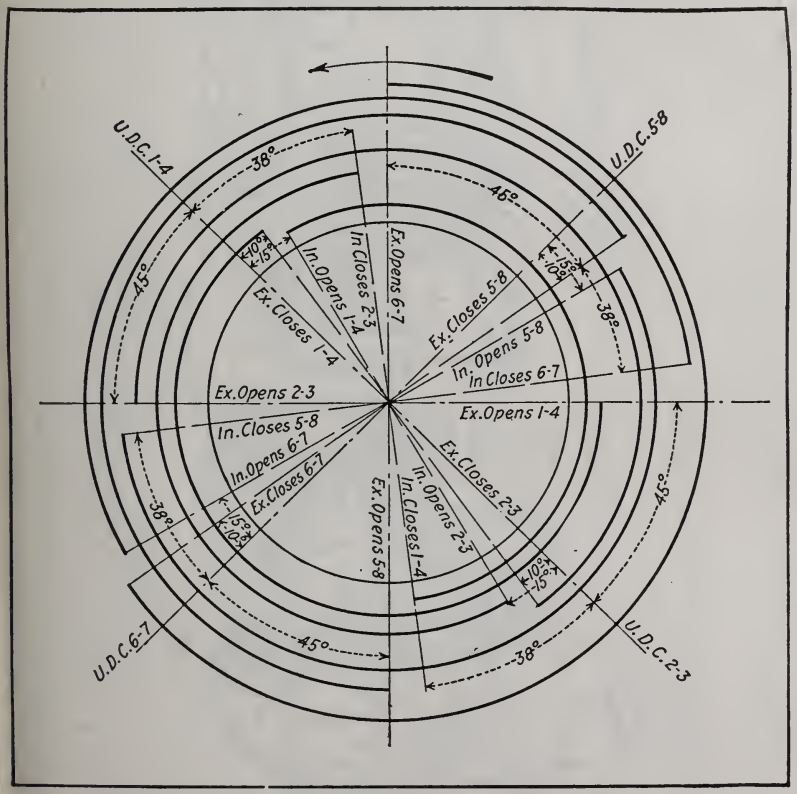


Fig. 219.—Valve Timing Diagram for Oakland-Northway Eight-Cylinder Engine.

mined by rotating the fly wheel until the line "Exhaust closes 2 and 3" comes under the trammel.

This operation is carried on with all the cylinders, it being well to remember that but one cylinder is working at a time and that a half revolution of the fly wheel corresponds to a full working stroke of all the cylinders, and that while one is exhausting, the others are respectively taking in a new charge, compressing and exploding. For in-

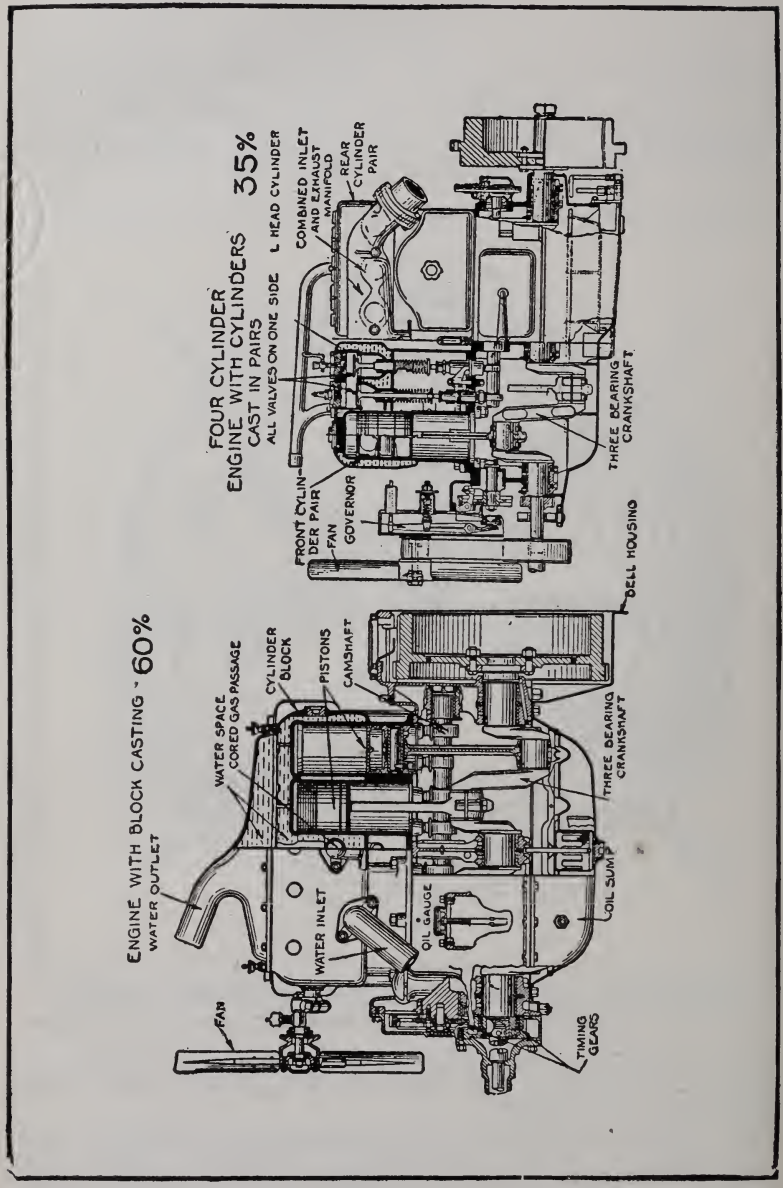


Fig. 220.—Graphic Representation of Most Popular Engine Type for Motor Truck Power Plants.

stance, if cylinder No. 1 has just completed its power stroke the piston in cylinder No. 3 has reached the point where the gas may be ignited to advantage. The piston of cylinder No. 4, which is next to fire, is at the bottom of its stroke and will have inspired a charge, while cylinder No. 2, which is the last to fire, will have just finished expelling a charge of burned gas, and will be starting the intake stroke.

VALVE TIMING OF SOME TYPICAL AMERICAN CARS
FROM S.A.E. DATA SHEET, No. 53, VOL. I

Car	Intake Opens Deg. Min.	Intake Closes Deg. Min.	Exhaust Opens Deg. Min.	Exhaust Closes Deg. Min.
Abbott, 34–40	11.30	49.12	45.48	11.30
Abbott, 44–50	17.53	29.25	42.36	8.20
Cadillac, 1914	4.20 to 14.20	38.26	31.34	7.00
Case, 40	13.00	30.00	50.00	13.00
Chalmers	12.00	33.00	55.00	12.00
Chandler Six	14.00	39.00	49.30	12.00
Chevrolet C	13.00	49.00	47.00	9.00
Chevrolet H–2, H–4	16.48	54.08	27.13	14.06
Franklin, M No. 4	8.00	33.00	51.30	17.00
Haynes, 26–27	5.00	35.00	47.00	2.00
Haynes, 28	5.00	35.00	37.00	2.00
Hupmobile, 32	21.00	28.00	46.00	16.00
Jackson, 1914	15.00	38.00	45.00	10.00
Jeffery, 6–96	18.00	46.00	47.00	15.00
Jeffery, 4–93	18.00	46.00	47.00	15.00
King B	9.44	30.38	32.10	5.00
Lewis Six	15.00	30.00	45.00	5.00
Lyons-Knight	10.00	40.00	60.00	on
Maxwell, 4–35	5.00	40.00	35.00	on
Maxwell, 4–25	6.00	32.00	43.00	6.00
Moon, Six 50	10.00	28.00	40.00	2.30
Moon, Four 42	14.00	24.00	31.00	21.00
Oldsmobile, 54	15.00	38.00	45.00	10.00
Paige Detroit, 36	9.40	32.30	41.50	11.40
Paige Detroit, 25	9.40	32.25	40.30	12.00
Pathfinder Little 6	10.00	28.00	40.00	2.30
Reo	18.00	36.00	53.30	14.00
Speedwell, A.B.C	10.00	28.00	40.00	2.30
Velie	7.00	36.00	43.00	12.00
Vucan	15.00	30.00	45.00	10.00

CHAPTER IV

PISTONS, CRANKSHAFT AND CRANKCASE PARTS

Constructional Details of Pistons—Piston Forms—Wrist Pin Retention Methods—Piston Ring Construction—Leak-Proof Rings—Aluminum Cylinders and Pistons—Connecting Rod Forms—Connecting Rods for "V" Engines—Cam Shaft Forms—Crankshaft Types Outlined—Built-up Crankshaft—Ball Bearing Crankshafts—Counterweighted Crankshafts—Lanchester-Packard Vibration Damper—Fly Wheel Construction and Retention—Positive Fly Wheel Retention Important—Fly Wheel Marks—Engine Base Construction—Barrel Type Crankcase—Steel Engine Cylinders.

Constructional Details of Pistons.—The piston is one of the most important parts of the gasoline motor inasmuch as it is the reciprocating member that receives the impact of the explosion and which transforms the power obtained by the combustion of gas to mechanical motion by means of the connecting rod to which it is attached. The piston is one of the simplest elements of the motor, and it is one component which does not vary much in form in different types of motors. The piston is a cylindrical member provided with a series of grooves in which packing rings are placed on the outside and two bosses which serve to hold the wrist pin in its interior. It is usually made of cast iron, though in some motors where extreme lightness is desired, such as those used for aëronautic work, it may be made of steel. Considerable interest now prevails in aluminum pistons, which were tried out in racing motors in 1915 and adopted successfully by many makers of pleasure cars during 1916. The aluminum alloy used generally contains some magnesium, which gives greater strength. The use of the more resisting material enables the engineer to use lighter sections where it is important that the weight of this member be kept as low as possible consistent with strength.

A number of piston types are shown at Fig. 221. That at A has a round top and is provided with four split packing rings and two oil grooves. A piston of this type is generally employed in motors where the combustion chamber is large and where it is desired to obtain a higher degree of compression than would be possible with a flat top piston. This construction is also stronger because of the

arched piston top. The most common form of piston is that shown at B, and it differs from that previously described only in that it has a flat top. The piston outlined in section at C is a type used on some of the sleeve-valve motors of the Knight pattern, and has a concave head instead of the convex form shown at A. The design shown at

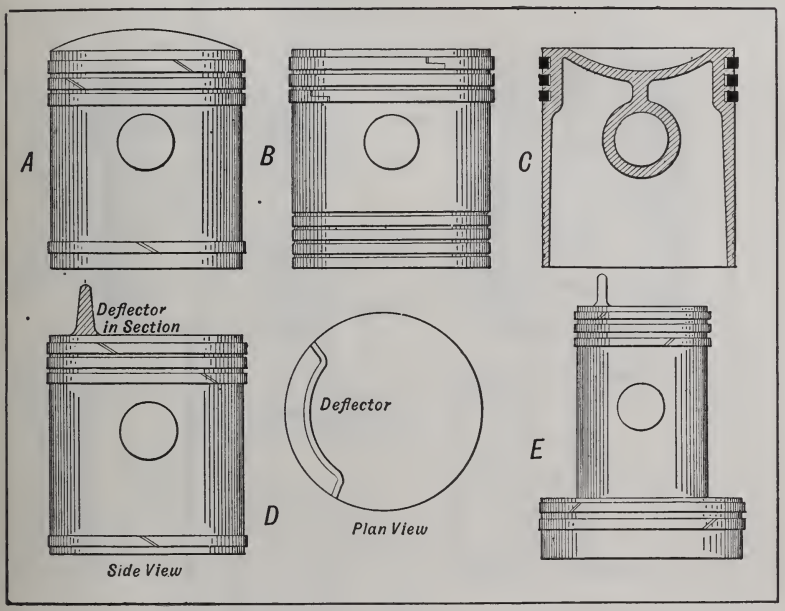


Fig. 221.—Forms of Pistons Commonly Employed in Gasoline Engines. A—Dome-Head Piston with Four Packing Rings. B—Flat Top Form Almost Universally Used with Three Packing Rings and Four Oil Grooves. C—Concave Piston Utilized in Knight Motor. D—Two-Cycle Engine Member with Deflector Plate Cast Integrally. E—Differential or Two-Diameter Piston Used in Some Two-Cycle Engines.

D in side and plan views is the conventional form employed in two-cycle engines. The deflector plate on the top of the cylinder is cast integral and is utilized to prevent the incoming fresh gases from flowing directly over the piston top and out of the exhaust port which is usually opposite the inlet opening. On those types of two-cycle engines where a two-diameter cylinder is employed, the piston shown at E is used. This is known as a "differential piston," and has an enlarged portion at its lower end which fits the pumping cylinder. The usual form of deflector plate is provided at the top of the piston and one may consider it as two pistons in one. A typical piston assembly is shown at Fig. 222, this showing the conventional cast iron type

with the marine pattern connecting rod now generally used in all motors.

One of the important conditions in piston design is the method of securing the wrist pin which is used to connect the piston to the upper

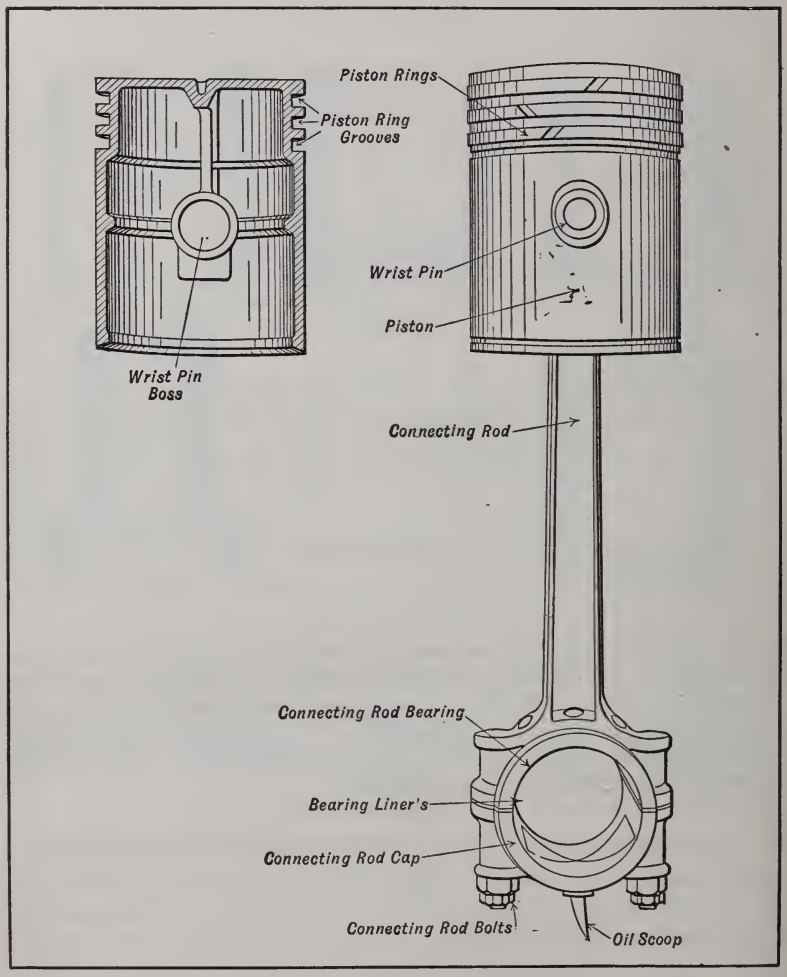


Fig. 222.—Typical Piston and Connecting Rod Assembly. Note Sectional View of Piston, Showing Internal Ribbing.

end of the connecting rod. Various methods have been devised to keep the pin in place, the most common of these being shown at Fig. 223. The wrist pin should be retained by some positive means which

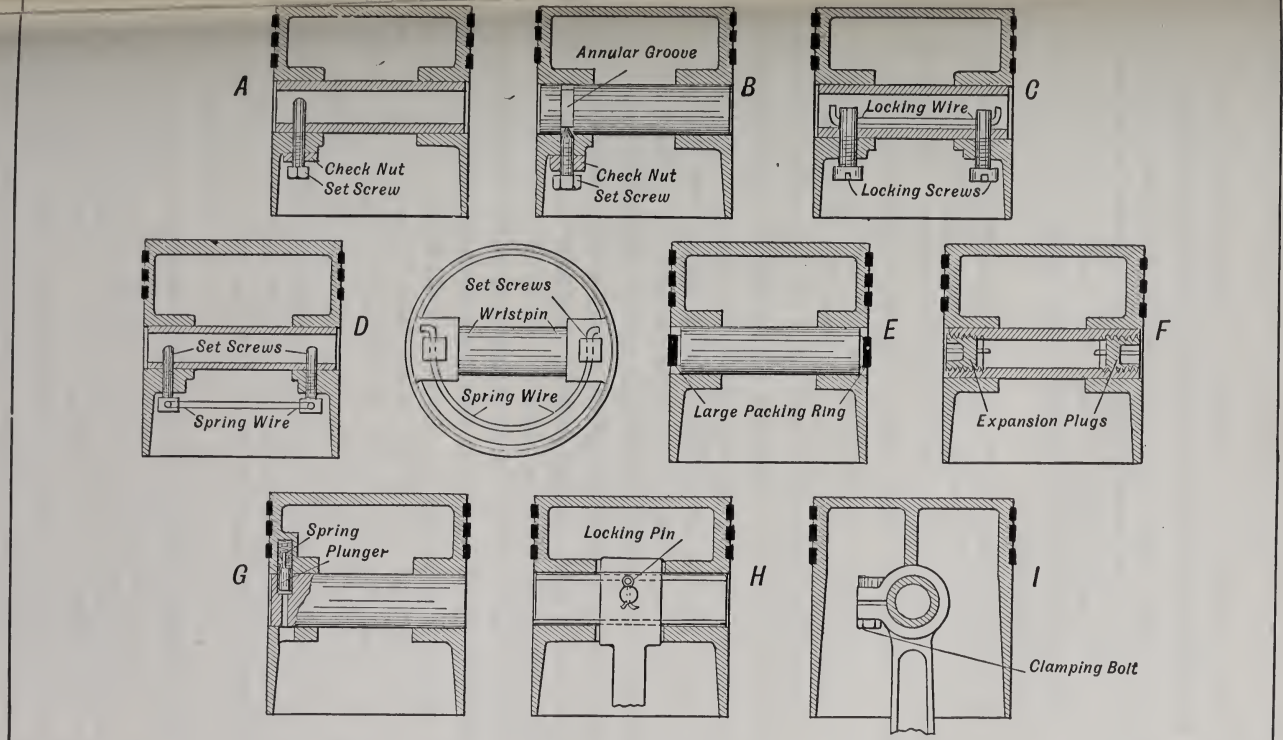


Fig. 223.—Typical Methods of Piston Pin Retention Generally Used in Engines of American Design. A—Single Set Screw and Locknut. B—Set Screw Fitting Groove in Wristpin and Checknut. C and D—Two Locking Screws Passing into Interior of Hollow Wristpin. E—Split Ring Holds Pin in Place. F—Use of Taper-Expanding Plugs Outlined. G—Spring Pressed Plunger Type. H—Piston Pin Pinned to Connecting Rod. I—Wristpin Clamped in Connecting Rod Small End by Bolt.

is not liable to become loose under the vibratory stresses which obtain at this point. If the wrist pin was free to move it would work out of the bosses enough so that the end would bear against the cylinder wall. As it is usually made of steel, which is a harder material than cast iron used in cylinder construction, the rubbing action would tend to cut a groove in the cylinder wall which would make for loss of power because it would permit escape of gas. The wrist pin member is a simple cylindrical element that fits the bosses closely, and it may be either hollow or solid stock.

The method of retention shown at A is the simplest and consists of a set screw having a projecting portion passing into the wrist pin and holding it in place. The screw is kept from turning or loosening by means of a check nut. The method outlined at B is similar to that shown at A, except that the wrist pin is solid and the point of the set screw engages an annular groove turned in the pin for its reception. A very positive method is shown at C. Here the retention screws pass into the wrist pin and are then locked by a piece of steel wire which passes through suitable holes in the ends. The method outlined at D is sometimes employed, and it varies from that shown at C only in that the locking wire, which is made of spring steel, is passed through the heads of the locking screws. Some designers machine a large groove around the piston at such a point that when the wrist pin is put in place a large packing ring may be sprung in the groove and hold the wrist pin in place.

The system shown at F is not so widely used as the simpler methods, because it is more costly and does not offer any greater security when the parts are new than the simple lock shown at A. In this a hollow wrist pin is used, having a tapered thread cut at each end. The wrist pin is slotted at three or four points, for a distance equal to the length of the boss, and when taper expansion plugs are screwed in place the ends of the wrist pin are expanded against the bosses. This method has the advantage of providing a certain degree of adjustment if the wrist pin should loosen up after it had been in use for some time. The taper plugs would be screwed in deeper and the ends of the wrist pin expanded proportionately to take up the loss motion. The method shown at G is an ingenious one. One of the piston bosses is provided with a projection which is drilled out to receive a plunger. The wrist pin is provided with a hole of sufficient size to receive the plunger, which is kept in place by means of a spring in back of it. This makes a very positive lock and one that can be easily loosened when it is desired to remove the wrist pin. To unlock, a piece of fine rod is thrust into the hole at the bottom of the boss and pushes the plunger

back against the spring until the wrist pin can be pushed out of the piston.

Some engineers think it advisable to oscillate the wrist pin in the piston bosses, instead of in the connecting rod small end. It is argued that this construction gives more bearing surface at the wrist pin and also provides for more strength because of the longer bosses that can be used. When this system is followed the piston pin is held in place by locking it to the connecting rod by some means. At H the simplest method is outlined. This consisted of driving a taper pin through both rod and wrist pin and then preventing it from backing out by putting a split cotter through the small end of the tapered locking pin. Another method, which is depicted at I, consists of clamping the wrist pin by means of a suitable bolt which brings the slit connecting rod end together as shown.

Piston Ring Construction.—As all pistons must be free to move up and down in the cylinder with minimum friction, they must be less in diameter than the bore of the cylinder. The amount of freedom or clearance provided varies with the construction of the engine, but it is usual to provide from .005 to .010 of an inch to compensate for the expansion of the piston due to heat and also to leave sufficient clearance for the introduction of lubricant between the working surfaces. Obviously, if the piston were not provided with packing rings, this amount of clearance would enable a portion of the gases evolved when the charge is exploded to escape by it into the engine crank case. The packing members or piston rings, as they are called, are split rings of cast iron, which are sprung into suitable grooves machined on the exterior of the piston, three or four of these being the usual number supplied. These have sufficient elasticity so that they bear tightly against the cylinder wall and thus make a gas-tight joint. Owing to the limited amount of surface in contact with the cylinder wall and the elasticity of the split rings the amount of friction resulting from the contact of properly fitted rings and the cylinder is not of enough moment to cause any damage and piston is free to slide up and down in the cylinder bore.

These rings are made in two forms, as outlined at Fig. 224. The design shown at A is termed a "concentric ring," because the inner circle is concentric with the outer one and the ring is of uniform thickness at all points. The ring shown at B is called an "eccentric ring," and it is thicker at one part than the other. It has theoretical advantages in that it will make a tighter joint than the other form, as it is claimed its expansion due to heat is more uniform. The piston rings must be split in order that they may be sprung in place in the

grooves, and also to insure that they will have sufficient elasticity to take the form of the cylinder at the different points in their travel. If the cylinder bore varies by small amounts the rings will spring out at

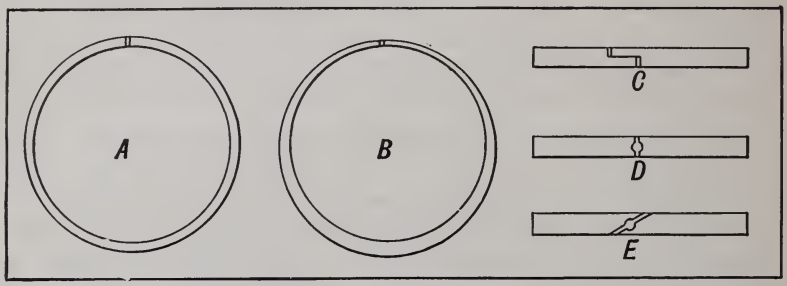


Fig. 224.—Common Types of Piston Rings and Ring Joints. A—Concentric Ring. B—Eccentrically Machined Form. C—Lapped Joint Ring. D—Butt Joint, Seldom Used. E—Diagonal Cut Member in Popular Form.

the points where the bore is larger than standard, and spring in at those portions where it is smaller than standard.

It is important that the joint should be as nearly gas-tight as possible, because if it were not a portion of the gases would escape through

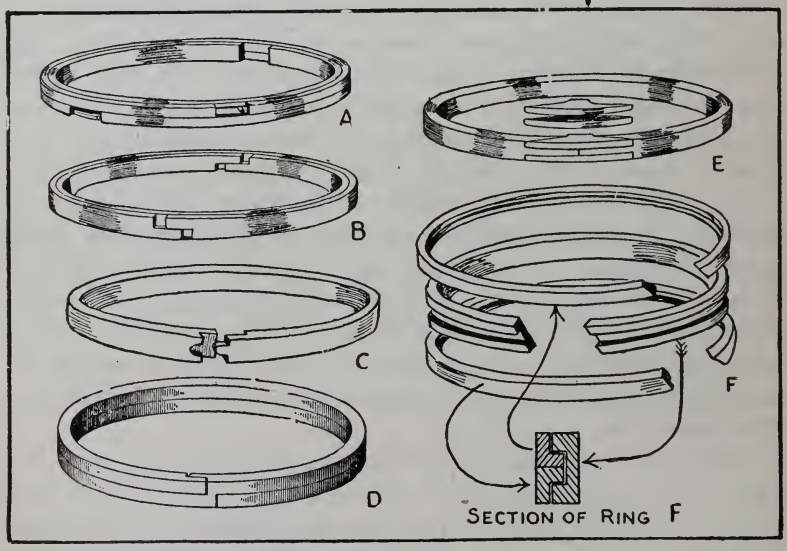


Fig. 225.—Leak-Proof and Other Compound Piston Rings.

the slots in the piston rings. The joint shown at C is termed a "lap joint," because the ends of the ring are cut in such a manner that they overlap. This is the approved joint. The butt joint shown at

D is seldom used and is a very poor form, the only advantage being its cheapness. The diagonal cut shown at E is a compromise between the very good form shown at C and the poor joint depicted at D. It is also widely used, though most constructors prefer the lap joint, because it does not permit the leakage of gas as much as the other two types. In order to avoid the leakage that is present with simple rings a number of compound rings of various types have been offered on the open market and some have been adopted by engine builders. Various designs of this nature are shown at Fig. 225. The construction of these rings is clearly shown in the illustrations. The simple ring still remains the most popular among engine builders.

Fig. 226.—Showing Flat Top Piston Provided with Four Concentric Rings, One of the Packing Members and the Wristpin with its Bushing.

The illustration at Fig. 226 shows a typical flat top piston, provided with diagonal cut concentric packing rings. One of these members is shown on top of the piston and the wrist pin and the bushing which fits it and which is forced into the small end of the connecting

rod are placed at one side. In some cases the piston rings are pinned in place in their grooves so that they cannot move around until they are all in such a position that the slots will come in line. In others, it is believed that they are left free to turn that they will wear in place and conform to the bore of the cylinder better than if they are kept from turning. When the rings are pinned they usually have the diagonal cut, while those that are left free are usually provided with the lap joint.

Aluminum for Cylinders and Pistons.—Aluminum pistons outlined at Fig. 227, C, D, E and F, have replaced cast iron members in many motors, as these weigh about one-third as much as the cast iron forms of the same size, while the reduction in the inertia forces has made it possible to increase the engine speed without correspondingly stressing the connecting rods, crankshaft and engine bearings.

Aluminum has not only been used for pistons, but a number of motors will be built for the coming season that will use aluminum cylinder block castings as well, as shown at Fig. 227, B. Of course, the aluminum alloy is too soft to be used as a bearing for the piston, and it will not withstand the hammering action of the valve. This makes the use of cast iron imperative in all motors. When used in connection with the aluminum cylinder block the cast iron pieces are placed in the mould so that they act as cylinder liners and valve seats, and the molten metal is poured around them when the cylinder is cast. It is said that this construction results in an intimate bond between the cast iron and the surrounding aluminum metal. Another method and a superior one is to bore out the aluminum cylinder and force in a steel sleeve as shown in the sectional view of the 1917 Marmon engine at Fig. 228. Aluminum has for a number of years been used in many motor car parts. Alloys have been developed that have greater strength than cast iron and that are not so brittle. Its use for manifolds, clutch cones and engine crank and gear cases has been general for a number of years.

At first thought it would seem as though aluminum would be entirely unsuited for the use in those portions of internal combustion engines exposed to the heat of the explosion, on account of the low melting point of that metal and its disadvantageous quality of suddenly "wilting" when a critical point in the temperature is reached. Those who hesitated to use aluminum on account of this defect lost sight of the great heat conductivity of that metal, which is considerably more than that of cast iron. It was found in early experiments with aluminum pistons that this quality of quick radiation meant that aluminum pistons remained considerably cooler than cast iron

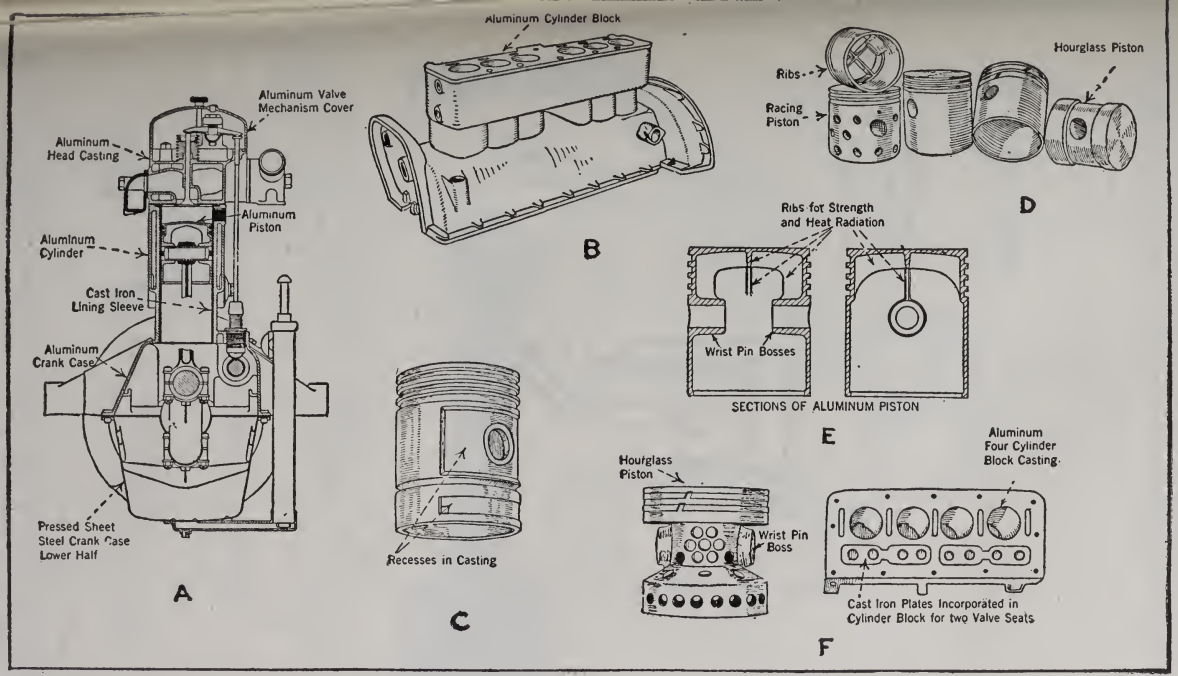


Fig. 227.—How Aluminum is Used for Auto Engine Parts. A—Sectional View of Overhead Valve Motor, Depicting Construction of Aluminum Cylinder Block and Cylinder Head Casting. B—Six-Cylinder Aluminum Block Casting. C, D and E—Various Forms of Aluminum Pistons. F—Top View of Four-Cylinder Aluminum Block Casting, Showing Use of Iron Plates for Valve Seats.

ones in service, which was attested to by the reduced formation of carbon deposits thereon. The use of aluminum makes possible a

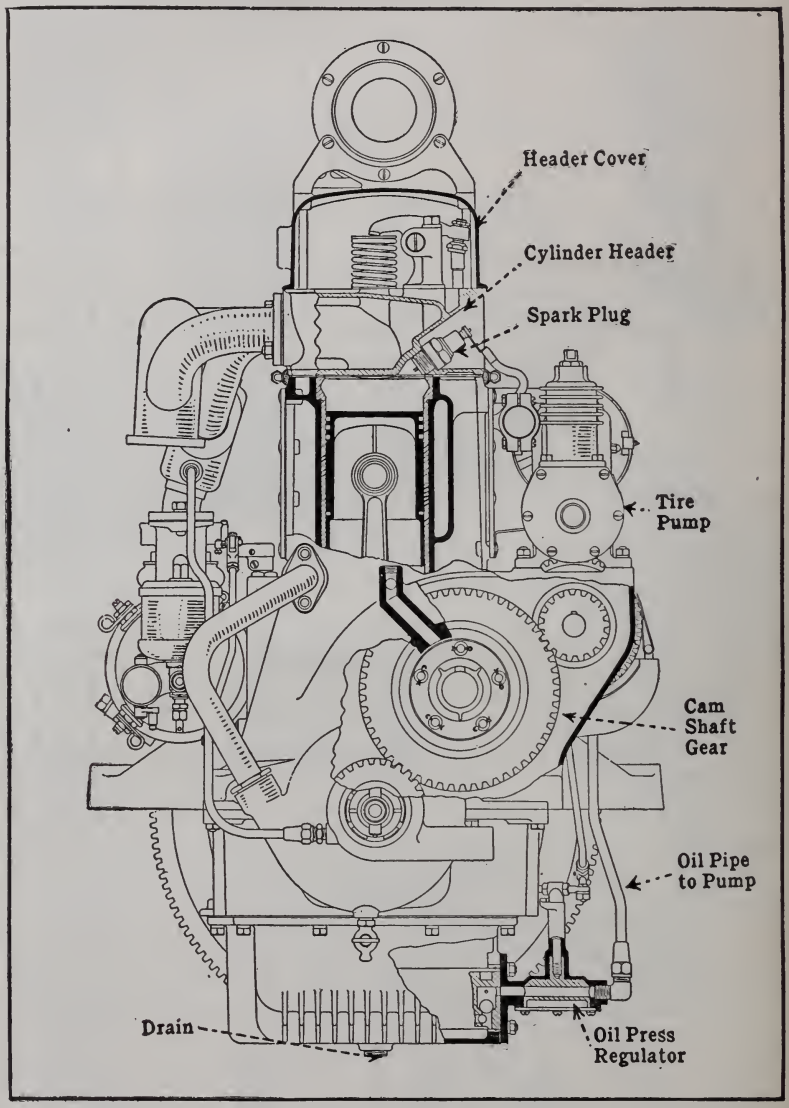


Fig. 228.—Sectional View of 1917 Marmon Engine, Showing Aluminum Cylinder Block with Iron Liner to Act as Piston Bearing.

marked reduction in power plant weight. A small four cylinder engine which was not particularly heavy even with cast iron cylinders

was found to weigh 100 pounds less when the cylinder block, pistons, and upper half of the crank case had been made of aluminum instead of cast iron. Aluminum motors are no longer an experiment, as a considerable number of these have been in use on cars during the past year without the owners of the cars being apprised of the fact. Absolutely no complaint was made in any case of the aluminum motor and it was demonstrated, in addition to the saving in weight, that the motors cost no more to assemble and cooled much more efficiently than the cast iron form. One of the drawbacks to the use of aluminum is the high cost of that metal.

Connecting Rod Forms.—The connecting rod is the simple member that joins the piston to the crank shaft and which transmits the power imparted to the piston by the explosion so that it may be usefully applied. It transforms the reciprocating movement of the piston to a rotary motion at the crank shaft. A typical connecting rod and its wrist pin are shown at Fig. 229. It will be seen that it has two

Fig. 229.—Tubular Connecting Rod and its Wristpin. Lower Bearing Cap Held by Four Bolts. White Metal Boxes in Cast Bronze Rod Big End.

bearings, one at either end. The small end is bored out to receive the wrist pin which joins it to the piston, while the large end has a hole of sufficient size to go on the crank pin. The connecting rod is usually a steel forging, though it is sometimes made a steel or high tensile strength bronze casting, and in cases where extreme lightness is desired it may be cast of "Magnalium," aluminum alloy. In all cases it is desirable to have softer metals than the crank shaft and wrist pin at the bearing point, and for this reason the connecting rod is usually provided with bushings of anti-friction or white metal at the lower end, and bronze at the upper. The upper end of the connecting rod may be one piece, because the wrist pin can be introduced after it is in place between the bosses of the piston. The lower

bearing must be made in two parts in most cases, because the crank shaft cannot be passed through the bearing owing to its irregular form.

Some of the various designs of connecting rods that have been used are shown at Fig. 230. That at A is the simple form often employed in single-cylinder motors, having built-up crank shafts. Both ends of the connecting rod are bushed with a one-piece bearing, as it can be assembled in place before the crank-shaft assembly is built up. A built-up crank shaft such as this type of connecting rod would be used which is shown at Fig. 242. The pattern shown at B is one that has been used to some extent on heavy work, and is known as the "marine type." It is made in three pieces, the main portion being a steel forging having a flanged lower end to which the bronze boxes are secured by bolts. The modified marine type depicted at C is the form that has received the widest application in automobile construction. It consists of two pieces, the main member being a steel drop forging having the wrist-pin bearing and the upper crank-pin bearing formed integral, while the lower crank-pin bearing member is a separate forging secured to the connecting rod by bolts. In this construction bushings of anti-friction metal are used at the lower end, and a bronze bushing is forced into the upper or wrist-pin end. The rod shown at D has also been widely used. It is similar in construction to the form shown at C, except that the upper end is split in order to permit of a degree of adjustment of the wrist-pin bushing, and the lower bearing cap is a hinged member which is retained by one bolt instead of two. When it is desired to assemble it on the crank shaft the lower cap is swung to one side and brought back into place when the connecting rod has been properly located. Sometimes the lower bearing member is split diagonally instead of horizontally, such a construction being outlined at E.

In a number of instances, instead of plain bushed bearings anti-friction forms using ball or rollers have been used at the lower end. A ball-bearing connecting rod is shown at F. The big end may be made in one piece, because if it is possible to get the ball bearing on the crank pins it will be easy to put the connecting rod in place. Ball bearings are not used very often on connecting rod big ends because of difficulty of installation, though when applied properly they give satisfactory service and reduce friction to a minimum. One of the advantages of the ball bearing is that it requires no adjustment, whereas the plain bushings depicted in the other connecting rods must be taken up from time to time to compensate for wear.

This can be done in forms shown at B, C, D, and E by bringing

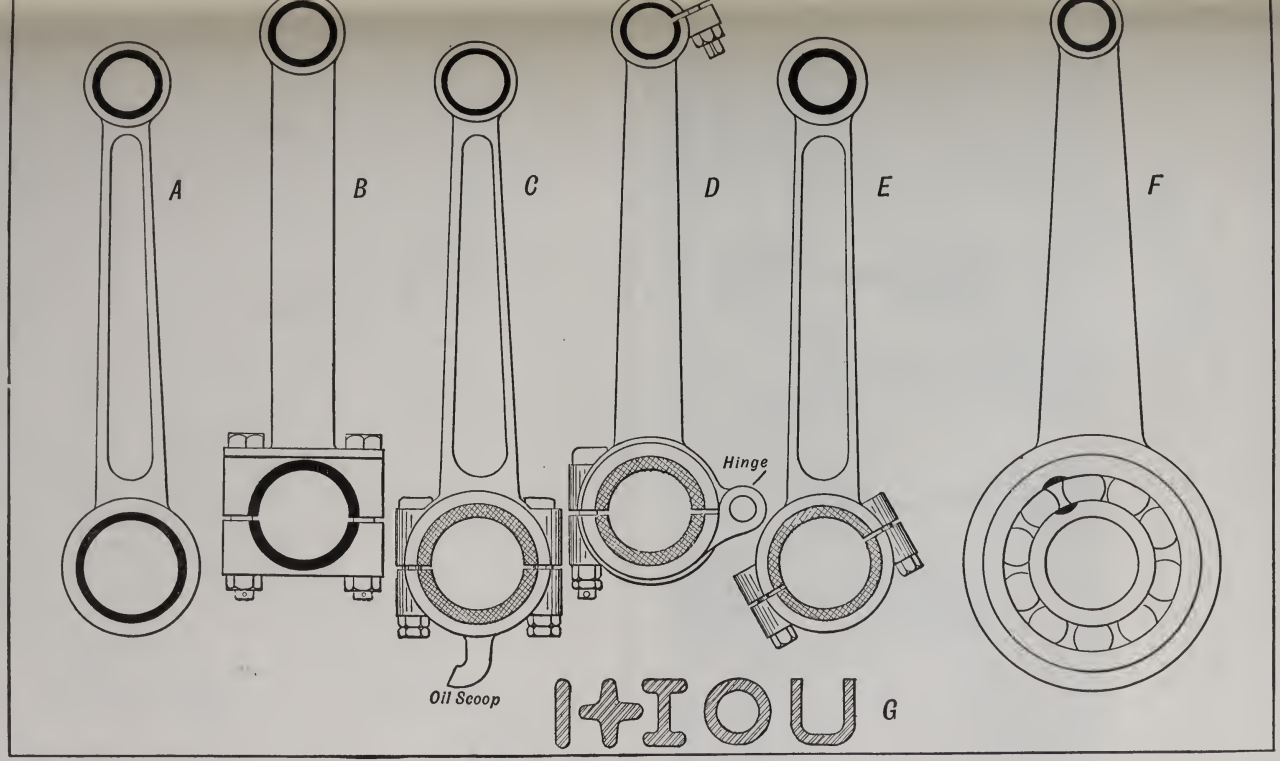


Fig. 230.—Connecting Rod Types Summarized. A—Simple Connecting Rod Made in One Piece, Usually Fitted in Small Single Cylinder Engines Having Built-Up Crankshaft. B—Marine Type, a Popular Form on Heavy Engines. C—Conventional Automobile Engine Rods, a Modified Marine Form. D—Type Having Hinged Lower Cap and Split Wristpin Bushings. E—Connecting Rod Having Diagonally Divided Big End. F—Ball-Bearing Connecting Rod. G—Section Showing Structural Shapes Commonly Employed in Connecting Rod Construction.

the lower bearing caps closer to the upper one and scraping out the brasses to fit the shaft. A number of liners or shims of thin brass or copper stock varying from .002 inch to .005 inch are sometimes interposed between the halves of the bearings when it is first fitted to the crank pin. As the brasses wear the shims may be removed and the

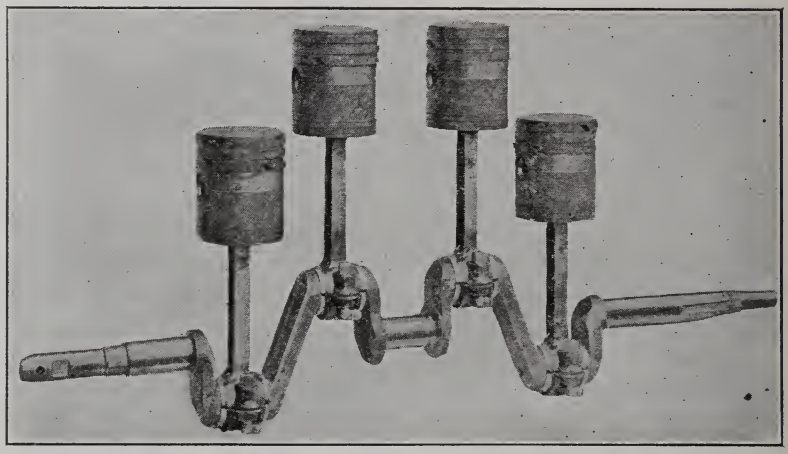


Fig. 231.—Crankshaft, Piston and Connecting Rod Assembly for Four-Cylinder Engines.

portions of the bearings brought close enough together to take up any lost motion that may exist.

The various structural shapes in which connecting rods are formed are shown in section at G. Of these the I section is most common, because it is strong and a very easy shape to form by the drop-forging process. Where extreme lightness is desired, as in small high-speed motors used for cycle propulsion, the section shown at the extreme left is often used. If the rod is a cast member the cross, hollow cylinder, or U sections are sometimes used. If the sections shown at the right are employed, advantage is often taken of the opportunity for passing lubricant through the center of the hollow round section on vertical motors or at the bottom of the U section, which would be used on a horizontal cylinder power plant.

Connecting Rods for V Engines.—The development of the eight- and twelve-cylinder engines having angularly placed cylinders called for some study on the part of designers to determine how they would attach two connecting rods to the same crankpin. If the cylinders are placed directly opposite each other, two methods of construction are possible. That shown at Fig. 232 calls for the use of a forked

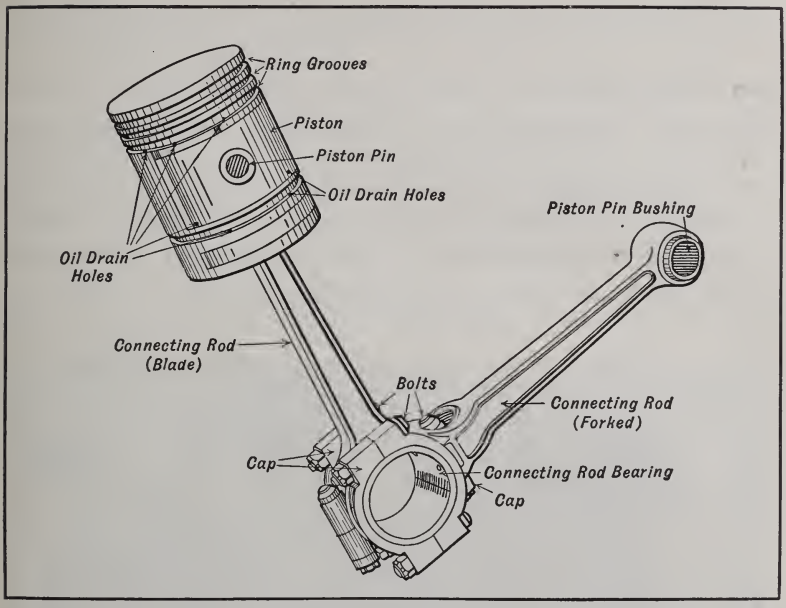


Fig. 232.—Hinged Type Connecting Rod Used on Some Eight- and Twelve-Cylinder V Engines.

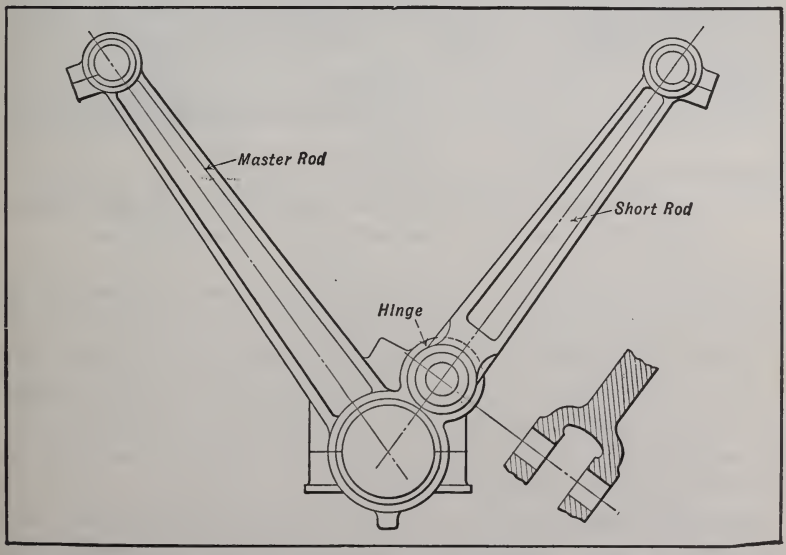


Fig. 233.—Unconventional Connecting Rod Construction Used on Some V Engines.

rod which encircles a bushing that acts as a crankpin bearing and which is attached to the big end of a rod of the conventional pattern, only having a narrower big end. The conventional rod is known as the "blade," the other as the "fork." Another method is shown at Fig. 233. In this a master rod has a boss forged integrally to which a forked short rod is hinged as indicated. The hinge joint is subjected to a purely oscillating movement, though the big end of the master rod encircles the crankpin in the usual manner. By far the most desirable construction is shown at Fig. 234, which shows

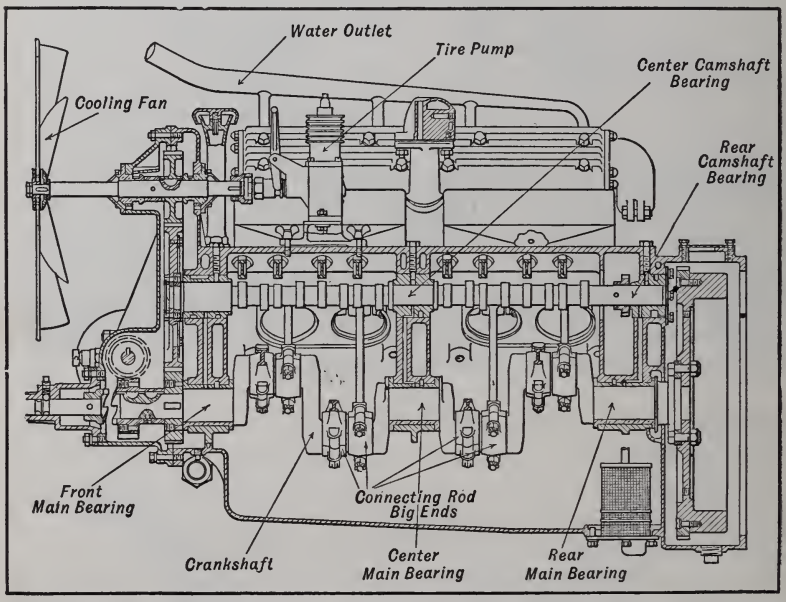


Fig. 234.—Part Sectional View of Peerless Eight-Cylinder Engine Showing Side-by-Side Connecting Rods for Opposite Cylinder Groups.

how the rods can be placed side by side on the same crankpin if the cylinders are placed in staggered relation, i. e., one advanced somewhat ahead of the other. With this construction all connecting rods are the same. The two systems previously described in which forked rods are used have been thoroughly tried out in motorcycle engines. The method shown at Fig. 234 appears to the writer to be the most logical and the easiest to keep in repair.

Cam-shaft Forms.—Piston and connecting rod types having been described, the next component of importance to receive attention should be the crank shaft. These vary in form according to the designs of the motor and number of cylinders employed. A typical

crank shaft, piston, and connecting rod assembly which forms part of the Reo motor is shown at Fig. 231, and the parts are so clearly shown that no description is necessary.

Before going extensively into the subject of crank-shaft construction it will be well to consider cam-shaft design, which is properly a part of the valve system and which should be considered in connection with the other elements which have to do directly with cylinder construction. Cam shafts are usually simple members carried at the base of the cylinder in the engine case by suitable bearings and having the cams employed to lift the valves attached at intervals. A typical cam-shaft design is shown at Fig. 235 in connection with one of the twin-

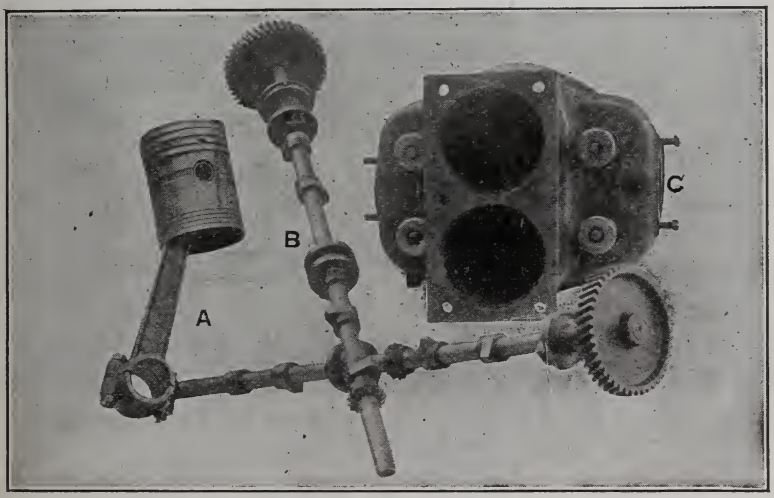


Fig. 235.—Some of the Components of a T-Head Truck Motor. A—Piston and Connecting Rod Assembly. B—Inlet and Exhaust Cam Shaft. C—Twin Cylinder Casting.

cylinder castings and the piston and connecting rod assembly of a typical truck engine. Two main methods of cam shaft construction are followed—that in which the cams are separate members, keyed and pinned to the shaft, and the other where the cams are formed integral.

The cam shafts shown at Fig. 235 are of the former type, as the cams are machined separately and held in place by means of keys and taper pins. The small gears used to drive some of the accessory mechanism, such as the oil pump, timer, etc., are also separately formed and pinned to the cam shaft. At Figs. 237, 238 and 239 the other method of cam-shaft construction is outlined. In this case not only the cams but also the gears used in driving the auxiliary shafts are

forged integral. This is a more expensive construction than that shown at Fig. 235, when engines are made in small lots, because of the high initial cost of forging dies as well as the greater expense of machining. When manufactured in large quantities the in-

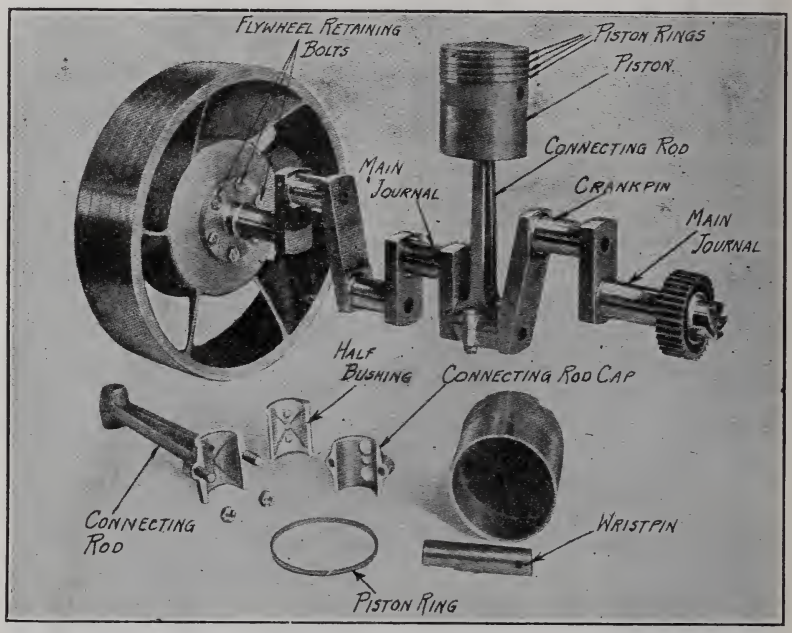


Fig. 236.—Typical Piston, Connecting Rod and Crank-shaft Assembly of a Heavy Duty Fire Truck Motor.

tegral construction is much the cheapest. It has the advantage over the other form in which the cams are keyed in place in that it is stronger, and as the cams are a part of the shaft they

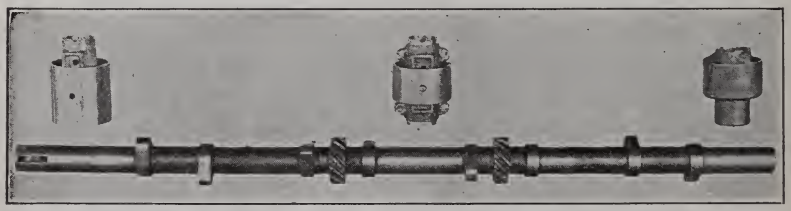


Fig. 237.—Typical Cam Shaft with Valve Lifting Cams and Gears to Operate Auxiliary Devices Forged Integrally. Note Plain Bearings for Cam Shaft Shown Above it.

can never become loose, as might be possible where they are separately formed and assembled on a simple shaft. As an example of an auxiliary shaft carried at the side of the motor and driven from the cam shaft

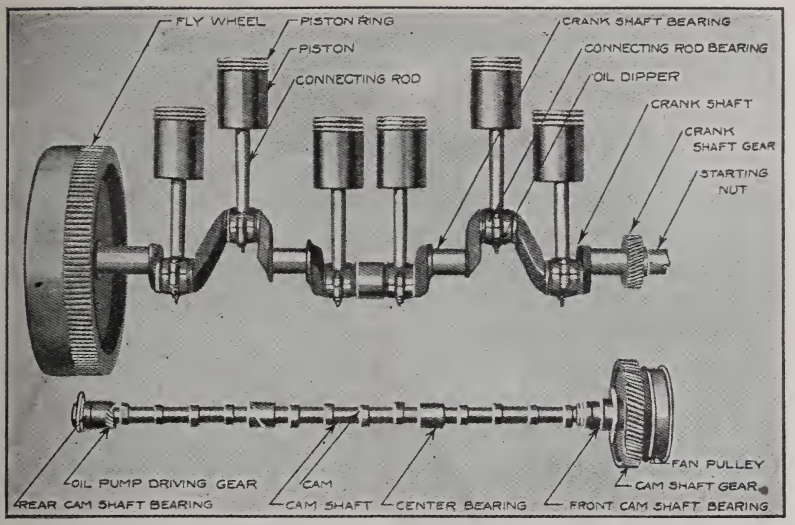


Fig. 238.—Buick Light Six Crank-shaft and Cam-shaft Assembly.

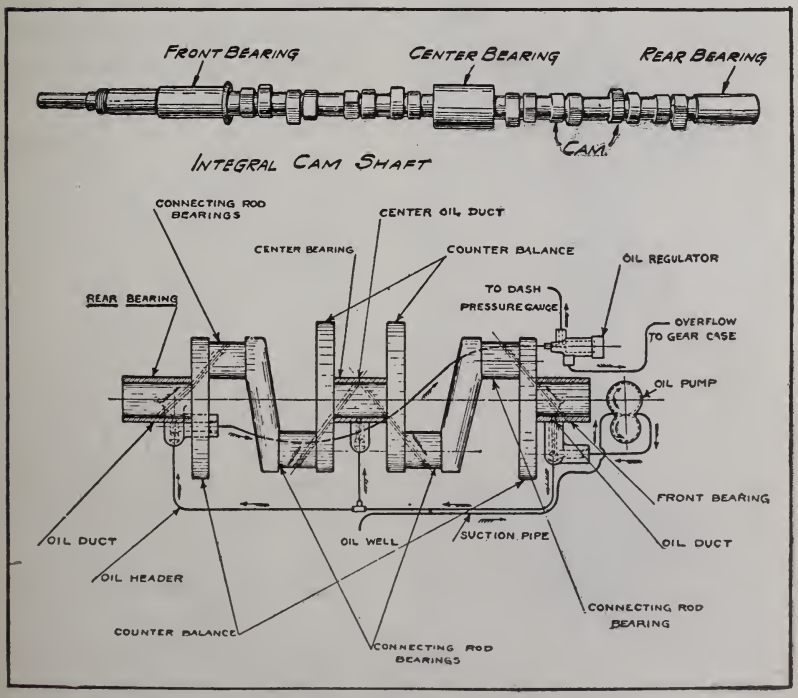


Fig. 239.—Crank Shaft and Cam Shaft of Cole-Northway Motor.

the assembly at Fig. 240 is given. This is driven from one of the small gears shown at Fig. 237 and carries the ignition timer at the upper end and drives the oil pump through a spring coupling at its lower end.

Crank-shaft Types Outlined.—The importance of the crank shaft has been previously considered, and some of its forms have been shown in views of the motors presented in earlier portions of this work. The crank shaft is one of the parts subjected to the greatest strain and extreme care is needed in its construction and design, because practically the entire duty of transmitting the power generated by the motor to the gearset devolves upon it. Crank shafts are usually made of high tensile strength steel of special composition. They may be made in four ways, the most common being from a drop or machine forging which is formed approximately to the shape of the finished shaft and in rare instances they may be steel castings. Sometimes they are made from machine forgings, where considerably more machine work is necessary than would be the case where the shaft is formed between dies. Some engineers favor blocking the shaft out of a solid slab of metal and then machining this rough blank to form. In some single-cylinder motors of the enclosed fly-wheel type the crank shaft and fly wheel are built up as a unit.

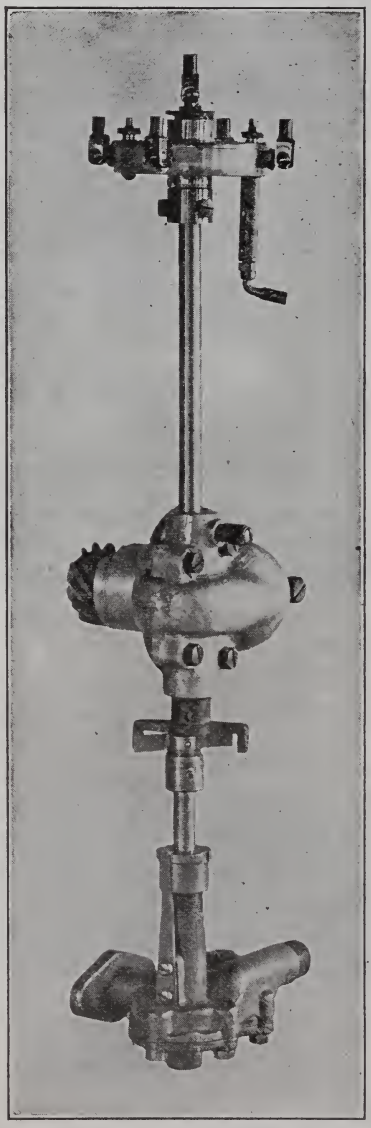


Fig. 240.—Auxiliary Shaft Used in Connection with Cam Shaft Driven from a Spiral Gear Turns Timer and Oil Pump.

The form of the shaft depends on the number of cylin-

ders and the form has material influence on the method of construction. For instance, a one-, two- or four-cylinder crank shaft could be made by either of the methods outlined. On the other hand, a three- or six-cylinder shaft is best made by the machine forging process, because if drop forged or cut from the blank it will have to be heated and the crank throws bent around so that the pins will lie in three planes one hundred and twenty degrees apart, while the other types described need no further attention, as the crank pins lie in planes one hundred and eighty degrees apart. This can be better understood by referring to Fig. 241, which shows a six-cylinder shaft in the rough and finished

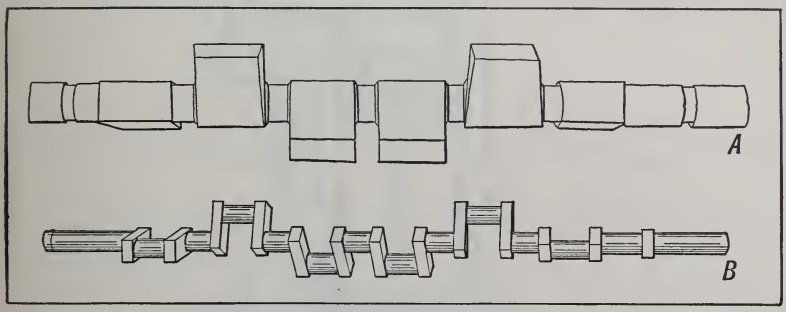


Fig. 241.—Showing One Method of Making a Crank Shaft. A—The Rough Steel Forging Before it is Machined. B—The Finished Six-Throw, Seven-Bearing Crank Shaft.

stages. At A the appearance of the machine forging before any of the material is removed is shown, while at B the appearance of the finished crank shaft is clearly depicted. The built-up crank shaft is seldom used on multiple-cylinder motors, except in some racing engines where the crank shafts revolve on ball bearings and the connecting rods are provided with this form as well and in small motorcycle power plants of the twin V engine type.

A typical single-cylinder high-speed motor is shown at Fig. 242, this being the De Dion-Bouton, a power plant which has been quite popular in France in the past for "voiturette" or small car use. In this design the fly wheels are enclosed in the crank case and the crank shaft is a built-up construction formed of five pieces. The two halves of the crank shaft fit into taper holes in the fly wheels and are held securely in place by means of keys and clamping nuts. The crank pin is similarly retained. Brief study of the illustration will show this method of construction very clearly. It should be stated that this is seldom used on automobile motors but that it is very common construction in motorcycle power plants.

Crank-shaft form will vary with a number of cylinders and it is possible to use a number of different arrangements of crank pins and

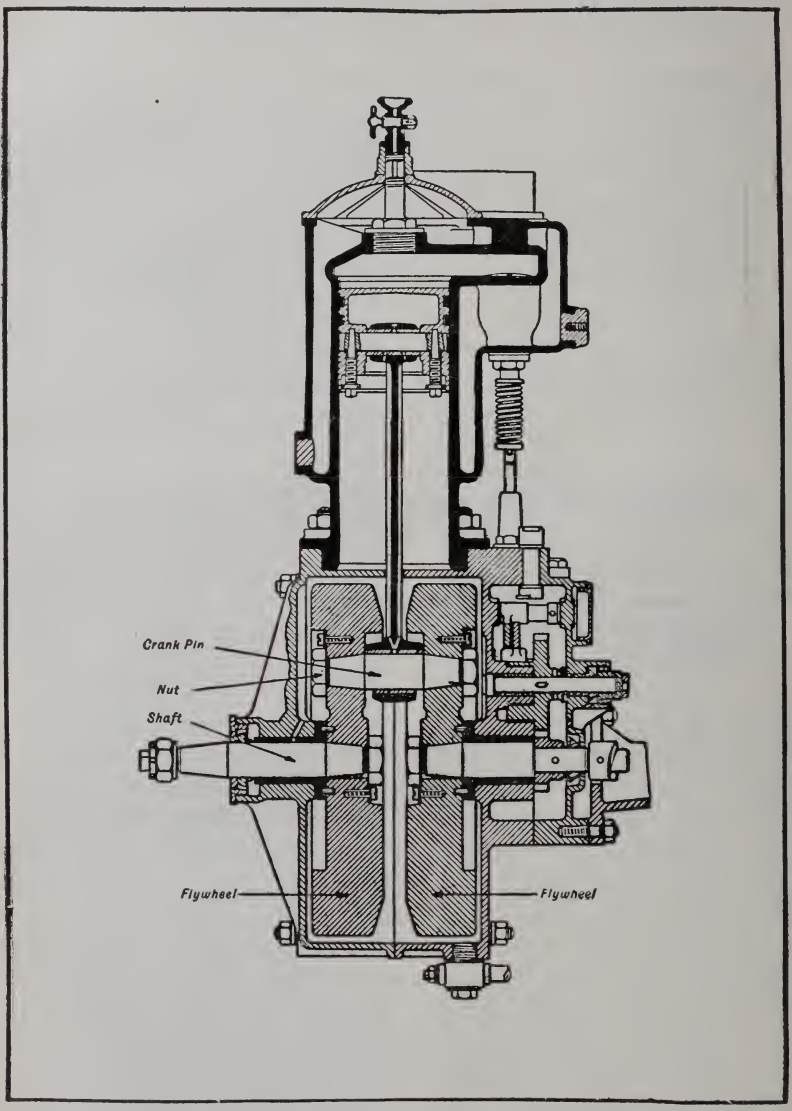


Fig. 242.—Sectional View of High-Speed Single-Cylinder Motor of Foreign Design, Showing Built-Up Crankshaft Construction Sometimes Used in Small Motors, Especially Motorcycle Types.

bearings for the same number of cylinders. The simplest form of crank shaft is that used on a one-cylinder motor, as it would consist

of but one crank pin, two webs, and the crank shaft. As the number of cylinders increase, as a general rule more crank pins are used. The crank shaft that would be used on a two-cylinder opposed motor is shown at Fig. 243. This has two throws and the crank pins are

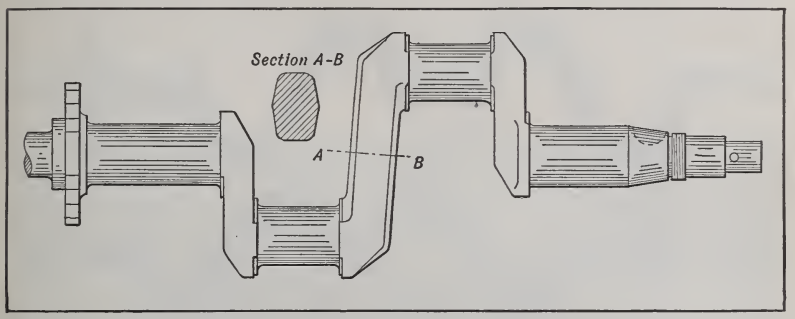


Fig. 243.—Showing Form of Crankshaft for Twin Cylinder Opposed Power Plant.

spaced 180 degrees apart. The bearings are exceptionally long and a flange is forged integral at the rear end for fly-wheel retention. Four-cylinder crank shafts may have two, three or five main bearings and three or four crank pins. In some forms of two-bearing crank shafts,

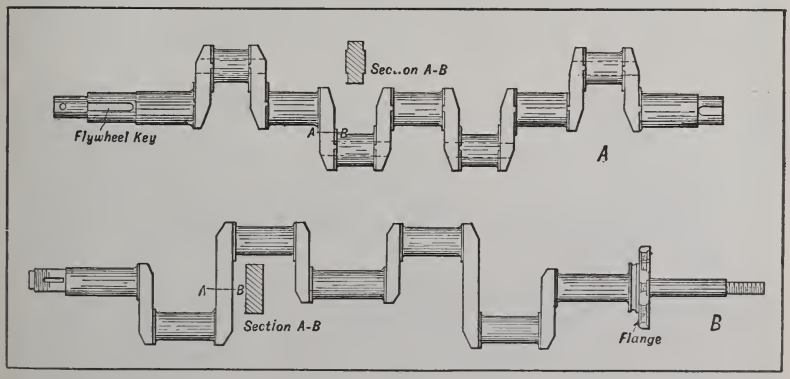


Fig. 244.—Two Forms of Four-Cylinder Crankshaft. A—Five-Bearing Type with Flywheel Fastening Key at Front End. B—Three-Bearing Type with Flange for Securing Flywheel Formed Integrally.

such as used when four cylinders are cast in a block, or unit casting, two of the pistons are attached to one common crank pin, so that in reality the crank shaft has but three crank pins. Such a form is shown at Fig. 249, which depicts a four-cylinder two-bearing crank shaft used on Chalmers' motors.

When the cylinders are cast individually five-bearing crank shafts are the rule. One of these, which is used on Maxwell engines, is shown at Fig. 244, A. The three-bearing type shown at Fig. 108, B, is used when the cylinders are cast in pairs. Two other three-bearing shafts

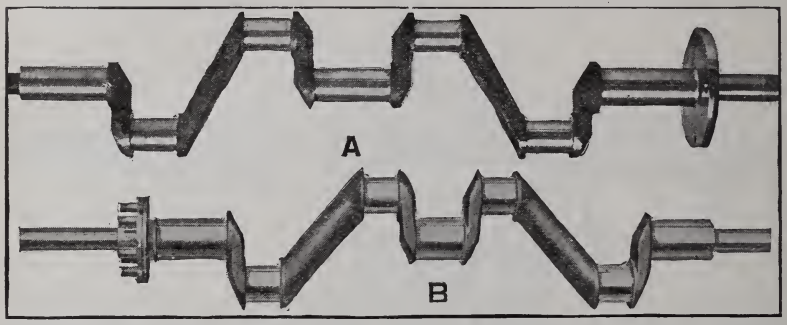


Fig. 245.—Three-Bearing, Four-Throw Crankshafts. A—For Use when Cylinders are Cast in Pairs. B—Early Design Used with Individually Cast Cylinders. Note Round Section Portions Connecting Ends to Center Crank Throw.

used in four-cylinder motors are shown at Fig. 109. That at A forms part of an engine, which has the cylinders cast in pairs, while the three-bearing four-throw type, shown at B, is used in a four-cylinder engine, which has individually cast cylinders. Six-cylinder crank-

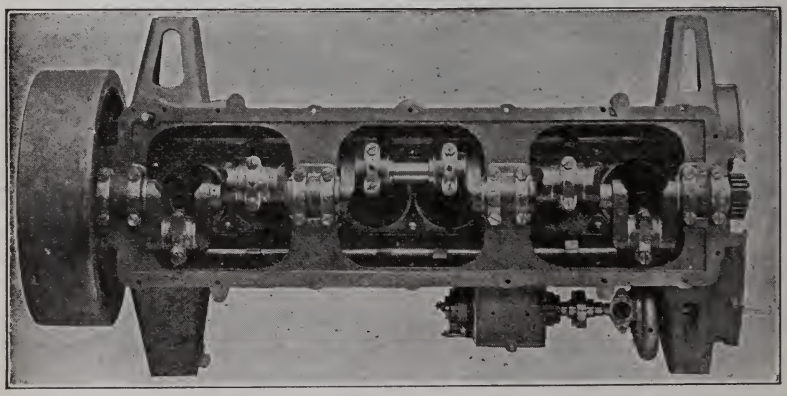


Fig. 246.—Bottom View of Six-Cylinder Engine, Showing Four-Bearing Crankshaft with Connecting Rods in Place.

shafts usually have four or seven main bearings depending upon the disposition of the crank pins and arrangement of cylinders. At Fig. 246 the bottom view of a Premier six-cylinder engine with bottom

half of crank case removed is given. This illustrates clearly the arrangement of crank pins and main bearings when the crankshaft is supported on four journals. The crank shaft shown at Fig. 247, B, is also a six-cylinder four-bearing type. That shown above it is a three-bearing form. The cylinders in this case are cast "en bloc" in the four-bearing type; they are usually cast in pairs. The arrangement shown at Fig. 247, A, could also be used on a six-cylinder engine

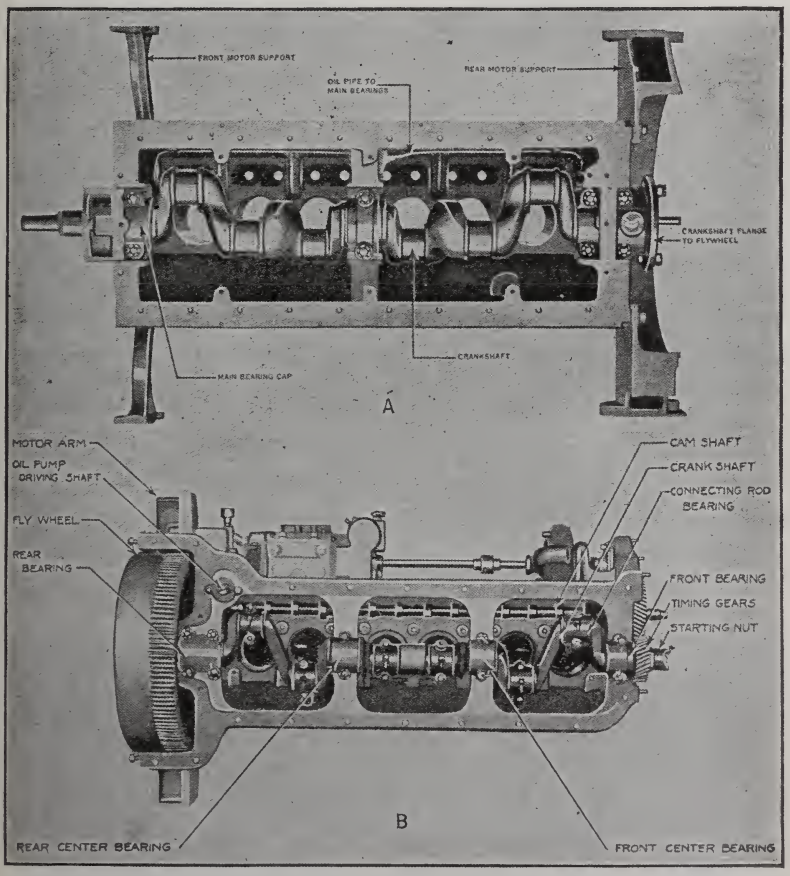


Fig. 247.—View of Chalmers Three-Bearing, Six-Cylinder Crank Shaft at A. The Buick Light Six Four Main Bearing Crank Shaft at B.

having cylinders cast in blocks of three. The crank shaft for an eight-cylinder engine is practically the same as a four; that of a "twin six" is similar to a six-cylinder design.

Ball-Bearing Crank Shafts.—While crank shafts are usually supported in plain journals a number of racing engines use anti-friction bearings of the ball type for their support. This is especially noticeable on block motors where but two main bearings are

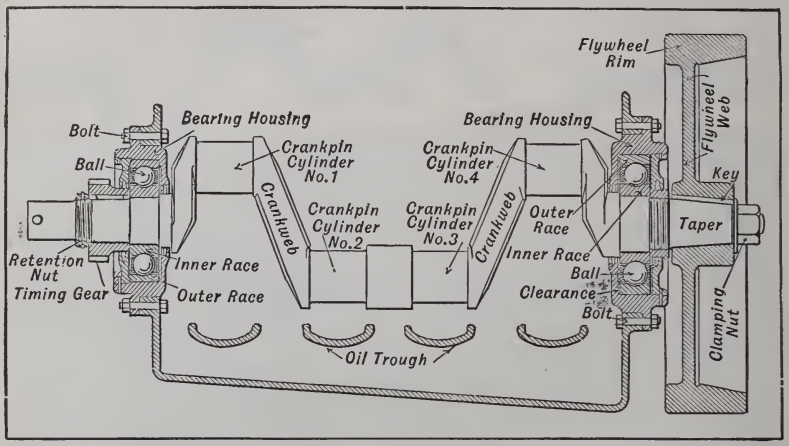


Fig. 248.—Design of Four-Cylinder Crank Shaft Mounted on Two Annular Ball Bearings. Note Method of Fly-wheel Retention by Key and Taper and Method of Housing Bearing.

utilized. When ball bearings are selected with proper relation to the load which obtains they will give very satisfactory service. They permit the crank shaft to turn with minimum friction, and if properly selected will never need adjustment. The drawing at Fig. 248 shows the usual method of mounting a four-cylinder crank shaft on two

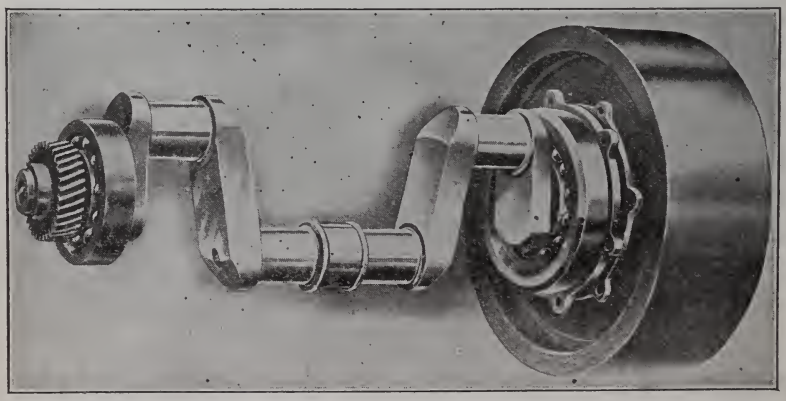


Fig. 249.—Four-Throw, Two-Bearing Crank Shaft of Chalmers Four-Cylinder Motors Mounted on Anti-friction Ball Bearings.

annular ball bearings. The front end is supported by a bearing which is clamped in such a manner that it will take a certain amount of load in a direction parallel to the axis of the shaft, while the rear end is so supported that the outer race of the bearing has a certain amount of axial freedom or "float." The inner race or cone of each bearing is firmly clamped against shoulders on the crank shaft. At the front end of the crank shaft the timing gear and a suitable check nut are used, while at the back end the bearing is clamped by a threaded retention member between the fly wheel and a shoulder on the crank shaft. The fly wheel is held in place by a taper and key retention. The ball bearings are carried in a housing of bronze or malleable iron, which in turn are held in the crank case by bolts. The two-bearing crank shaft

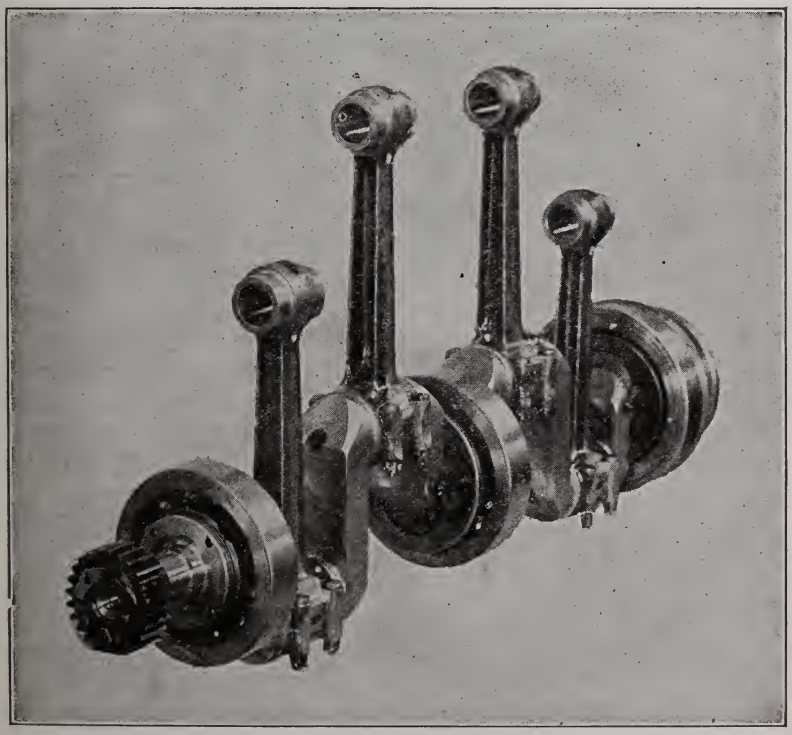


Fig. 250.—Four-Throw, Three-Bearing Crank Shaft of Lozier Four-Cylinder Cars Mounted on Three Annular Ball Bearings.

shown at Fig. 249 is that used in Chalmers' four-cylinder motors, while a three-bearing crank shaft supported on anti-friction members of the ball type which has been used successfully on Lozier cars is shown at Fig. 250. Figs. 248 and 249 show designs of two-bearing,

four-cylinder crankshafts, such as used in block motors very clearly, while the form depicted at Fig. 250 forms part of a motor having the cylinders cast in pairs.

Counterweighted Crankshafts.—The development of the high-speed engine has produced the balanced crankshafts shown at Fig. 251.

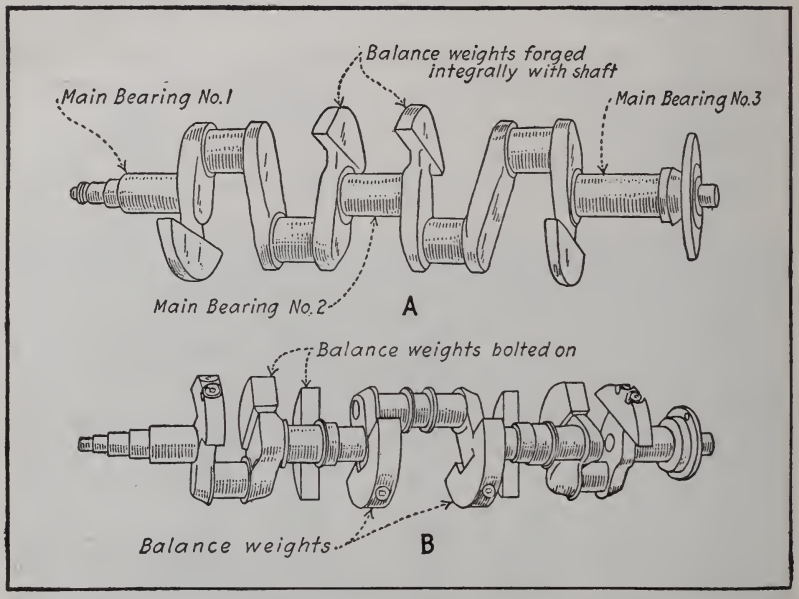


Fig. 251.—Latest Design of Counterbalanced Crankshafts. A—Four-Cylinder Type with Balance Weights Forged Integral. B—Balanced Crankshaft of the Hudson Super-Six Engine Having Bolted-on Balance Weights.

That at A is a four-cylinder type having the weights forged integrally. That at B is the crankshaft of the Hudson Super-Six and has the balance weights attached to the crankshaft by nickel steel bolts. The Hudson system of balancing takes care of inertia forces as well as the rotating masses, and is said to enable high rotative speeds without destructive vibration. In order to demonstrate the fact that the counterbalanced crankshaft reduces the internal friction of an engine, the Hudson company made a series of runs with the counterbalanced shaft and with the shafting nearly in static balance. The first run was made to obtain maximum power, this being reached at 3,100 r. p. m. when 110 H. P. was developed. The connecting-rod bearings were then adjusted and a 40-minute run at 3,000 r. p. m. was made, the horsepower varying between 100.4 and 103.5. At the conclusion of this second run the weights on the crankshaft were removed and

a steel ring attached to the center throw in order to bring the shaft into static balance. This having been done, the test was repeated, first for maximum power and second for endurance. The latter test only lasted for 2 minutes, 30 seconds, as the cap of one of the connecting-rod bearings became loose and was thrown off.

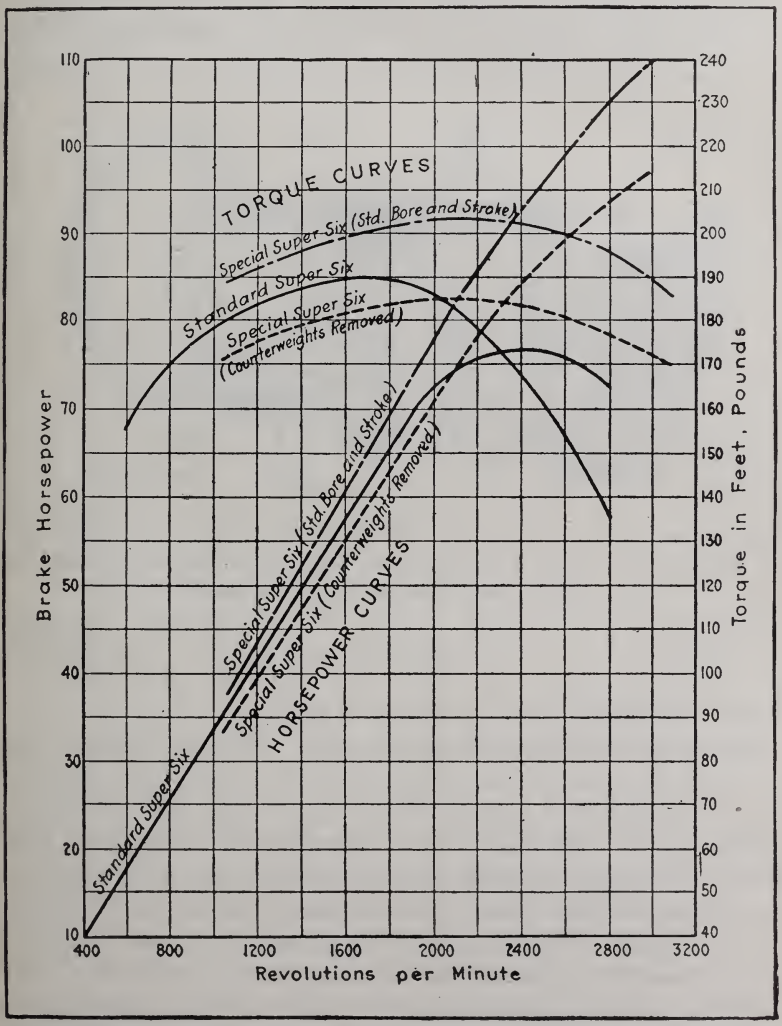


Fig. 252.—Horse-power Curves Showing Increase in Power Possible by Counterbalancing Hudson Super-Six Crankshaft.

It will be noticed from the curves shown at Fig. 252 that the special engine with which the tests were made, both with and without

counterweights, gives practically the same reading as the stock Hudson engine up to 2,000 r. p. m., but that considerable divergence commences at this point. The similarity between the torque curves of the Special Super-Sixes is characteristic of the kind of difference caused by internal friction.

The six-cylinder crankshaft shown at Fig. 253 is balanced by two disks placed between the first and second cylinder crank throws

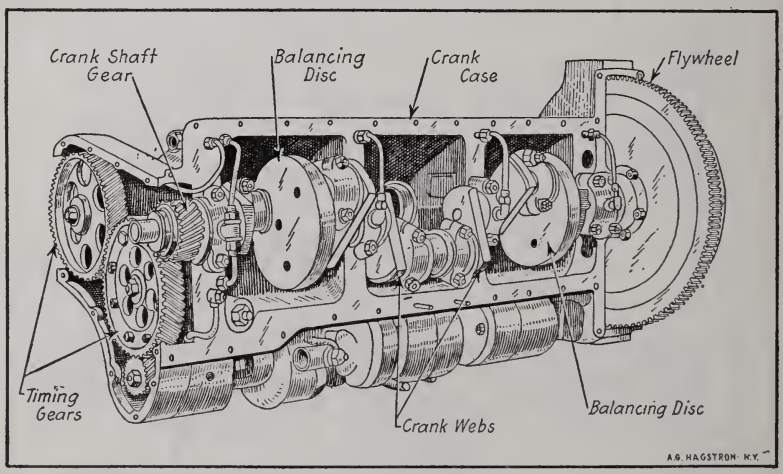


Fig. 253.—Bottom View of Amalgamated Six-Cylinder Engine, Showing Balancing Disk Arrangement on Crankshaft.

and between the fifth and sixth cylinder crank pins. The crankshaft is a four-main-bearing pattern and differs from the usual construction because of the disk form of balance weights.

Lanchester-Packard Vibration Damper.—With a six-throw crankshaft, whether there be six pistons or twelve, one of the commonest forms of vibration is that produced by the twisting of the shaft at certain speeds. The shaft has a natural period of vibration if deflected torsionally, and when the sequence of explosions coincides with the natural vibration period the pendulum effect causes the violence of the vibration to be increased. The matter is explained fully in the *Automobile,* from which the following excerpts were taken: The vibration which is perceptible to the passengers in the car is due to the front crank throw twisting with each explosion, and then the spring of the crank jerking the piston back as soon as the power stroke is over. Elasticity of the steel causes oscillations to take place, so the crank flies back too far, springs forward again and so vibrates many times before returning to its proper position, by which time the

succeeding explosion again displaces it. The oscillation of the piston disturbs the center of gravity of the whole piston mass much more than the first deflection does, and the object of the Lanchester damper is to resist the return spring of the crank so that the twist caused by the explosion is made "dead beat."

The original design of F. W. Lanchester, a leading British automobile engineer, was to mount on the front end of the crankshaft a little fly-wheel and disk clutch, as shown at Fig. 254. The inner mem-

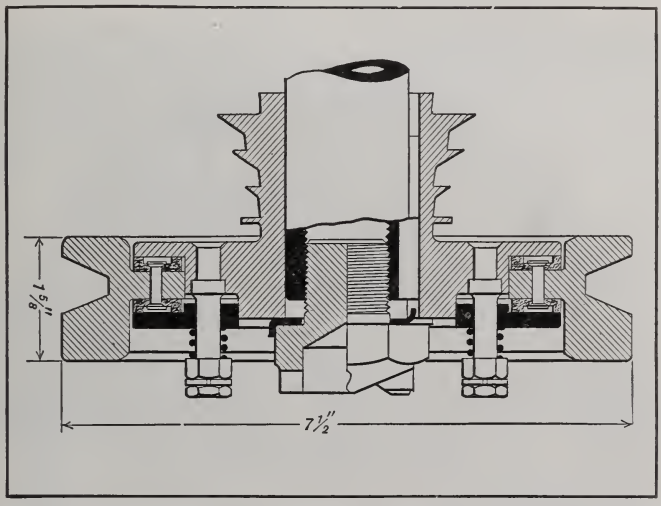


Fig. 254.—Lanchester-Packard Vibration Dampener for Twelve-Cylinder V Engines.

ber of the clutch was secured to the shaft and the fly-wheel rim rode loose. Thus when the crank twisted forward the inertia of the fly-wheel rim caused it to try to maintain a steady speed and the clutch slipped a little, and when the crank tried to twist back at the end of the power stroke the fly-wheel rim again resisted the tendency to oscillate. The sum total of effect is that the energy of the twisting crank is absorbed by friction between the clutch surfaces and the rapid oscillations are prevented. Something depends upon the strength of the clutch spring in the damper, as the little fly-wheel rim must be sufficiently loose to be able to act as described, but not so loose that the friction will be too small to absorb the energy of torsion. The adjustment is not delicate and once the proper strength for the clutch spring has been found the damper can be made on a production basis and fitted complete without any further attention. When first tried out the effect of the damper was amazing, turning a six-cylinder motor

with a weak crankshaft and two bad vibration periods into a smooth and almost vibrationless engine. Broadly, it may be said that a 2-inch crankshaft with the damper is the equivalent of a 2½-inch shaft without the device.

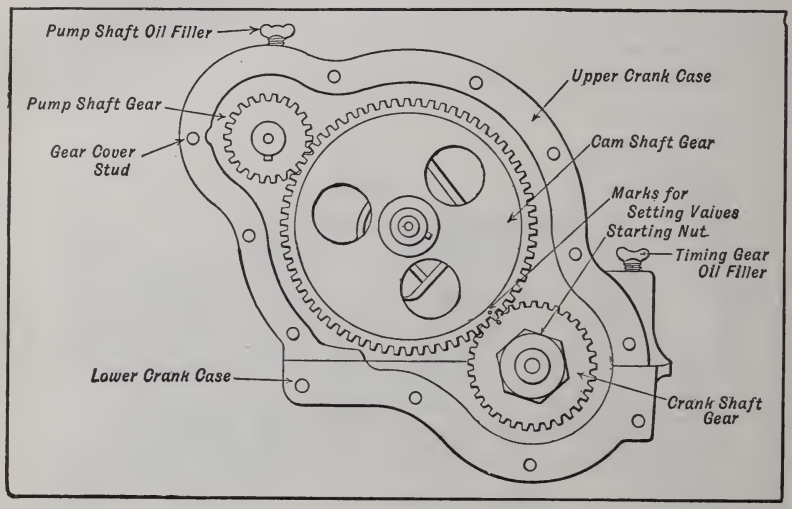


Fig. 255.—Timing Gear Assembly, Showing Gear on Buick Crankshaft Employed to Drive Crankshaft Gear.

Fly-wheel Construction and Retention.—In explaining the principle of operation of the internal combustion engine it was made clear that there were four strokes of the piston necessary to complete the cycle of operation in any one cylinder, and of these but one was a useful or power stroke. The gasoline engine would not be a practical power producer, especially if made in one- and two-cylinder patterns, without some means of equalizing the uneven power generation. Considering first the single-cylinder motor, we find that we have but one explosion every four strokes, and as this represents two revolutions of the crank shaft it will be evident that it is necessary to store up energy by some means in order to carry the crank shaft through the idle strokes. This is accomplished by supplying a heavy wheel which is secured in a positive manner to the crank shaft and which turns with it. When the explosion drives the piston down considerable energy is stored in the fly-wheel rim and it will continue to revolve after the impulse given it has diminished in value to a considerable extent. In fact there is enough energy stored in the fly wheel of proper weight to carry the piston through all the idle strokes and to tend to equalize

the torque produced. This insures a more even turning moment and makes for reasonably uniform application of power to the mechanism.

The fly-wheel weight is dictated largely by the number of cylinders employed, it being a general rule that the motors having the least number of cylinders require the heaviest fly wheels. This means that a single-cylinder motor will need a heavier equalizing member than one having a greater number of cylinders and a more even turning moment at the crank shaft. As an example of how the number of

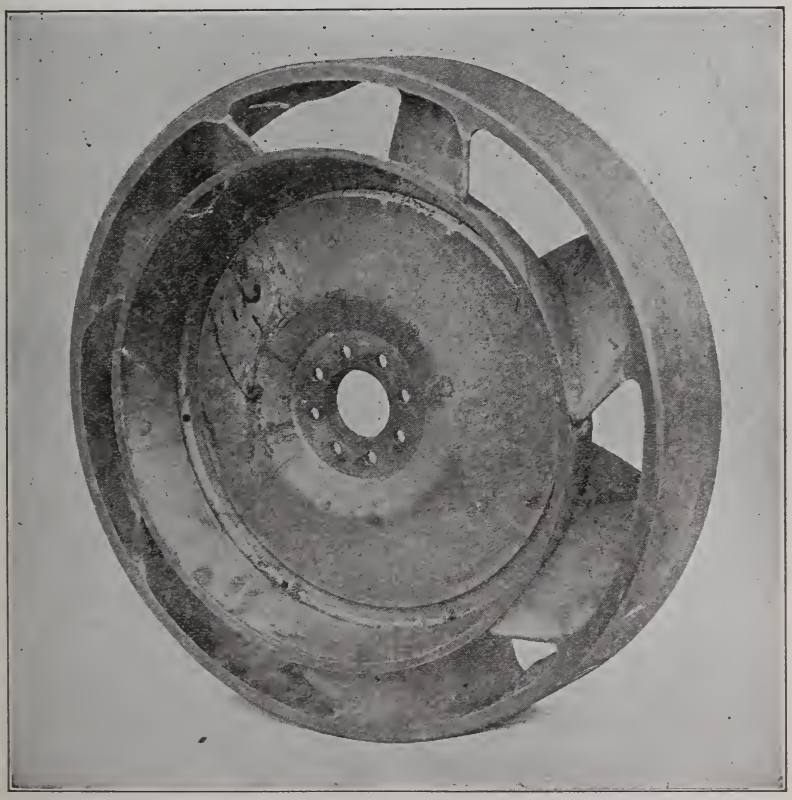


Fig. 256.—Typical Flywheel, Showing Female Member of Cone Clutch and Fan-Blade Spokes. Rim is Light Because of Large Diameter.

cylinders directly affects fly-wheel weight, one may say that if a single-cylinder engine of given power required a fly wheel of two hundred pounds weight to equalize the power effect, a double-cylinder engine would need one of about one hundred and sixty pounds, a four-cylinder engine would use one weighing but one hundred pounds, while a six-cylinder motor would furnish a uniform torque with a fly-wheel

member weighing no more than sixty pounds. Fly-wheel weight is determined by many conditions, some of the important ones being bore of the cylinder, speed of crank-shaft rotation, degree of compression, and mode of transmission. It is common practice to provide a fly wheel somewhat heavier than the actual requirements on multi-cylin-

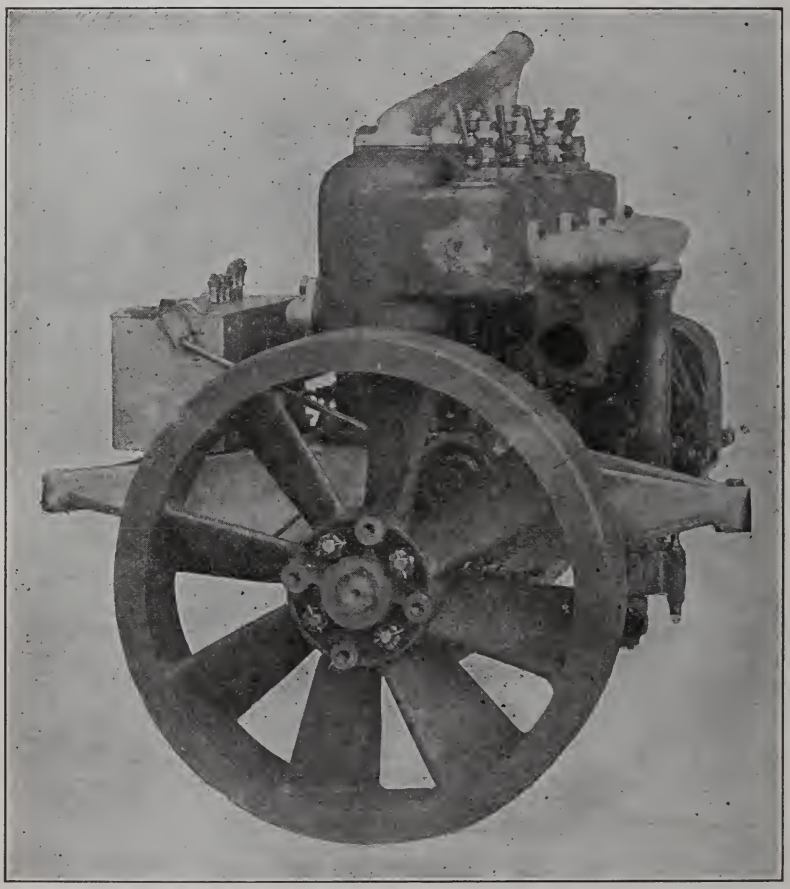


Fig. 257.—Rear View of Early Overland Power Plant, Showing Fan-Blade Spoke Fly-wheel Construction.

der motors of large bore so that these may be more easily started with the hand crank by a person of average strength.

Fly-wheel types vary from simple spoked members resembling a belt pulley with a heavy rim to others having fan-shaped spokes and light rims. Where a sliding gear transmission is used it is customary to make one of the clutch members integral with the fly wheel. For

instance, at Fig. 256 a typical fan-blade fly wheel adapted for use with a cone clutch is shown. This has a central web member which forms the back of a saucer-shaped casting which serves as a female member of the cone clutch. From the periphery of this, the spokes radiate to the rim. As the fly wheel is of comparatively large diameter the rim is lighter than would be necessary if the weight were concentrated nearer the center of the crankshaft. At Fig. 257 the rear view of a power plant is given showing a simple type of fan-blade fly wheel, which is secured to the crank shaft by means of four bolts. As this member is designed for use with a type of gearset with the clutches incorporated, it is not necessary to provide for part of the clutch in the fly-wheel casting.

The diameter of a fly wheel must be held to certain limits and this restricts the useful weight one can put at the rim. If the fly wheel is placed low in the car it cannot be of large diameter, because one must have at least twelve or fourteen inches clearance between the bottom of the fly wheel and the roadway. Then again, the factor of centrifugal force must be taken into account, as when a fly wheel revolves there is a tendency for the particles of which it is composed to fly out in a direction tangential to the circle of rotation, and this force tends to rupture the rim. If steel is used instead of cast iron, the fly wheel may be of larger diameter, because the stronger material has greater resistance to this rupturing stress, but these wheels are not easy to make because in ordinary motor car sizes they must be steel castings or large forgings and are thus quite costly. For a cast-iron fly wheel a safe value for speed of rotation of a point on the rim is about a mile a minute. It will be seen that the diameter must be such that the fly wheel may be run at maximum speeds without danger of bursting.

A fly wheel having a solid web joining the hub and rim is considerably stronger than one of the spoke type. The object of providing spokes shaped like fan blades is to take advantage of a suction effect produced to draw air from the motor compartment and exhaust it under the car. In some cars the draft created by the fly wheel is depended upon to supply the air needed for cooling the engine, either by applying it directly to the cylinders or by pulling it through the interstices of a water-cooling radiator. It is considered desirable to concentrate as much of the weight of the fly wheel at the rim as possible, because the further away from center the weight is carried the more effective the fly wheel is as a reservoir of energy and equalizer of power. Most modern engines use the solid web type of fly wheel, as shown at Fig. 234, and have a steel gear for the electric starter to

engage attached to the rim. In some cases the teeth are cut into the periphery of the cast-iron fly wheel. The method shown is the best, because any defect in the gear may be remedied without replacing the entire fly wheel.

Positive Fly-wheel Retention Important.—Methods of fly-wheel retention vary to some extent, and the main point observed by most designers is to use as secure a method of attaching it to the crank shaft as possible. The common systems of retention employed are shown at Fig. 258. The simplest of these is depicted at A. This consists merely

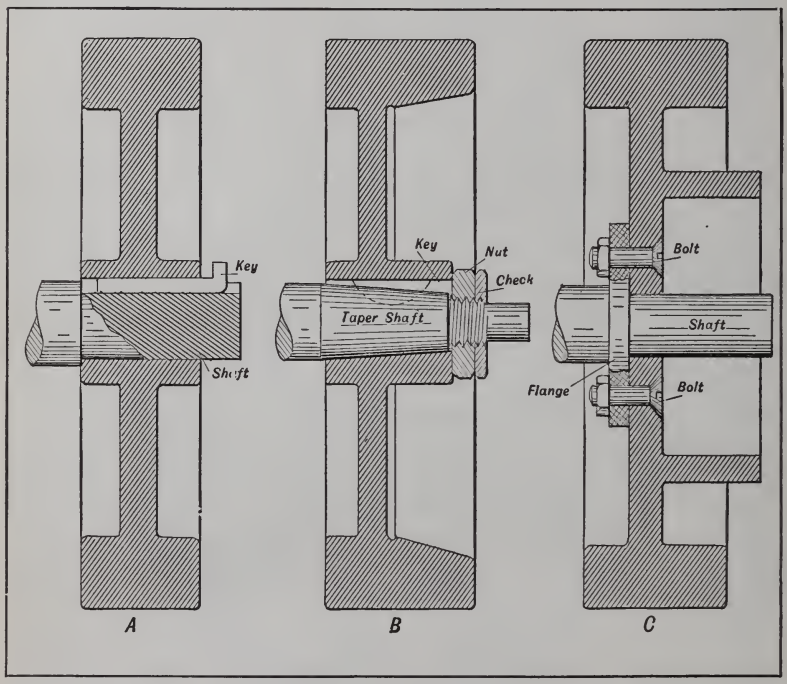


Fig. 258.—Outlining Methods of Fly-wheel Retention Commonly Used. A—By Gib Key. B—By Woodruff Key, Taper and Clamp Nut. C—By Bolting to Flange Forged Integrally with Crankshaft.

of forcing the shaft into the fly-wheel hub and keeping the fly wheel from turning on the shaft by a substantial key which fits keyways machined in both shaft and fly-wheel hub. This method was formerly used to a greater extent than it is at present, but its use has been practically abandoned, except on marine engines, because the means of fastening was not reliable. The intermittent application of power to the fly wheel meant that its speed of rotation was accelerated

at a certain point of the crank-shaft travel corresponding to the power stroke and checked at the other, or idle strokes. This produced stresses which tended to loosen the fly wheel on the key, and as soon as the retaining member was slightly loose a very disagreeable knocking sound was produced by the hammering action of the loose fly wheel on its retaining key.

At B a system often employed on types of crank shafts where it is not practical to use the preferred method shown at C is outlined. For instance, when ball bearings are applied it is necessary that they

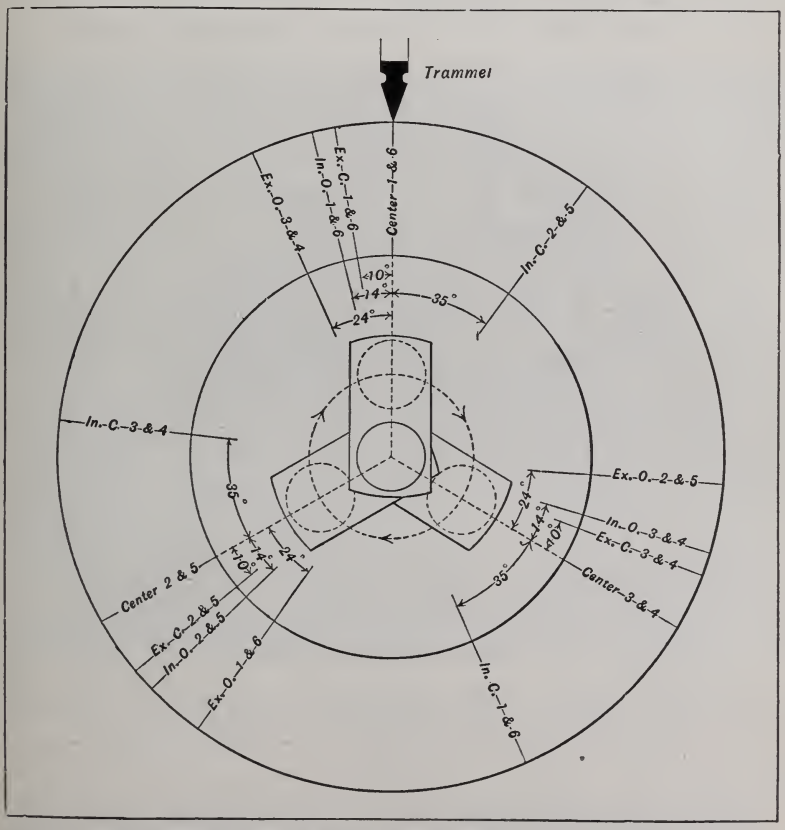


Fig. 259.—Showing Method of Marking Rim of Six-Cylinder Engine Fly Wheel for Guiding Repairman or Motorist to Retain Correct Valve Timing.

be put on the shaft from each end and if a flange was formed integral it would not be possible to use ball bearings except of very large bore. Then again, some engineers using alloy steel for crank-shaft construction machine it from a slab of that material, and in order to reduce

cost of manufacture no attempt is made to form the flange integral with the shaft. In this the end of the shaft designed to support the fly wheel is tapered, as is also the fly-wheel hub. In addition to the taper a Woodruff key is usually let into the shaft and keyway cut into the fly-wheel hub to receive it. When the fly wheel is forced on the taper by the clamping nut it is firmly retained by the key, and at the same time the wedging effect of the taper and the pressure of the clamping nut prevents the fly wheel from loosening. The fly wheel at B has a portion of the rim machined on a taper, so it can receive the male member of a cone-type clutch.

The fly wheel shown at C is held by the preferred method. In forging the crank shaft a flange is formed integral and the fly wheel is secured to this flange by means of suitable retaining screws or bolts. If these are properly fitted it is practically impossible for the fly wheel to loosen on the flange, and as the flange is a part of the shaft it is obviously impossible for it to become separated therefrom. The fly wheel shown at C is provided with a casing formed integral which is designed to receive a clutch of the multiple-disk pattern.

Fly-wheel Marks.—The writer has previously explained the action of the valve mechanism and diagrams have been presented to show the sequence of the strokes. Most manufacturers mark the fly wheel with the various points at which valves should open or close. This not only facilitates work at the plant of the producer, but it insures that the timing will be restored to the proper point in event of taking the engine down for repair at some garage or machine shop. The various points are laid out on the fly-wheel periphery by means of steel stamps or letters, which may be easily interpreted. The position of these lines is determined by the peculiarities of that specific engine, and will vary in the different designs. The layout is always made with reference to some fixed point on the motor bed, this usually being a small metal pointer attached to a center point and known as a "trammel." The various points at which valves should open and close for a typical six-cylinder engine are clearly shown laid out on the fly-wheel rim at Fig. 259.

Engine-Base Construction.—One of the important parts of the power plant is the substantial casing or bed member, which is employed to support the cylinders and crank shaft and which is attached directly to the motor-car frame. This will vary widely in form, but as a general thing it is an approximately cylindrical member which may be divided either vertically or horizontally in two or more parts. Automobile crank cases are usually made of aluminum, a material which has about the same strength as cast iron, but which only weighs

a third as much. In many cases cast iron is employed, but is not favored by all engineers because of its brittle nature and low resistance to tensile stresses. Where exceptional strength is needed alloys of bronze are used, and in some cases where cars are produced in large quantities the lower portion of the crank case may be a sheet steel stamping.

Crank cases are always large enough to permit the crank shaft and parts attached to it to turn inside and obviously its length is determined by the number of cylinders and their disposition. The crank case of the single-cylinder or double-opposed cylinder engine would be substantially the same in length. That of a four-cylinder will vary

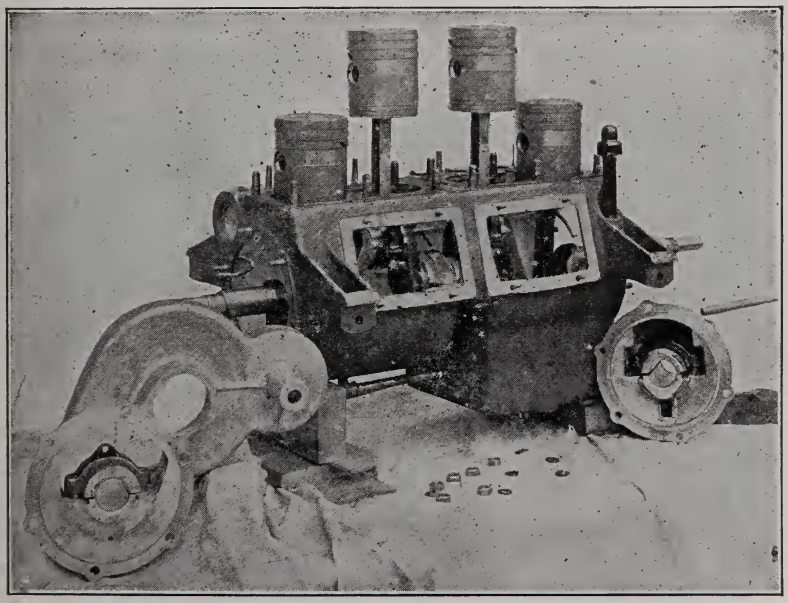


Fig. 260.—Crank Case of Reo Four-Cylinder Motor, a Barrel Type with Ends Closed by Plates which Support the Crankshaft.

in length with the method of casting the cylinder. When the four cylinders are cast in one unit and a two-bearing crank shaft is used, the crank case is a very compact and short member. When a three-bearing crank shaft is utilized and the cylinders are cast in pairs, the engine base is longer than it would be to support a block casting, but is shorter than one designed to sustain individual cylinder castings and a five-bearing crank shaft.

A four-cylinder crank case of the barrel type is shown at Fig. 260. The construction calls for the use of end-bearing plates, which carry

the front and rear main journals. In order to gain access to the interior, large openings are provided at the side of the case and closed by plates when the assembly is completed. The cylinders are held in place by a series of stud bolts screwed into the top of the case, and a similar method of retention is utilized for the end plates. A projection from the side serves to house the cam shaft, while the motor-timing gears are protected by a separate casting member, which is part of the front bearing plate. It is now common construction to cast an oil container integral with the bottom of the engine base and to draw the lubricating oil from it by means of a pump. The arms by which the motor is supported in the frame are substantial-ribbed members cast integrally.

The approved method of crank-case construction favored by the majority of engineers is shown at Fig. 261, bottom side up. The

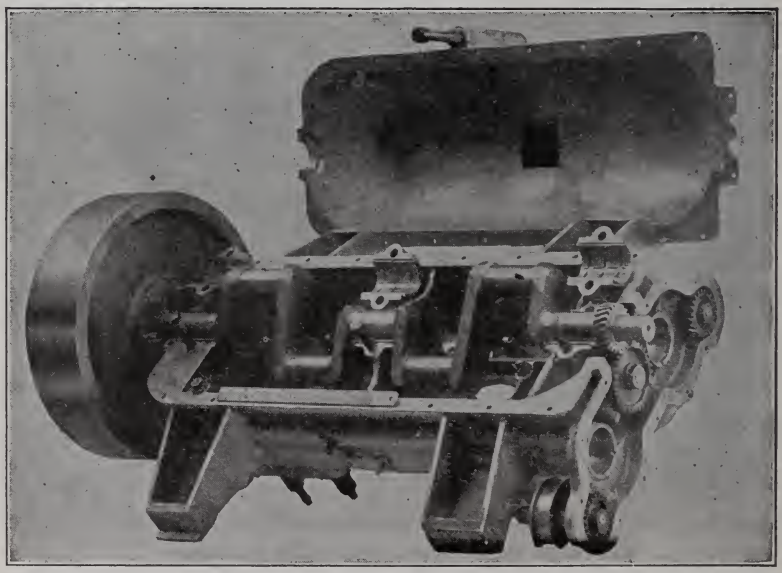


Fig. 261.—Crank Case of Motor Truck Power Plant Made in Two Halves. Crank-shaft Bearings and Caps Supported by Upper Half, which also Has Carrying Arms Cast Integrally. The Lower Portion of Crank Case Acts Merely as an Oil Container. Engine Base Shown Up-side-down in Illustration.

upper half not only forms a bed for the cylinder but is used to hold the crank shaft as well. In the illustration the three-bearing crank shaft is shown resting in the upper main bearing boxes which form part of the case, while the lower brasses are in the form of separately

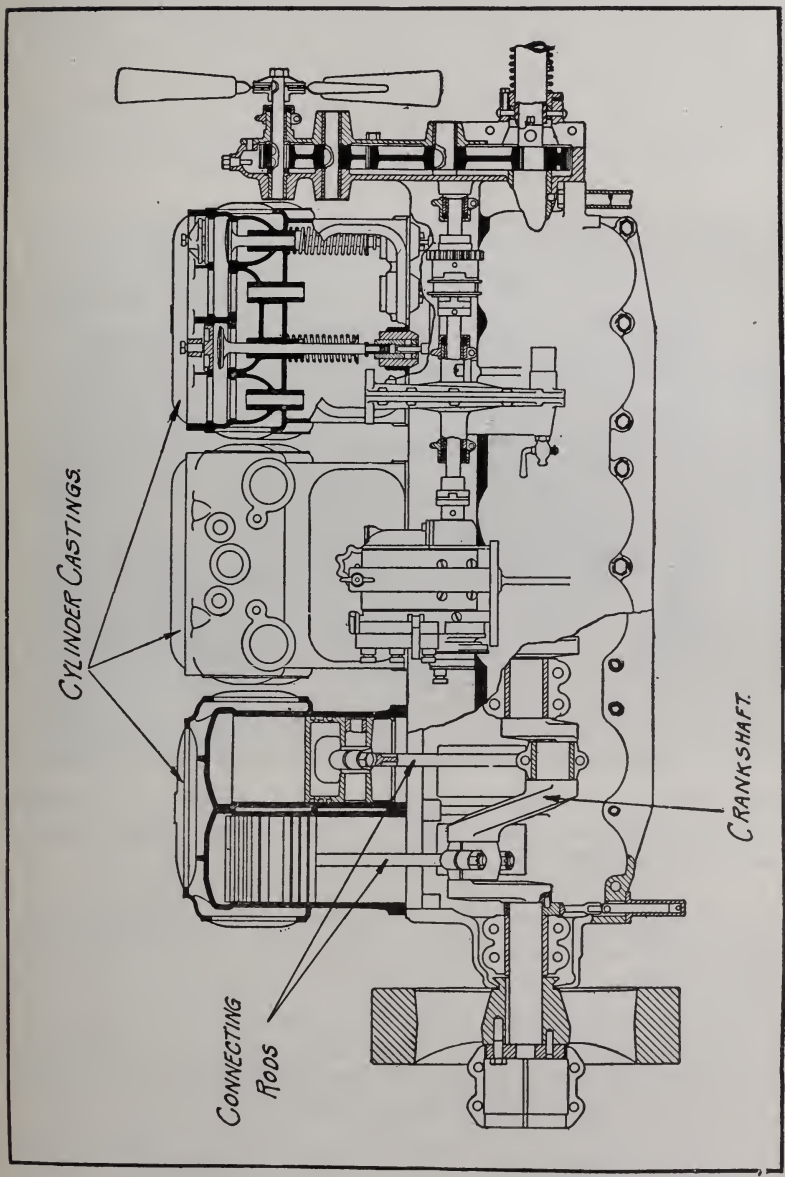


Fig. 262.—Part Sectional View of Early Winton Six-Cylinder Engine, an Unconventional Design Having the Crank Case Divided on Vertical Instead of Horizontal Center Lines.

cast caps retained by suitable bolts. In the construction outlined the bottom part of the case serves merely as an oil container and a protection for the interior mechanism of the motor, a vertically divided crank case which was used for some time by the makers of the Winton automobile and is shown at Fig. 262.

In some instances where barrel-type crank cases are employed, instead of using hand holes for adjustment in the side, the design is as shown at Fig. 263. The bottom of the crank case is left open in cast-

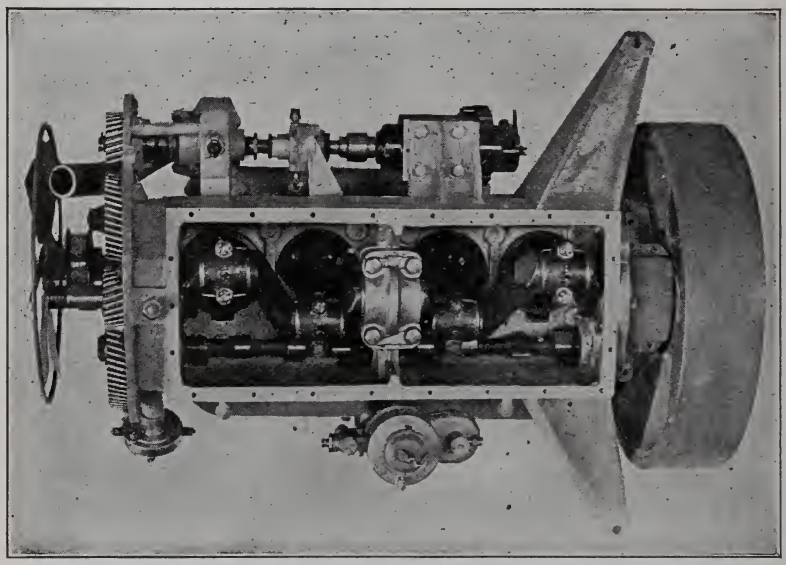


Fig. 263.—Bottom View of Four-Cylinder Power Plant. Crank Case is a Barrel Form with Removable Bottom Plate to Permit Access to Engine Interior, Important Power Plant Parts Clearly Shown.

ing and is closed by a large plate. The interior parts of the engine are clearly depicted, as they appear viewed from the bottom, and the accessibility afforded by this design should be readily perceived. Engineers who favor unit power plants often include as a portion of the crank case the housing for the clutch and gearset. In designing crank cases the main thing to be considered is to have it of ample strength and to arrange the various parts so that the interior mechanism may be reached without dismantling the entire engine when adjustments are necessary.

Steel Engine Cylinders.—Cylinders made of steel have been used in racing engines as far back as ten years ago, and in recent years they have been extensively used in aeronautical engines of the revolv-

ing cylinder air cooled type as exemplified in the Gnome engine. The cost of these is so high that the use of steel cylinders in standard stock automobiles was not practical. Steel cylinders have advantages, though they have not been looked upon with favor by automobile engineers. The illustrations at Fig. 264 show a built-up design that

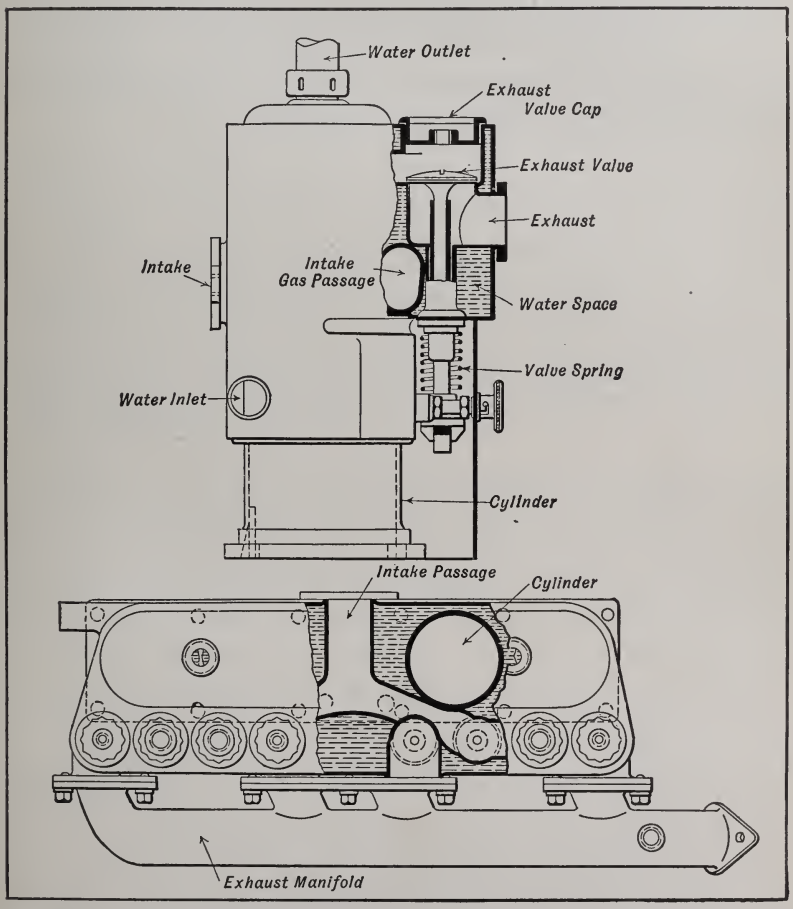


Fig. 264.—Part Sectional Views, Showing Construction of Steel Four-Cylinder Block of German Design.

originated in Germany and which has been applied to stock cars. It is claimed that these cylinders weigh only one-third as much as cast-iron cylinders of the same strength. With steel cylinders almost absolute uniformity of cylinder wall thickness is obtained, something that cannot be assured with cast iron. The four-cylinder block shown

is intended for an engine of about 3¼-inch bore and 5 inches stroke. The inlet passage is formed inside the cylinder and has its outlet at the opposite side from the valves. A separate exhaust manifold of thin wall tubing is provided, this being joined to the cylinders by flange connections. Cast-iron valve stem guides are used, these being forced into the steel valve chambers. The block is built up of steel tubing and sheet metal sections, flame-welded together after they are formed. In order to secure a rigid cylinder block, a common steel plate unites all the cylinder ends and has holes for the retaining bolts by which the group is fastened to the crank case.

CHAPTER V

Liquid Fuels and Distillates of Crude Petroleum—Gasoline—Kerosene—Benzol and Its Properties—Special Vaporizers Needed for Kerosene—Advantages and Disadvantages of Alcohol—Alcohol-Benzol Fuel—Taylor-White Process—Solid Gasoline as a Fuel—Principles of Carburetion Outlined—Air Needed to Burn Gasoline—What a Carburetor Should Do—Liquid Storage and Supply—Storage in Cowl Tank—Rear Tank Location—Fuel Tank Location Advantages Summarized—Stewart Vacuum Fuel Feed—Air Stoves—Church Fuel Feed—Carter Diaphragm Pump—Early Vaporizer Forms—Wick Surface Vaporizer—Bubbling Type Vaporizer—Spraying Type Carburetors—Mixing Valves—Lanchester Wick Feed Carburetor—Development of Float Feed Carburetor—Maybach's Early Design—Elements of Carburetor Design—Venturi Type Mixing Chamber—Concentric Float and Mixing Chambers—Problem of Float Bowl Design—Gasoline Spray Nozzle Forms—Typical Auxiliary Air Valves—Methods of Gas Supply Regulation—Centrifugal Governors—Hydraulic Governor—Kramer Governor.

THERE is no appliance that has more material value upon the efficiency of the internal combustion motor than the carburetor or vaporizer which supplies the explosive gas to the cylinders. It is only in recent years that engineers have realized the importance of using carburetors that are efficient and that are so strongly made that there will be little liability of derangement. As the power obtained from the gas engine depends upon the combustion of fuel in the cylinders, it is evident that if the gas supplied does not have the proper proportions of elements to insure rapid combustion the efficiency of the engine will be low. When a gas engine is used as a stationary installation it is possible to use ordinary illuminating or natural gas for fuel, but when this prime mover is applied to automobile or marine service it is evident that considerable difficulty would be experienced in carrying enough compressed coal gas to supply the engine for even a very short trip. Fortunately, the development of the internal combustion motor was not delayed by the lack of suitable fuel.

Engineers were familiar with the properties of certain liquids which gave off vapors that could be mixed with air to form an explosive gas which burned very well in the engine cylinders. A very small quantity of such liquids would suffice for a very satisfactory period of operation. The problem to be solved before these liquids could be

applied in a practical manner was to evolve suitable apparatus for vaporizing them without waste. Among the liquids that can be combined with air and burned, gasoline is the most volatile and is the fuel utilized by the majority of internal combustion engines employed in self-propelled conveyances.

The widely increasing scope of usefulness of the internal combustion motor has made it imperative that other fuels be applied in some instances because the supply of gasoline may in time become inadequate to supply the demand. In fact, abroad this fuel sells for fifty to two hundred per cent more than it does in America because most of the gasoline used must be imported from this country or Russia. Because of this foreign engineers have experimented widely with other substances, such as alcohol, benzol, and kerosene. The properties of these fuels, their derivation and use should be considered fully before describing the types of apparatus utilized for vaporizing them.

Distillates of Crude Petroleum.—Crude petroleum is found in small quantities in almost all parts of the world, but a large portion of that produced commercially is derived from American wells. The petroleum obtained in this country yields more of the volatile products than those of foreign production, and for that reason the demand for it is greater. The oil fields of this country are found in Pennsylvania, Indiana, and Ohio, and the crude petroleum is usually in association with natural gas. This mineral oil is an agent from which many compounds and products are derived, and the products will vary from heavy sludges, such as asphalt, to the lighter and more volatile components, some of which will evaporate very easily at ordinary temperatures.

The compounds derived from crude petroleum are composed principally of hydrogen and carbon and are termed "Hydro-Carbons." In the crude product one finds many impurities, such as free carbon, sulphur, and various earthy elements. Before the oil can be utilized it must be subjected to a process of purifying which is known as refining, and it is during this process, which is one of destructive distillation, that the various liquids are separated. The oil was formerly broken up into three main groups of products as follows: Highly volatile, naphtha, benzine, gasoline, eight to ten per cent. Light oils, such as kerosene and light lubricating oils seventy to eighty per cent. Heavy oils or residuum five to nine per cent. From the foregoing it will be seen that the available supply of gasoline is determined largely by the demand existing for the light oils forming the larger part of the products derived from crude petroleum. New processes recently discovered by which the lighter oils, such as kerosene, are reduced in

proportion and that of gasoline increased, though the resulting liquid is neither the high grade, volatile gasoline known in the early days of motoring nor the low grade kerosene. It is a liquid that has the properties of both fuels to a degree. Great improvements in carburetor design and application have made it possible to use fuels of low volatility with considerable success.

As a comparatively small portion of the distillates can be used with ordinary vaporizing devices any improvements to make possible the use of less liquid or utilize the cheaper fuels, such as kerosene, will be of great value in increasing the usefulness of internal combustion motors. Considerable attention is being given to mixing devices which will permit the use of kerosene, and many authorities have agreed that this material or alcohol will be the fuel of the future. To show the enormous consumption of gasoline in this country, it has been said that if all of the engines in use which depended on this fuel were to be operated continuously together for a ten-hour day that over fifteen million gallons of liquid would be consumed. When one considers that the number of explosive engines is constantly augmenting it will not be difficult to perceive the reason why the development of devices to use fuels other than gasoline should be encouraged.

Benzol and Its Properties.—In England, where gasoline sells for fifty cents a gallon in normal times, or one hundred per cent more than the average price in this country, engineers have sought to use benzol, which is said to be adaptable to the present types of motors without change, and in cases where it has been used as much power is obtained as with gasoline. This material is a by-product incidental to the manufacture of illuminating gas and coke, and while it was formerly distilled from coal-tar and obtained only in small quantities, improved methods make it possible to produce about three gallons from every ton of coal changed into coke or gas. The former material was at one time produced by a process which permitted the gas to escape, but at the present time this is retained and condensed to form benzol. The crude product is a foul-smelling liquid which has about the same consistency and color as heavy ale. When subjected to a refining process the dirty liquid is converted to one that is about the same color as water.

Benzol is not so volatile as gasoline, but it is claimed that a motor may be started without difficulty with this fuel supplied to a carburetor of ordinary construction. Owing to the greater number of heat units it contains, it is said it will develop more power than gasoline, and as it will not evaporate so readily it does not become stale or heavy by the vaporization of the lighter constituents. A disadvantage incidental to its use has been that owing to it being richer in carbon

than gasoline it would deposit more of this substance on the piston head and interior of the combustion chamber. While this may be true of a poorly refined benzol and when mixture proportions are not correct, it applies equally well when low grades of gasoline are used and when the mixture of gasoline vapor and air supplied the cylinders is too rich.

Special Vaporizers Needed for Kerosene.—As kerosene forms one of the larger portions of the distillates of crude oil it is apparent that if this material could be used as fuel for internal combustion engines it might replace gasoline to a certain extent. If considered from a point of view of heat units contained or heating value kerosene would be a better fuel than gasoline, though considering it with its other disadvantages in mind it is not so suitable for use in existing types of motors. The chief difficulty which retards its use is that it will not vaporize readily at ordinary temperatures, and before it will evaporate sufficiently to form a gas with air it must be heated. This calls for specially constructed vaporizing devices and jacketed manifolds, which will be described in proper sequence. Owing to the low rate of evaporation it is contended that it cannot be used as successfully as gasoline on high-speed motors where flexibility of control is desired and where the engine must be accelerated from its minimum to the highest speed in a short time. On slow and moderate speed motors, such as used for stationary and marine service, kerosene has been employed with some degree of success. It contains more carbon in its composition, and as the combustion of kerosene vapor is apt not to be as complete as gasoline gas, more carbon will be deposited in the interior of the combustion chamber than when gasoline is burned. Recently devised carburetion systems have made it possible to secure good commercial results with kerosene, and while it can never be as good as the more volatile hydrocarbons, it may be used in many engines where extreme high speed and flexibility is not needed.

Advantages of Alcohol.—Considerable experimenting with alcohol has been done by French and German engineers, and there are many points to be considered in its favor when discussing its value as a fuel. Alcohol, instead of being derived from natural mineral deposits, which become more and more depleted as the demands increase, is derived from various plants and vegetables and is the one fuel that can be produced in quantities that could be augmented as the demand for it increased. The vegetable substances which are distilled to make alcohol are reproduced each cycle of seasons, and in tropical countries there is no cessation to the growth of the vegetation. The raw materials from which alcohol may be manufactured are found in all parts

of the earth. It is derived from any substance which contains either starch or sugar, and it can profitably be produced from fruits, grains, and vegetables. It may be made from beets, sugar-cane, rice, barley, rye, corn, wheat, or potatoes, and decaying fruit or other refuse, which could not be utilized otherwise, may be subjected to a process of distillation and alcohol derived therefrom.

Alcohol differs materially from gasoline, and as it is less volatile it requires more heat to vaporize it. Alcohol vapor can be compressed to a greater degree than the vapors of gasoline, and as the heat units liberated from a fuel vary with the degree of compression even though alcohol gives out less heat when burned under the same conditions, higher efficiency may be obtained by compressing the alcohol vapor to a higher degree. While this substance has been used for a decade or more abroad, in engines designed especially for its use, it has not been applied with any degree of economy in motors designed for use with gasoline.

A motor constructed for use with alcohol must use a higher degree of compression than a gasoline motor, and a form of carburetor which will heat the mixture before it is taken into the cylinder should be used. An engine designed for gasoline will use twice as much alcohol as it does gasoline to develop the same amount of energy, though in a special motor the same amount of power will be obtained as when equal quantities of gasoline are burned in the conventional engine. One of the disadvantages of alcohol that is shared in common with kerosene is that it is difficult to start an engine when cold, as alcohol is not very volatile unless heated.

The amount of air necessary for complete combustion is roughly estimated at one third that needed with gasoline. Twice the amount of compression before ignition can be used with alcohol vapor. The range of explosive mixture proportions of alcohol and air is much greater than that possible with gasoline and air. Various authorities have stated that a compression of one hundred and fifty pounds per square inch is possible with alcohol, but it is doubtful if automobile engines will ever be built using such high degrees of compression unless demands for extremely economical operation will result in the development of Diesel engine types which use much higher compression pressure than this because only air is compressed by the main engine piston and there cannot be any danger of pre-ignition as when a gaseous mixture is compressed too much.

Taylor-White Process.—A process has been developed with a view of permitting one to use alcohol in engines of present design with no change except a special form of vaporizer. In this the alcohol vapor is

passed through calcium carbide before it enters the cylinder. The water which is present in commercial alcohol and which lowers its efficiency as a fuel is absorbed by the carbide and the resulting chemical action liberates acetylene gas. This is very inflammable and increases the explosive value of the alcohol vapor. When the alcohol-acetylene combination is used, to obtain the same thermal efficiency as with gasoline gas, it is necessary to add water to the alcohol until a solution containing seventeen per cent water and eighty-three per cent alcohol is obtained.

This is no great disadvantage, as water costs nothing to speak of, and the increase in the bulk of the fuel nearly pays for the carbide. It is estimated that one pound of carbide is used per gallon of liquid. As the market price of carbide in lots of one hundred pounds or more is but four to five cents per pound, the only objection that can be advanced to the process is the increased complication of the vaporizing appliance. The combination of alcohol and acetylene has proved efficient on motors employing compressions as low as sixty pounds to the square inch and running as high as two thousand revolutions per minute, but when used alone the slow burning qualities of alcohol vapor have made it most efficient on slow-speed high-compression motors.

Alcohol used for fuel purposes must be rendered unfit for drinking by mixing substances with it which are not palatable, but which do not interfere with its use as a fuel. When so treated the substance is called denatured alcohol. Among the substances which may be mixed with the ethyl alcohol are wood alcohol, benzine, and benzol, and various distillates of crude petroleum. Chemists contend that it is better to use a hydrocarbon, such as benzol, than the wood alcohol, as a denaturizing substance, because wood alcohol tends to produce acetone and other compounds which are of corrosive nature and which might corrode the metal parts of the cylinder which were exposed to the effects of a by-product resulting from incomplete combustion of such a vapor.

Alcohol has the advantage in that the fire risk is less than with gasoline. The latter is a more volatile liquid than alcohol, and is more dangerous because it evaporates more readily. The flame of burning gasoline is one which radiates heat rapidly, whereas the alcohol flame does not radiate heat to such an extent. A mass of burning gasoline will generate sufficient heat to set objects at a considerable distance from it on fire. The heat from burning alcohol goes upward and exists mostly in the hot gases evolved by the flame. A gasoline fire is spread by water, whereas burning alcohol may be extinguished by it. Gasoline is much lighter than water and floats on its surface,

but alcohol is so nearly the same density that it will mix with the water.

If one compares the chemical composition of alcohol and gasoline it will be found that it requires less air to burn a pint of alcohol than the same amount of gasoline. The oxygen contained in the alcohol tends to make combustion better, and there is practically no residue left in an engine burning alcohol gas. The exhaust from any of the petroleum distillates will smell strong and be smoky if an excess of fuel in proportion to air is in the mixture. The burned products of an alcohol mixture are not objectionable even if there is an excess of alcohol. These exhaust gases, besides being more agreeable to the senses, are cooler and cleaner, and as they contain a smaller proportion of free carbon less of this is deposited in the combustion chamber and muffler.

Among the conditions which are unfavorable to the use of alcohol and which militate against its use at the present time can be cited the present types of engines and carburetors, and the high price of denatured alcohol. While alcohol has not been extensively experimented with in this country, because the supply of gasoline at the present time seems adequate, it is expected that, should there be a shortage of this valuable commodity, forms of vaporizers will be devised which will permit the use of alcohol in connection with present-day forms of motors. Some authorities contend that alcohol will be the fuel of the future, while others believe that kerosene is more adaptable for use in the hydrocarbon motor.

Alcohol-Benzol Fuel.—According to reports, the German army automobiles are being run on a mixture of benzol and alcohol. As soon as Germany found herself cut off from outside supplies of gasoline a technical committee was appointed to find a substitute. Experiments were carried out with a 1914 Mercedes touring car equipped with an ordinary carburetor, when mixtures of alcohol and benzol were found to give satisfactory results. Summarized, the results obtained in these tests were as follows:

Benzol	Alcohol	Speed Obtained M. p. h.	Miles on 1 Liter of Fuel
1 part	1 part	42.2	4.66
1 part	2 parts	41	4.4
1 part	3 parts	39.1	4.3
1 part	4 parts	38.5	4.1
1 part	5 parts	36	3.7
Benzol only		41.6	3.79
Gasoline only		43.49	3.6

Calculating on the rates existing before the war, the benzol-alcohol mixture is the cheapest fuel obtainable. One liter of gasoline costs 9 cents, benzol 8.6 cents, and alcohol 8.2 cents. The cost per kilometer works out as follows:

	Cents		Cents
Gasoline	0.0157	Alcohol-benzol, 50%	0.0125
Benzol	0.01362	Pure alcohol	0.0167

This shows that a fifty per cent mixture of alcohol and benzol is the most economical, and it is this fuel which has been used throughout the German motor transport service. The only inconvenience experienced is the necessity of a preliminary heating of the carburetor. Starting the motor is a difficult task, and on several occasions when the army has been retreating automobiles have been abandoned on this account. This difficulty has been overcome by fitting a secondary tank containing a small quantity of gasoline or ether. A three-way cock allows the supplementary tank to be put into connection with the carburetor for starting purposes. As soon as the motor is warm the reserve fuel is shut off and the alcohol-benzol mixture supplied to the motor. In case of a breakdown near the enemy's lines, or the loss of the main fuel through a bullet or piece of shell entering the tank, the reserve supply is used. This is able to take the vehicle ten or twelve miles, which is generally sufficient to remove it from the danger zone.

Solid Gasoline as a Fuel.—Experiments are being conducted in Europe with gasoline in the solid form, which is said to have some advantages over the liquid fuels. Solid gasoline is a transparent product which is in the form of a jelly, having sufficient consistency so that it can be handled like any other solid body. It can be cut into pieces just as gelatine can, and may be conveyed in wooden or cardboard boxes. If examined under the microscope its structure is similar to that of a very fine sponge and the theory is that liquid gasoline is present in the pores. Its properties in general are the same as liquid fuels as it evaporates very easily, and has the same heat value. When solid gasoline is heated it does not melt under ordinary conditions but evaporates. If it is lighted it does not melt, but burns like wood, and the flame may be easily extinguished by covering with a piece of cloth.

Solidified gasoline has about eighty per cent the bulk of ordinary liquid gasoline; whereas a gallon of liquid will occupy a space of 231 cubic inches, the same amount solidified will occupy but about 185

cubic inches. The mixture may be easily obtained, as solid gasoline dissolves in air at ordinary temperatures and yields a combustible gas which may be used in explosion motors. Solid gasoline can be used without first converting it into a liquid and a mixture of gasoline vapor and air is formed by causing a slightly heated current of air to pass over the surface of the solid fuel. It is claimed that a very good mixture is obtained. Appliances designed for carbureting solid gasoline utilize the exhaust gases of the motor as a source of heat for securing more ready evaporation.

It is not likely that gasoline in this form will ever be used to any extent because the carburetor used will have to be very bulky and very much different in construction from that used for the liquid. The argument that solid gasoline is safer than liquid gasoline is not borne out by facts, because it will evaporate quite readily and give off vapors at ordinary temperatures. It is open to question whether a fuel can be handled easier in solid or liquid form. It would seem to the writer that it would be as easy to pour fuel out of a can directly into a suitable container as it would be to handle it in the form of blocks. The expense of solidifying the liquid would probably be sufficiently large so that any advantages accruing would be more than balanced by disadvantages of some moment. When one considers that all motor vehicles now in use are fitted to burn liquid gasoline the difficulty experienced in attempting to put the solid fuel on the market, even if it was cheaper than the liquid form, will be readily understood.

Principles of Carburetion Outlined.—The process of carburetion is combining the volatile vapors which evaporate from the hydrocarbon liquids with certain proportions of air to form an inflammable gas. The quantities of air needed vary with different liquids and some mixtures burn quicker than do other combinations of air and vapor. Combustion is simply burning and it may be rapid, moderate, or slow. Mixtures of gasoline and air burn quickly, in fact, the combustion is so rapid that it is instantaneous and we obtain what is commonly termed an "explosion." Therefore the explosion of gas in the automobile engine cylinder which produces the power is really a combination of chemical elements which produce heat and an increase in the volume of the gas because of the increase in temperature.

If the gasoline mixture is not properly proportioned the rate of burning will vary, and if the mixture is either too rich or too weak the power of the explosion is reduced and the amount of power applied to the piston is decreased proportionately. In determining the proper proportions of gasoline and air, one must take the chemical composition of gasoline into account. The ordinary liquid used for fuel is

said to contain about eighty-four per cent carbon and sixteen per cent hydrogen. Air is composed of oxygen and nitrogen and the former has a great affinity, or combining power, with the two constituents of hydrocarbon liquids. Therefore, what we call an explosion is merely an indication that oxygen in the air has combined with the carbon and hydrogen of the gasoline.

Air Needed to Burn Gasoline.—In figuring the proper volume of air to mix with a given quantity of fuel, one takes into account the fact that one pound of hydrogen requires eight pounds of oxygen to burn it, and one pound of carbon needs two and one-third pounds of oxygen to insure its combustion. Air is composed of one part of oxygen to three and one-half portions of nitrogen by weight. Therefore for each pound of oxygen one needs to burn hydrogen or carbon four and one-half pounds of air must be allowed. To insure combustion of one pound of gasoline which is composed of hydrogen and carbon we must furnish about ten pounds of air to burn the carbon and about six pounds of air to insure combustion of hydrogen, the other component of gasoline. This means that to burn one pound of gasoline one must provide about sixteen pounds of air.

While one does not usually consider air as having much weight, at a temperature of sixty-two degrees Fahrenheit about fourteen cubic feet of air will weigh a pound, and to burn a pound of gasoline one would require about two hundred cubic feet of air. This amount will provide for combustion theoretically, but it is common practice to allow twice this amount because the element nitrogen, which is the main constituent of air, is an inert gas and instead of aiding combustion it acts as a deterrent of burning. In order to be explosive, gasoline vapor must be combined with definite quantities of air. Mixtures that are rich in gasoline ignite quicker than those which have more air, but these are only suitable when starting or when running slowly, as a rich mixture ignites much quicker than a weak mixture. The richer mixture of gasoline and air not only burns quicker but produces the most heat and the most effective pressure in pounds per square inch of piston top area.

The amount of compression of the charge before ignition also has material bearing on the force of the explosion. The higher the degree of compression the greater the force exerted by the rapid combustion of the gas. It may be stated that as a general thing the maximum explosive pressure is somewhat more than three times the compression pressure prior to ignition. A charge compressed to sixty pounds will have a maximum of approximately two hundred pounds; one compacted to eighty pounds will produce a pressure of about two hundred

and fifty pounds on each square inch of piston area at the beginning of the power stroke. Mixtures varying from one part of gasoline vapor to four of air to others having one part of gasoline vapor to thirteen of air can be ignited, but the best results are obtained when the proportions are one to five or one to seven, as this mixture is the one that will produce the highest temperature, the quickest explosion, and the most pressure.

What a Carburetor Should Do.—While it is apparent that the chief function of a carbureting device is to mix hydrocarbon vapors with air to secure mixtures that will burn, there are a number of factors which must be considered before describing the principles of vaporizing devices. Almost any device which permits a current of air to pass over or through a volatile liquid will produce a gas which will explode when compressed and ignited in the motor cylinder. Modern carburetors are not only called upon to supply certain quantities of gas, but these must deliver a mixture to the cylinders that is accurately proportioned and which will be of proper composition at all engine speeds.

Flexible control of the engine is sought by varying the engine speed by regulating the supply of gas to the cylinders. The power plant should run from its lowest to its highest speed without any irregularity in torque, i. e., the acceleration should be gradual rather than spasmodic. As the degree of compression will vary in value with the amount of throttle opening, the conditions necessary to obtain maximum power differ with varying engine speeds. When the throttle is barely opened the engine speed is low and the gas must be richer in fuel than when the throttle is wide open and the engine speed high.

When an engine is turning over slowly the compression has low value and the conditions are not so favorable to rapid combustion as when the compression is high. At high engine speeds the gas velocity through the intake piping is higher than at low speeds, and regular engine action is not so apt to be disturbed by condensation of liquid fuel in the manifold due to excessively rich mixture or superabundance of liquid in the stream of carbureted air.

Liquid Fuel Storage and Supply.—The problem of gasoline storage and method of supplying the carburetor is one that is determined solely by design of the car. While the object of designers should be to supply the fuel to the carburetor by as simple means as possible the fuel supply system of some cars is quite complex. The first point to consider is the location of the gasoline tank. This depends upon the amount of fuel needed and the space available in the car.

A very simple and compact fuel supply system is shown at Fig. 265, which represents a view of the motor compartment of the Mar-

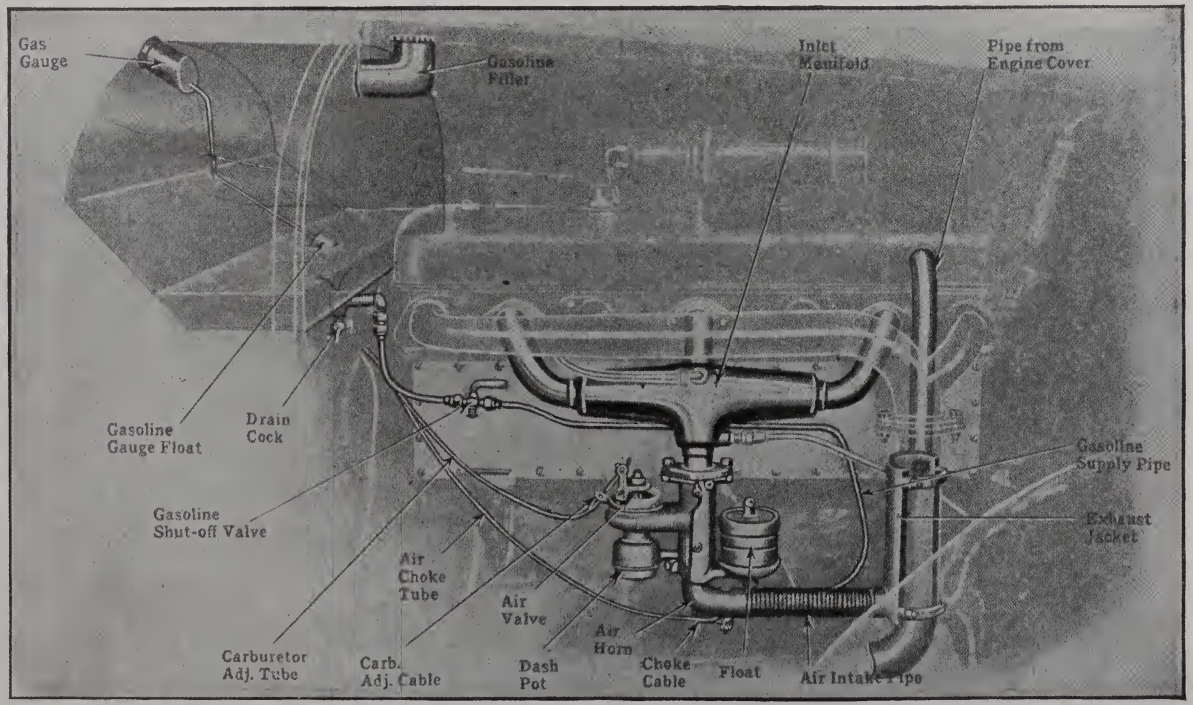


Fig. 265.—Illustrating Method of Storing Fuel in Tank Carried Under Dash Cowl of Marmon Cars, which Permits Short and Direct Gasoline Piping.

mon car. In this instance the fuel container is suspended from the dashboard cowl and is placed immediately back of the engine cylinder. The carburetor which is carried as indicated is joined to the tank by a short piece of copper tubing. This is the simplest possible form of fuel supply system.

As the sizes of cars increase and the power plant capacities augment it is necessary to use more fuel, and to obtain a satisfactory touring radius without frequent stops for filling the fuel tank it is necessary to supply large containers. The principal methods of carrying fuel are depicted at Figs. 265 to 269, inclusive. At Fig. 268

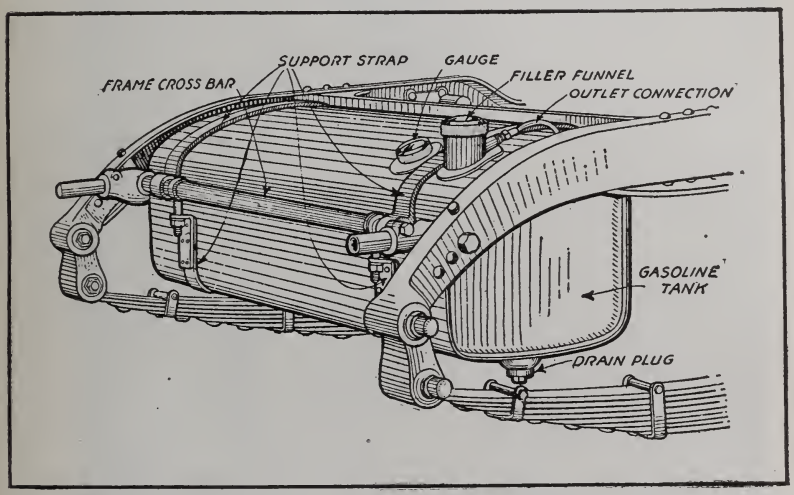


Fig. 266.—Showing Location of Fuel Tank at the Rear of Cole Eight Chassis.

the tank is placed back of the seats. It can be easily filled, and is carried high enough above the carburetor so that the fuel will run from the tank by gravity, though an air pump system is provided to make sure of the fuel feeding when climbing hills with only a small supply in the tank. The tank shown is a cylindrical form of large capacity, and is mounted at the rear end of the chassis.

In some touring cars sufficient space is provided for the reception of a fair-sized tank under the front seats. In these the tank is rectangular and is placed on suitable channel members so it can be supported on top of the frame. When a very powerful power plant is fitted, as on touring cars of high capacity, it is necessary to carry large quantities of gasoline. With the latest forms of bodies with low seats it is very difficult to find space enough for the placing of an adequately large tank. The usual method is depicted at Figs. 266, 267 and

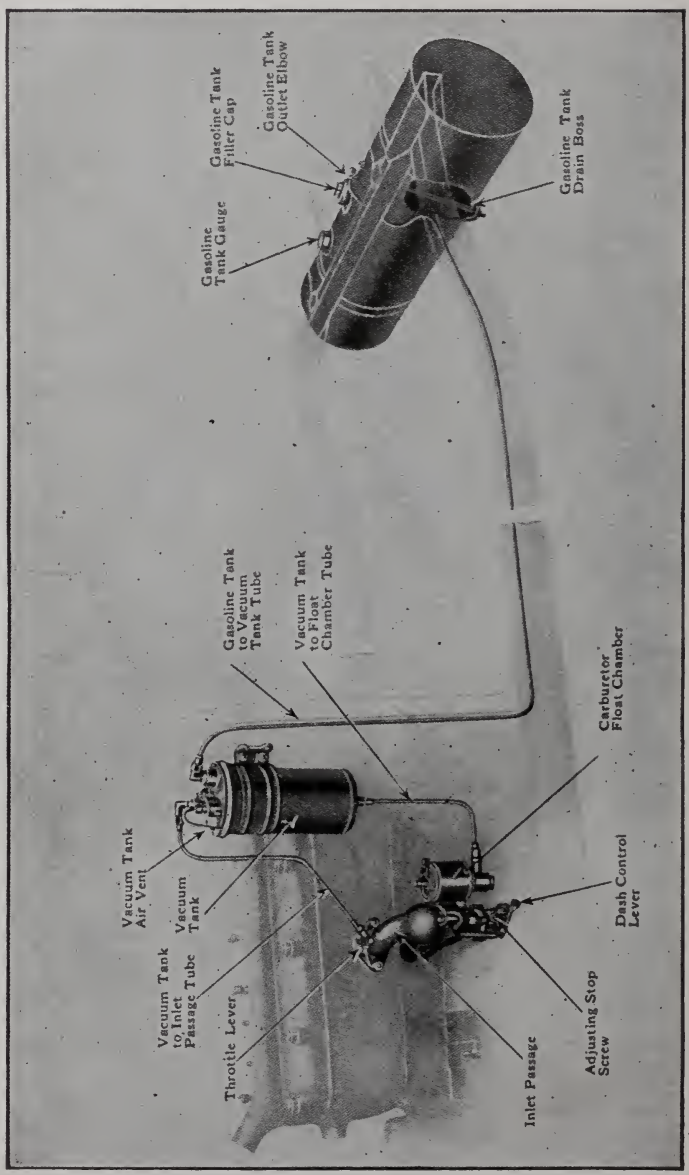


Fig. 267.—Application of the Stewart Vacuum Fuel Feed on Dodge Cars.

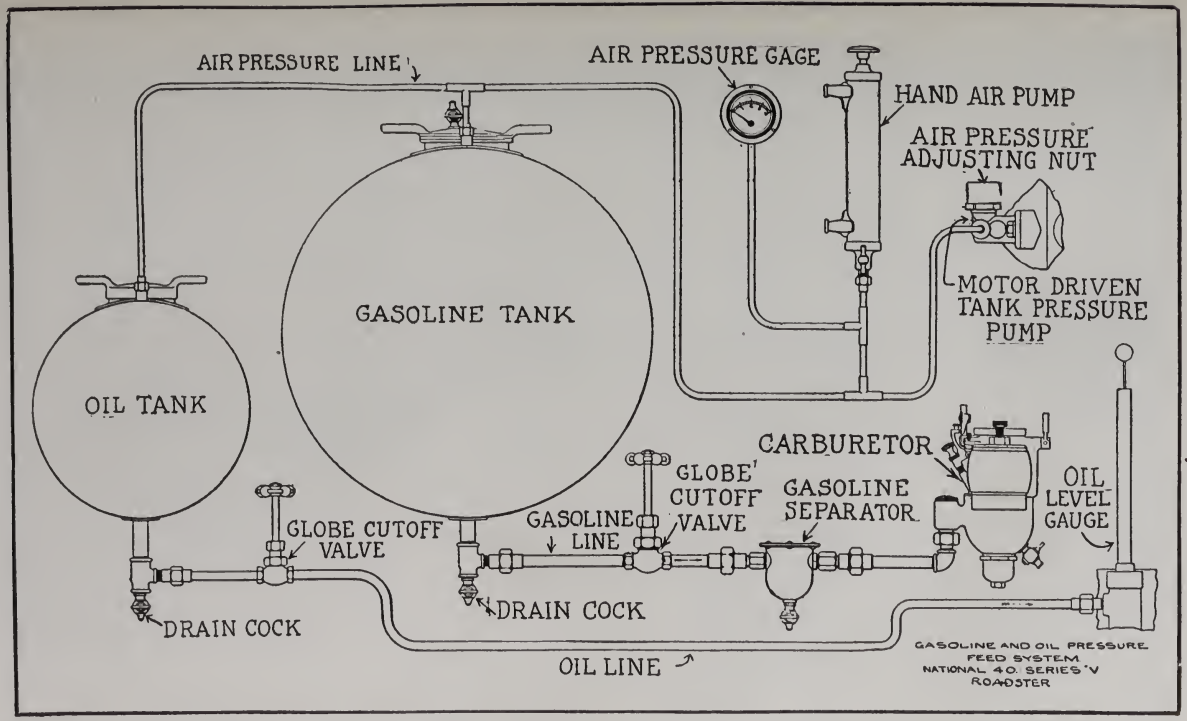


Fig. 268.—Complete Fuel and Oil Supply System of National Roadster.

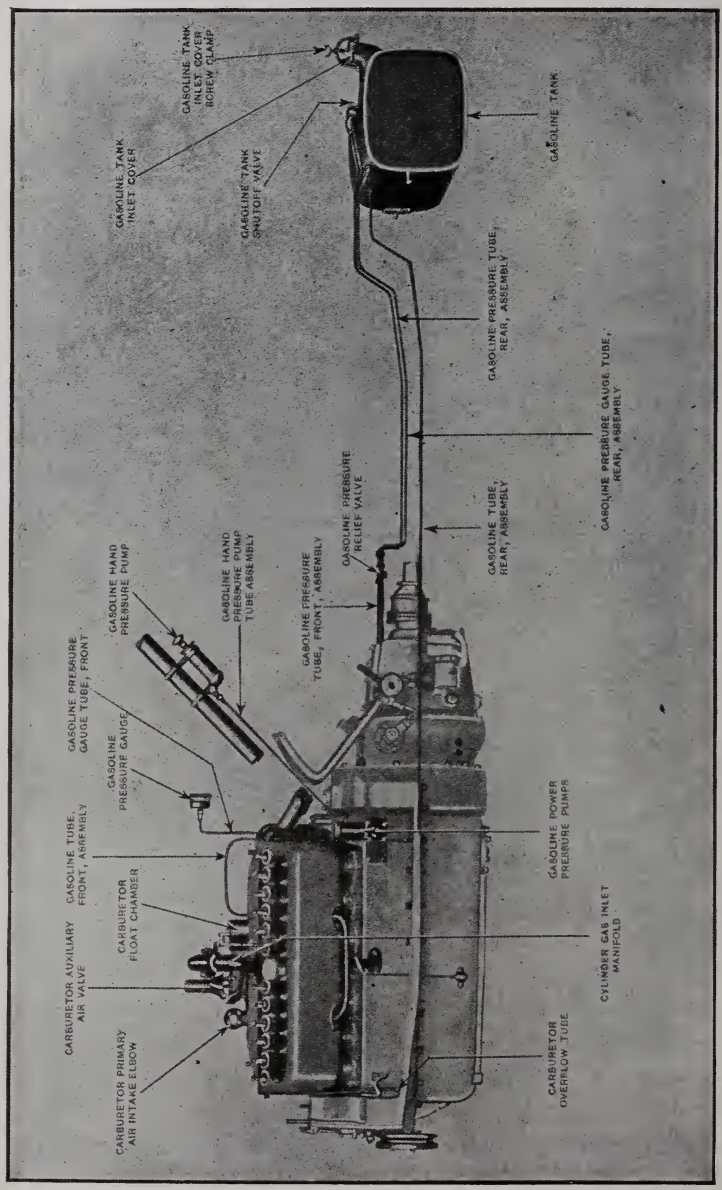

GASOLINE TANK INLET COVER SCREW CLAMP
GASOLINE TANK INLET COVER
GASOLINE TANK SHUTOFF VALVE
GASOLINE TANK
GASOLINE PRESSURE TUBE, REAR, ASSEMBLY
GASOLINE PRESSURE GAUGE TUBE, REAR, ASSEMBLY
GASOLINE TUBE, REAR, ASSEMBLY
GASOLINE PRESSURE RELIEF VALVE
GASOLINE PRESSURE TUBE, FRONT, ASSEMBLY
GASOLINE HAND PRESSURE PUMP TUBE ASSEMBLY
GASOLINE HAND PRESSURE PUMP
GASOLINE PRESSURE GAUGE TUBE, FRONT
GASOLINE PRESSURE GAUGE
GASOLINE TUBE, FRONT, ASSEMBLY
CARBURETOR AUXILIARY AIR VALVE
CARBURETOR FLOAT CHAMBER
CARBURETOR PRIMARY AIR INTAKE ELBOW
GASOLINE POWER PRESSURE PUMP
CYLINDER GAS INLET MANIFOLD
CARBURETOR OVERFLOW TUBE

Fig. 269.—Illustration Depicting Important Parts of Packard Twin-Six Air Pressure Fuel Supply System.

269. In this the large fuel container is carried under the frame members at the extreme rear of the chassis. When installed in this manner it is necessary to force fuel out of the tank by air pressure or to pump it with a vacuum tank because the gasoline tank is lower than the carburetor it supplies.

The fuel system shown at Fig. 270 shows how the gasoline may be raised to the carburetor when the tank is placed at the rear of the

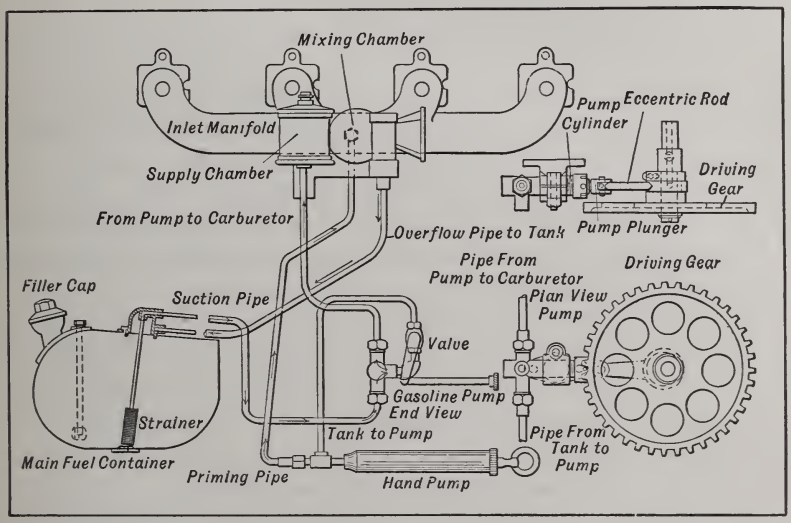


Fig. 270.—Unconventional System of Early Development, in which a Pump is Depended Upon to Draw Fuel from the Container and Deliver it to Vaporizer.

chassis. A gear-driven plunger pump takes the fuel from the tank through the suction pipe and delivers it to the supply bowl of the carburetor, which it fills to a height determined by an overflow tube. When the liquid in the supply compartment of the carburetor exceeds the predetermined level it returns to the tank through an overflow pipe. Two pumps are provided, one worked by the engine, the other manually operated. The hand pump is used in emergencies, such as for priming the carburetor or for regular supply of fuel in case of failure of the main pump.

Formerly the most common method of supplying gasoline to the carburetor when the tank was carried so low that the fuel would not flow by its weight was to pump air or gas into the supply tank and displace the gasoline by its pressure. From the main supply tank the fuel went to a small auxiliary tank carried on the dash of the power-plant compartment. A short pipe connects this small container with

the carburetor, and as this auxiliary tank is higher than the mixing device the fuel will flow by gravity. If the gasoline under pressure was fed directly to the carburetor it might result in an oversupply of fuel because there might exist pressure enough to force the gasoline into the float chamber when the shut-off needle valve did not seat positively. The auxiliary tank is generally provided with some form of automatic cut-off mechanism, which interrupts the fuel supply when the small container is nearly full.

Fuel Tank Locations Summarized.—A writer in "Motor" discusses the relative advantages and disadvantages of the various fuel tank locations in a very interesting and comprehensive manner as follows: There are three locations for the gasoline tank on the ordinary touring car: First, at the rear, suspended on the chassis frame. Second, under the front seat. Third, in the cowl dash. The first location requires an air-tight tank, so that air pressure can be used for forcing fuel from tank to carburetor. In the other two cases gasoline will flow by gravity from tank to carburetor.

The advantages of the location of the tank at the rear are as follows: First, tank may be of large capacity. Second, places fuel a greater distance from engine and hot muffler. Third, helps to make a low center of gravity for the entire machine. Fourth, helps to distribute the dead load of equipment over the springs. Fifth, tends to make the car ride easier when lightly loaded; that is, without passengers in the back seat. Sixth, does not take up valuable space in body. Seventh, enables tank to be filled without disturbing passengers or spilling gasoline over the car body.

Disadvantages of Rear Location: First, places gasoline tank where it may be easily damaged by rear-end collisions or by backing around in narrow quarters. Second, on account of location requires air pressure; therefore, constant operation of the machine depends upon tank always remaining air-tight. Third, adds additional apparatus to the machine in the way of air pump and pressure indicator. Air pump often gives trouble requiring the use of hand air pump in order to return to garage. These disadvantages are not held to apply to modern vacuum feed systems which eliminate all pressure pumps and which do not call for an air-tight tank. Fourth, places increased weight on rear springs and tires, which, in most cars, are loaded considerably more than front springs or tires. This is an important point, as the rear tires are under considerably more service, due to the fact that traction is supplied through the rear tires. Fifth, requires relatively long fuel line and air pressure pipe, which may become damaged.

Advantages of Location Under Front Seat: First, fuel will flow

by gravity to carburetor. Second, First cost should be low, as very little extra frame work is necessary for this location. Tank does not require painting, and, since it is not under pressure, can be made of relatively thin material. Third, admits of easy inspection for observing amount of gasoline in tank. Fourth, tank is not liable to be injured by rear or front end collisions. Fifth, location is about midway between front and rear axles; therefore, loads, springs and tires equally. Sixth, location is less exposed and usually will receive considerable heat from muffler, which will keep the temperature up during cold weather.

Disadvantages of Front Seat Location: First, limited capacity to the shape of seat and body. Capacity of tank usually limited to about fifteen gallons. Second, requires removing cushion and disturbing passengers to fill. Usually some gasoline is spilled over side of car, thus destroying body finish. Third, tanks so located are usually supported on car sills or short pieces bolted in place, which may allow tank to be noisy on rough roads. Fourth, when gasoline is low there may be insufficient head to force gasoline into carburetor on steep hills. Fifth, occupies valuable space in body which may be used to advantage for tool box and starting and lighting battery.

Advantages of Cowl Dash Location: First, admits of easy arrangement for filling. Second, insures constant feed, as tank so located will always be higher than carburetor, even on average hills. Third, utilizes space which, heretofore, has not been used to advantage. Fourth, may be built into car body, so it will not be noisy. Fifth, easy to provide float for indicating amount of gasoline in tank, which will always be in sight of driver. Sixth, tank will receive considerable heat from engine, thereby raising temperature of gasoline, which is desirable in cold weather.

Disadvantages of Cowl Dash Location: First, limited in capacity. Unless special provision is made capacity will probably be less than in any other location in the car. Second, increases dead weight on front springs and tires. Third, unless cars are used in designing, gives interior of body restricted appearance and limits available space for accommodation of driver and passengers. Fourth, requires special shape and design for every body and will probably make repairs for leaks, caused by accidents, expensive and difficult. Fifth, places gasoline near the engine where there is the greatest danger of explosion, due to overheating engine or fire in carburetor or pan.

Stewart Vacuum Fuel Feed.—One of the marked tendencies has been the adoption of a vacuum fuel feed system to draw the gasoline from tanks placed lower than the carburetor instead of using either

exhaust gas or air pressure to achieve this end. The device generally fitted is the Stewart vacuum feed tank which is clearly shown in section at Fig. 271-A, and method of application to the side of a motor

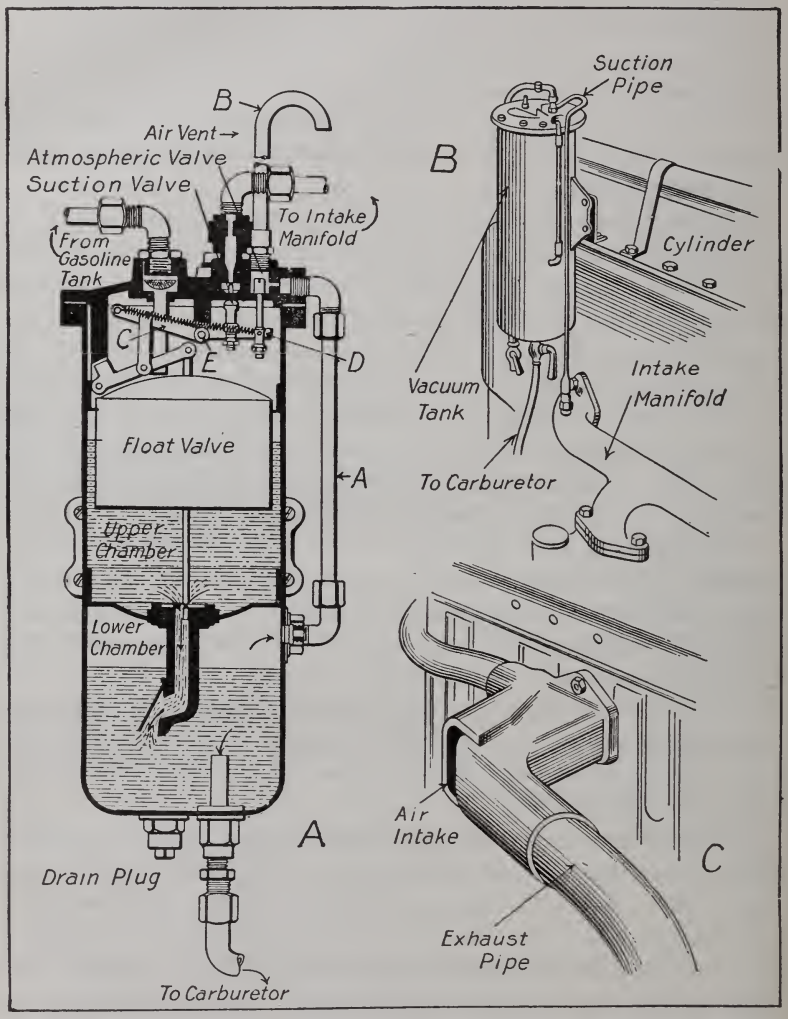


Fig. 271.—The Stewart Vacuum Fuel Feed Tank in Section and One Method of Application.

at Figs. 267 and 271-B. In this system the suction of a motor is employed to draw gasoline from the main fuel tank to the auxiliary tank incorporated in the device and from this tank the liquid flows to the carburetor. It is claimed that all the advantages of the pressure sys-

tem are obtained with very little more complication than is found on the ordinary gravity feed. The mechanism is all contained in the cylindrical tank shown, which may be mounted either on the front of the dash or on the side of the engine as shown.

The tank is divided into two chambers, the upper one being the filling chamber and the lower one the emptying chamber. The former, which is at the top of the device, contains the float valve, as well as the pipes running to the main fuel container and to the intake manifold. The lower chamber is used to supply the carburetor with gasoline and is under atmospheric pressure at all times, so the flow of fuel from it is by means of gravity only. Since this chamber is located somewhat above the carburetor, there must always be free flow of fuel. Atmospheric pressure is maintained by the pipes A and B, the latter opening into the air. In order that the fuel will be sucked from a main tank to the upper chamber, the suction valve must be opened and the atmospheric valve closed. Under these conditions the float is at the bottom and the suction at the intake manifold produces a vacuum in the tank which draws the gasoline from the main tank to the upper chamber. When the upper chamber is filled at the proper height the float rises to the top, this closing the suction valve and opening the atmospheric valve. As the suction is now cut off, the lower chamber is filled by gravity owing to there being atmospheric pressure in both upper and lower chambers. A flap valve is provided between the two chambers to prevent the gasoline in the lower one from being sucked back into the upper one. The atmospheric and suction valves are controlled by the levers C and D, both of which are pivoted at E, their outer ends being connected by two coil springs. It is seen that the arrangement of these two springs is such that the float must be held at the extremity of its movement, and that it cannot assume an intermediate position.

This intermittent action is required to insure that the upper part of the tank may be under atmospheric pressure part of the time for the gasoline to flow to the lower chamber. When the level of gasoline drops to a certain point, the float falls, this opening the suction valve and closing the atmospheric valve. The suction of the motor then causes a flow of fuel from the main container. As soon as the level rises to the proper height the float returns to its upper position. It takes about two seconds for the chamber to become full enough to raise the float, as but .05 gallon is transferred at a time. The pipe running from the bottom of the lower chamber to the carburetor extends up a ways, so that there is but little chance of dirt or water being carried to the float chamber.

If the car is allowed to stand long enough so that the tank becomes empty, it will be replenished after the motor has been cranked over four or five times with the throttle closed. The installation of the Stewart Vacuum-Gravity System is very simple. The suction pipe is tapped into the manifold at a point as near the cylinders as possible, while the fuel pipe is inserted into the gasoline tank and runs to the bottom of that member. There is a screen at the end of the fuel pipe to prevent any trouble due to deposits of sediment in the main container. As the fuel is sucked from the gasoline tank a small vent must be made in the tank filler cap so that the pressure in the main tank will always be that of the atmosphere.

In this illustration is also shown another recent improvement in carburetion at 271-C. Owing to the lower grades of fuel now being generally supplied, the primary inlet of the carburetor is connected to an air stove fastened to the exhaust pipe in order that heated air will be supplied the mixture. This assists in vaporization. The fitting outlined is exceptionally neat, inasmuch as it is a casting with which is incorporated the discharge elbow from the exhaust valve chambers of the motor to which the exhaust pipe leading to the muffler is secured.

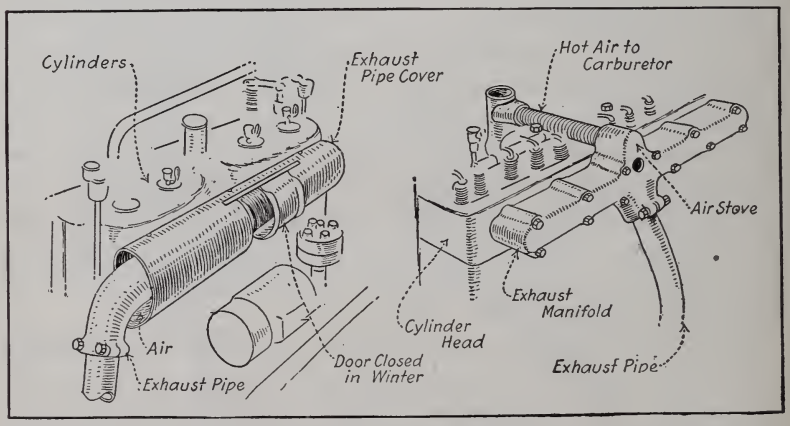


Fig. 272.—Showing Design of Air Stove for Heating Air Drawn into the Carburetor.

Other air stoves are shown at Fig. 272 and are used for the same purpose.

Church Fuel Feed.—The Church fuel feed system, shown at Fig. 273, takes pressure direct from one of the combustion chambers of the engine and uses it to lift gasoline from a rear tank to a supplementary tank, whence the feed to the carburetor is by gravity. Since its first introduction the system has been improved in detail and now includes

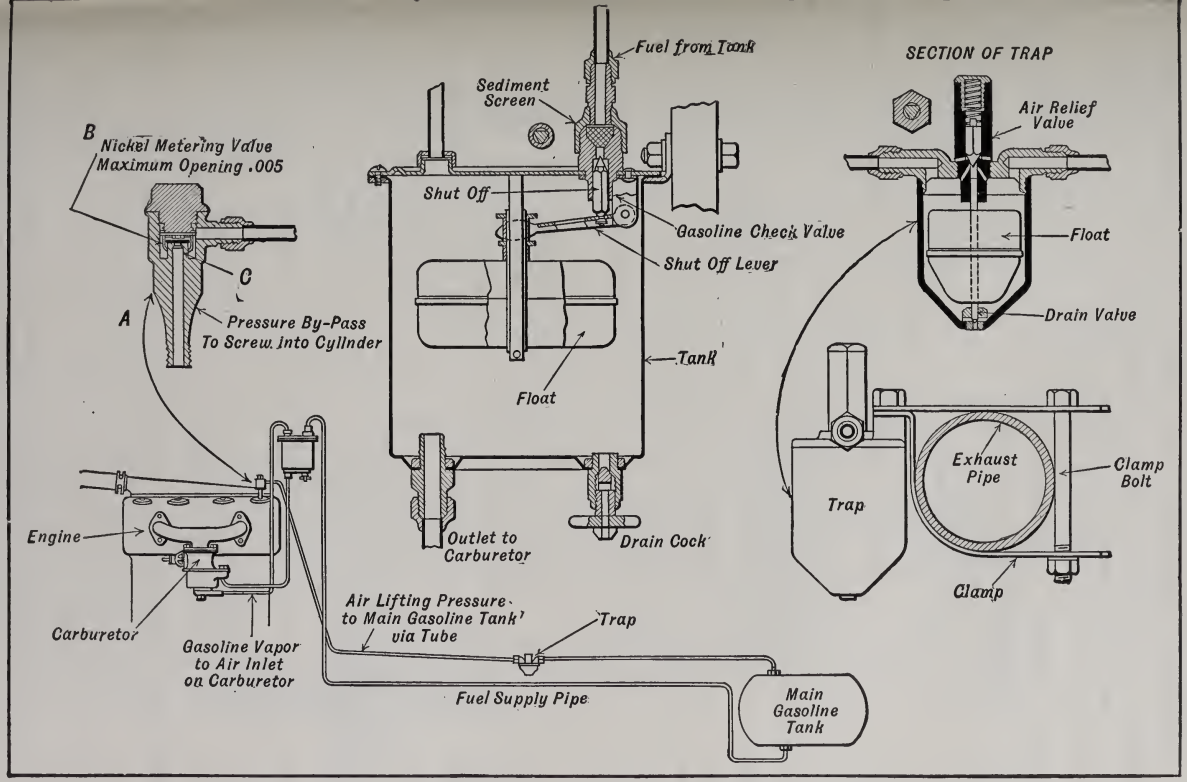


Fig. 273.—Diagrams Showing Parts of the Church Gasoline Feed System.

some very ingenious devices, of which the automatic discharge water trap is foremost.

As part of the products of combustion (which are used to furnish pressure in the main tanks) is water, it is necessary to catch this before it can reach the fuel container. Therefore a trap is placed in the pressure line, the details of this being fully made clear in the sectional drawing. However, a trap of this sort needs to be emptied when a sufficient amount of water has collected, and since the driver might neglect to perform this operation it is made automatic. The trap chamber contains a float which controls a needle valve at the bottom, and when a sufficient amount of water has collected, the float lifts the valve, allowing the water to escape. The water collecting in cold weather is liable to freeze, and if it does so the float cannot act, and the whole trap may get filled with ice. To prevent this the trap is provided with clips that attach it to the exhaust pipe, where it is kept well above freezing temperature. The pressure release valve is combined with the trap assembly, and the warmth is beneficial to this also, as it prevents the accumulation of gummy oil as might happen with an over-lubricated engine. In the section of the trap the water valve is seen at the bottom and the pressure release valve at the top of the chamber.

The supplementary fuel tank which supplies the carburetor by gravity, is also shown in the cut. Fuel enters at the top and the supply is cut off when the float rises enough to close the valve in the cover. Immediately back of this valve there is a screen for removing impurities from the gasoline. To allow the gravity feed it is necessary that there be an opening at the top of the tank to admit atmospheric pressure, and through this opening a certain amount of gasoline vapor might escape, thus causing waste. To prevent this the top opening is connected to a copper pipe that is carried down to the air opening of the carburetor, and of course the vapor is drawn into the engine and burned. A special by-pass fitting is screwed into the combustion head of one of the cylinders having a special check valve arrangement inside that has a very limited lift, the maximum opening being .005 inch (five thousandths of an inch). This allows a minute portion of each explosion in that cylinder to pass to the fuel tank and produce pressure to lift the fuel.

Action of Carter Diaphragm Pump.—The Carter system of fuel feed shown at Fig. 274 is applicable to any automobile and is a positive pumping system operating without regard to the depression in the intake manifold and also making no use of exhaust pressure. Its essential feature is a diaphragm something like the vibrating

diaphragm of an electric horn. This diaphragm is contained in a case and on one side of it there is a spring which normally keeps it pushed back against the opposite side of the case. Here there is a small hole in which a little plunger rests, and behind this plunger is a connection for a copper pipe, of which the other end is taken to one of the cylinders of the engine, usually being fitted to a union in a

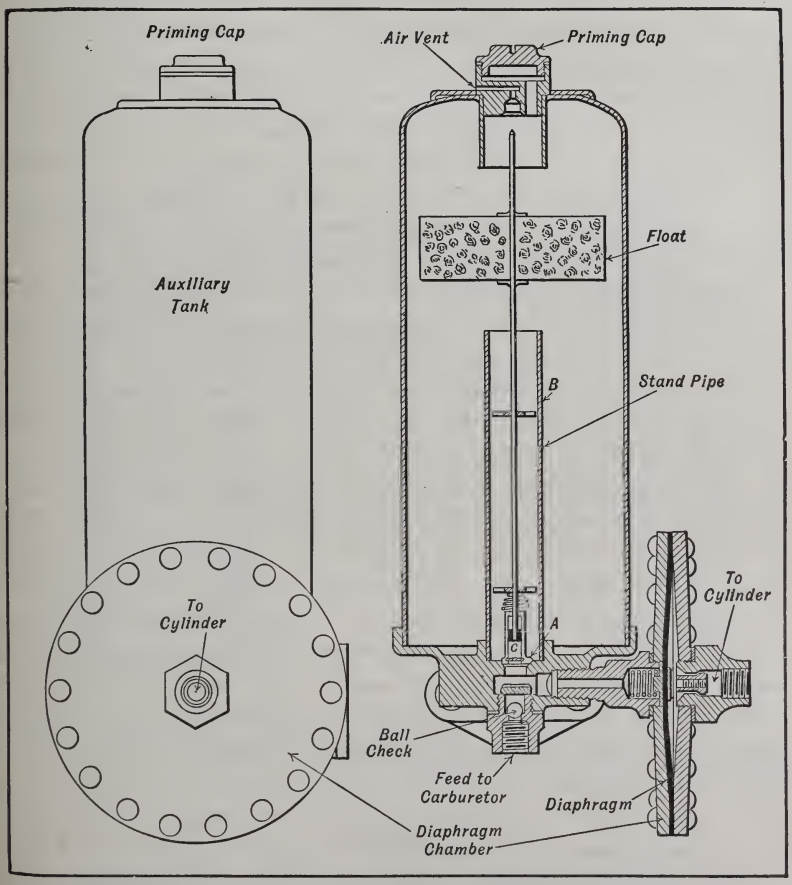


Fig. 274.—Sectional View of Carter Diaphragm Fuel Pump.

valve cap or some similar convenient place. The description which follows is taken from the *Automobile:*

"On the compression stroke the air in the pipe is compressed in proportion with that in the cylinder. This moves a little plunger and presses the diaphragm across its case against the spring. When it is pressed as far as it will go the little plunger comes against a seat in

the nipple so that when the explosion follows the compression it merely holds the plunger more tightly on its seat and does not transfer any more pressure to the diaphragm. As soon as the pressure drops in the cylinder on the exhaust or suction stroke the spring drives the diaphragm back again to its original position. Thus, during each cycle in the cylinder to which the diaphragm is attached, it makes one complete oscillation. The side of the diaphragm case furthest from the engine is connected by a non-return valve to a long pipe and the gasoline tank. It is also connected with the small tank by which the carburetor is fed. As the spring pushes the diaphragm back, when the cylinder pressure falls it sucks in fuel from the main tank, then on the next compression stroke this fuel is driven upwards into the supplementary tank, passing another non-return valve as it goes. It is by means of this second non-return valve that the pumping is caused to cease when the supplementary tank is full.

Referring to the illustration, Fig. 274, the valve being shown at A, it will be seen that it is a mushroom type and on the compression stroke of the diaphragm the fuel is forced upwards until it entirely fills the vertical tube B and flows out over the top into the tank. When the level in the tank lifts the float the stem of the latter raises the little plunger C, which is inside the mushroom valve. Thus, at the top of its travel the float lifts the mushroom valve off its seat. As soon as this happens the diaphragm, instead of sucking fuel from the main tank, merely draws it from the supplementary one and pumps it back again. To start the tank, originally when it is first fitted the priming cap at the top of the tank is unscrewed and the gasoline poured in. Once the lower part of the tank is filled it will require no further attention. A special claim made for the Carter system is that the fuel level remains very constant. Less than one-eighth inch of movement on the float will make all the difference between the mushroom valve being closed or open, and as this leaves its seat the pump is instantly stopped and as instantly started when it once more returns to its normal position.

Early Vaporizer Forms.—The early types of carbureting devices were very crude and cumbersome, and the mixture of gasoline vapor and air was accomplished in three ways. The air stream was passed over the surface of the liquid itself, through loosely placed absorbent material saturated with liquid, or directly through the fuel. The first type is known as the surface carburetor and is now practically obsolete. The second form is called the "wick" carburetor because the air stream was passed over or through saturated wicking. The third form was known as a "bubbling" carburetor. The illustrations at

Fig. 275 show the principles of operation of two of the earliest forms of carbureting devices that were applied to change liquid gasoline into an explosive vapor. That shown at A consisted of a large cylinder divided into three parts by sheet metal partitions. The upper one was utilized as a fuel compartment, and this was joined to the main tank by suitable piping. The center compartment was gas storage space, and was divided from the bottom chamber by two perforated baffle plates. The lower portion of the cylinder was filled with wicking. This wicking was kept saturated with gasoline supplied from the uppermost compartment through a pipe which directed the stream of

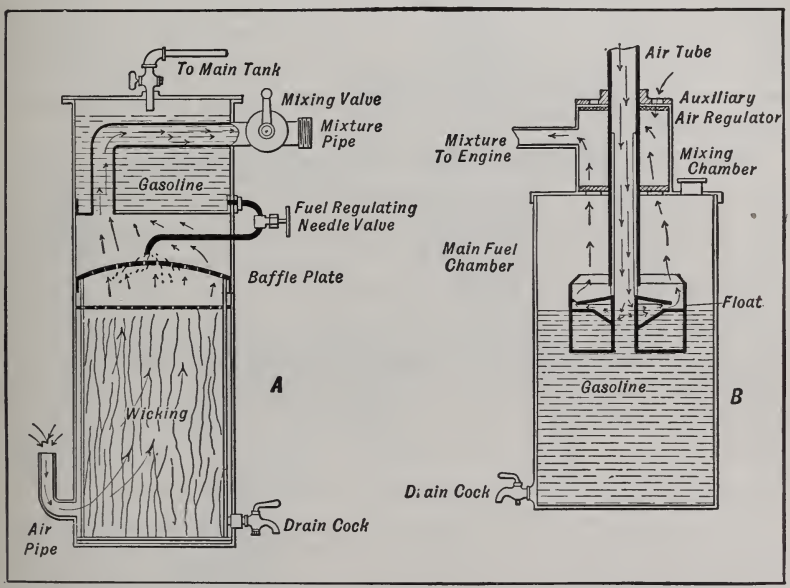


Fig. 275.—First Forms of Gasoline Vaporizers. A—An Early Wick Carburetor. B—Type in which Air is Drawn Through Fuel to Charge it with Explosive Vapor.

liquid against the center of the top baffle plate. As this member was provided with a large number of holes the gasoline was divided into a number of fine streams and the entire mass of wicking was saturated.

When the piston of the motor went down on its suction stroke air was drawn in through the air pipe at the bottom of the vaporizing device and into the center compartment or gas chamber through the wicking. In passing through this saturated material the air became charged with gasoline vapor and the resulting gas was supplied to the cylinder through the mixture pipe. This method of vaporizing the gasoline produced mixtures extremely rich in fuel and in order to

burn these successfully, a simple form of valve which permitted a certain amount of pure air to enter the cylinder and dilute the rich charge was provided in the mixture pipe.

The carburetor shown at B is known as the "filtering" or "bubbling" type. This consists of two chambers: one to hold the fuel, the other utilized as a gas storage or mixing chamber. A telescopic air pipe is needed, one portion fixed to the tank, the other, or sliding member, is carried by a float which maintains a certain definite distance between a deflector plate on the pipe and the surface of the liquid. The air enters through the air tube at the top, passes down under the surface of the gasoline, and is saturated with fuel particles. The rich gas flows into the mixing chamber through screens of wire gauze and after mixing with air entering through the auxiliary air regulator, the gas passes from the mixing chamber to the engine cylinder through suitable piping.

Spraying Carburetors.—While these primitive forms gave fairly good results with the early slow-speed engines and the high grade, or very volatile, gasoline which was first used for fuel, they would be entirely unsuitable for present forms of engines because they would not carburate the lower grades of gasoline which are used to-day, and would not supply the modern high-speed engines with gas of the proper consistency fast enough even if they did not have to use very volatile gasoline. The form of carburetor used at the present time operates on a different principle. These devices are known as "spraying carburetors." The fuel is reduced to a spray by the suction effect of the entering air stream drawing it through a fine opening.

The advantage of this construction is that a more thorough amalgamation of the gasoline and air particles is obtained. With the earlier types previously considered the air would combine with only the more volatile elements, leaving the heavier constituents in the tank. As the fuel became stale it was difficult to vaporize it, and it had to be drained off and fresh fuel provided before the proper mixture would be produced. It will be evident that when the fuel is sprayed into the air stream, all the fuel will be used up and the heavier portions of the gasoline will be taken into the cylinder and vaporized just as well as the more volatile vapors.

The simplest form of spray carburetor is that shown at Fig. 276. In this the gasoline opening through which the fuel is sprayed into the entering air stream is closed by the spring-controlled mushroom valve which regulates the main air opening as well. When the engine draws in a charge of air it unseats the valve and at the same time the air flowing around it is saturated with gasoline particles through the gaso-

line opening. The mixture thus formed goes to the engine through the mixture passage. Two methods of varying the fuel proportions are provided. One of these consists of a needle valve to regulate the amount of gasoline, the other is a knurled screw which controls the amount of air by limiting the lift of the jump valve.

While practically all modern motor cars use spraying carburetors having automatic fuel regulation, in rare cases one sometimes finds

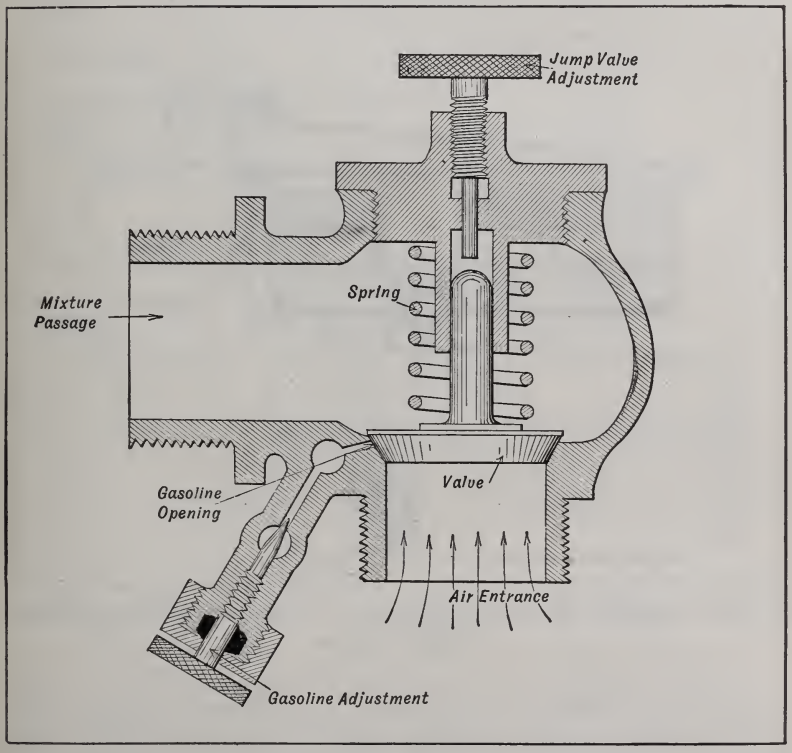


Fig. 276.—Marine Type Mixing Valve, by which Gasoline is Sprayed into Air Screen Through Small Opening in Air Valve Seat.

the earlier forms of carburetors used in improved and modified types. The wick carburetor, shown at Fig. 277, is that used on some Lanchester (English cars). In this the gasoline is taken from the main tank by means of a pump and forced up through the delivery pipe into a compartment in which a number of wicks are placed. The fuel is maintained to a certain level by means of an overflow pipe which returns any excess to the tank. The entering air stream which is taken from a jacket around the exhaust pipe and thoroughly heated passes through

the wicks and becomes thoroughly saturated with gasoline. It is well mixed with the liquid vapors by passing through screens which separate the wick compartment from the mixture pipes. An auxiliary air pipe and valve are provided to dilute the rich gas before it passes into the motor through the usual form of inlet manifold.

This is the only instance at the present time to the writer's knowledge where the earlier forms of carburetors have survived. One still finds many vaporizer valves, as shown at Fig. 276, used

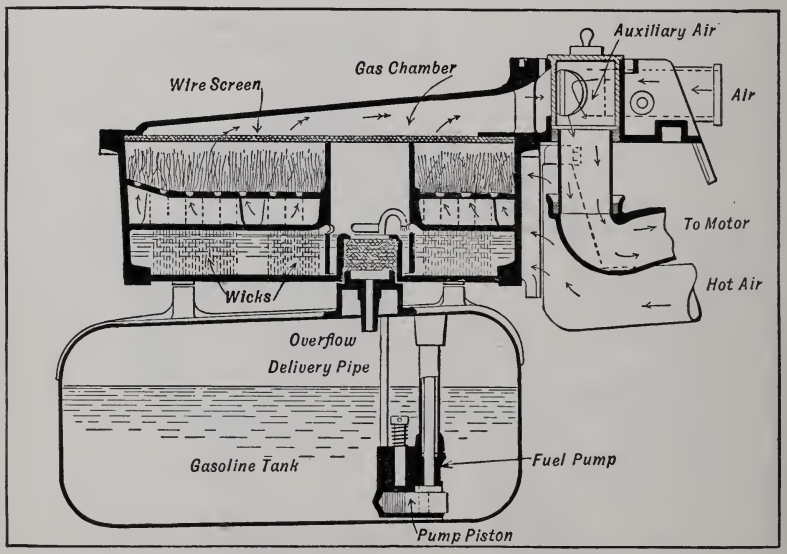


Fig. 277.—Lanchester Wick Feed Carburetor. A Relatively Modern Adaptation of Earlier Forms.

in marine installations, though there is a growing tendency at the present time to use more modern spraying carburetors in this field as well.

Development of Float-Feed Carburetor.—The modern form of spraying carburetor is provided with two chambers, one a mixing chamber through which the air stream passes and mixes with a gasoline spray, the other a float chamber in which a constant level of fuel is maintained by simple mechanism. A jet or standpipe is used in the mixing chamber to spray the fuel through and the object of the float is to maintain the fuel level to such a point that it will not overflow the jet when the motor is not drawing in a charge of gas. With the simple forms of generator valve in which the gasoline opening is controlled by the air valve, a leak anywhere in either valve or valve seat

will allow the gasoline to flow continuously whether the engine is drawing in a charge or not. The liquid fuel collects around the air opening, and when the engine inspires a charge it is saturated with gasoline globules and is excessively rich. With a float-feed construction, which maintains a constant level of gasoline at the right height in the standpipe, liquid fuel will only be supplied when drawn out of the jet by the suction effect of the entering air stream.

Maybach's Early Design.—The first form of spraying carburetor ever applied successfully was evolved by Maybach for use on one of the earliest Daimler engines. The general principles of operation of this pioneer float-feed carburetor are shown at Fig. 278-A. The mixing chamber and valve chamber were one and the standpipe or jet protruded into the mixing chamber. It was connected to the float compartment by a pipe. The fuel from the tank entered the top of the float compartment and the opening was closed by a needle valve carried on top of a hollow metal float. When the level of gasoline in the float chamber was lowered the float would fall and the needle valve uncover the opening. This would permit the gasoline from the tank to flow into the float chamber, and as the chamber filled the float would rise until the proper level had been reached, under which conditions the float would shut off the gasoline opening. On every suction stroke of the engine the inlet valve, which was an automatic type, would leave its seat and a stream of air would be drawn through the air opening and around the standpipe or jet. This would cause the gasoline to spray out of the tube and mix with the entering air stream.

The form shown at B was a modification of Maybach's simple device and was first used on the Phœnix-Daimler engines. Several improvements are noted in this device. First, the carburetor was made one unit by casting the float and mixing chambers together instead of making them separate and joining them by a pipe, as shown at A. The float construction was improved and the gasoline shut-off valve was operated through leverage instead of being directly fastened to the float. The spray nozzle was surrounded by a choke tube which concentrated the air stream around it and made for more rapid air flow at low engine speeds. A conical piece was placed over the jet to break up the entering spray into a mist and insure more intimate admixture of air and gasoline. The air opening was provided with an air cone which had a shutter controlling the opening so that the amount of air entering could be regulated and thus vary the mixture proportions within certain limits.

The form shown at B has been further improved, and the type shown at C is representative of modern practice. In this the float

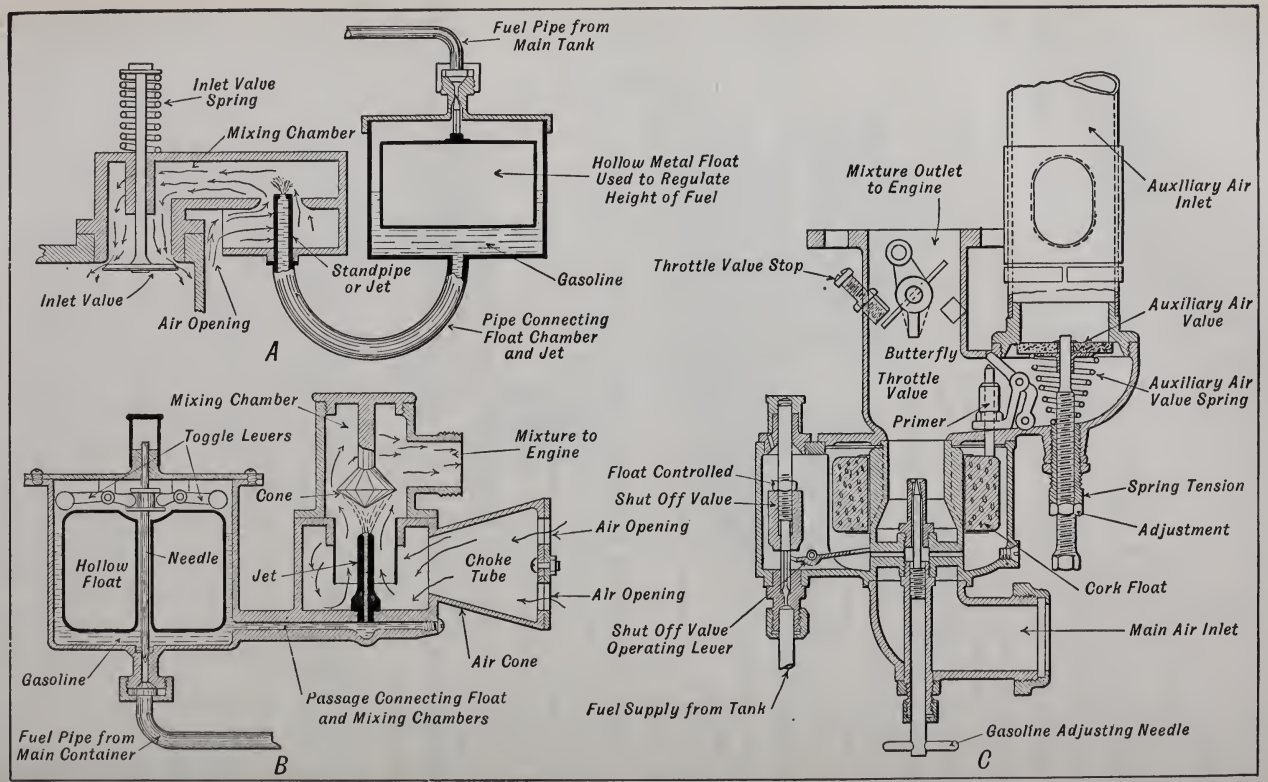


Fig. 278.—Tracing Evolution of Modern Spray Carburetor. A—Early Form Evolved by Maybach. B—Phœnix-Daimler Modification of Maybach's Principle. C—Modern Concentric Float Automatic Compensating Carburetor.

chamber and mixing chamber are concentric. A balanced float mechanism which insures steadiness of feed is used, the gasoline jet or standpipe is provided with a needle valve to vary the amount of gasoline supplied the mixture and two air openings are provided. The main air port is at the bottom of the vaporizer, while an auxiliary air inlet is provided at the side of the mixing chamber. There are two methods of controlling the mixture proportions in this form of carburetor. One may regulate the gasoline needle or adjust the auxiliary air valve. A full description of the modern types of carburetors will be given in proper sequence.

Elements of Carburetor Design.—The design of the components of modern carburetors differ largely, but most of the modern mixing devices operate on the same general principle. Certain features of design have been accepted generally, such as automatic mixture compensation by auxiliary air valves, Venturi type of mixing chamber, float and mixing chamber concentric, separate adjustment for gasoline and air, and simplicity of construction. Various carburetors have been devised of late in which auxiliary air valves are done away with and proper compensation for mixture variation due to various engine speeds is made by ingenious applications of double jets. In some manual regulation of the incoming air is again resorted to.

Automatic compensation is made necessary because a satisfactory mixture must be furnished at all engine speeds without the operator constantly varying the fuel supply or air proportions to allow for different conditions of operation produced by varying speeds. On early types of carburetors it was necessary to constantly vary the mixture proportions by working the air shutter or fuel valve from the driver's seat while the vehicle was in motion. The aim was to secure a mixture that was best adapted to the conditions of operation then present, and while a skillful driver would manipulate the adjustments in a way to deliver well-proportioned mixtures to the cylinder the average operator did not control the mixture exactly and the results obtained did not make for efficiency.

The writer has described the process of carburetion, and it is evident that the gas is supplied the cylinder by the pumping effect of the piston. The velocity of the entering gases depends upon engine speed, and as the draught diminishes it will not pick up as much fuel as when it is traveling at a higher rate. The present type of compensating carburetor provides for a sufficiently rapid flow of gas at low speed by constricting the mixing-chamber bore at the spray nozzle so that the gas speed will be sufficiently high when the engine is pumping slowly. The reduced diameter of the mixing chamber increases

the velocity of the gases because the cylinder must be filled through a smaller hole in a certain unit of time than would be the case if the bore were larger. Therefore to insure a full supply reaching the cylinder the gases must pass the top of the jet at a high rate of speed even if the piston is working slowly. As the opening is constricted not enough air will be drawn in at high speed, and it is necessary to supply it through an auxiliary opening usually controlled by some automatic form of valve. This can be adjusted to open only when the suction effect is sufficiently high to overcome the tension of the spring which holds the valve to the seat, and this increased suction effect obtains only at high speeds.

Venturi Type Mixing Chamber.—The Venturi type of mixing chamber is one which is being widely used at the present time because it has properties when properly proportioned of insuring high gas velocity at low engine speed. Special care must be taken in the proportions of the air passage, as it is necessary that the area be large enough to allow the air stream to pass through freely, yet at the same time it must be constricted to such a point that the entering air stream will pass the top of a standpipe with sufficient momentum to draw an adequate supply of gasoline from the spray nozzle. The velocity of the air stream has been variously estimated, but most authorities are agreed that it should be from 7,000 to 9,000 feet per minute to insure picking up a sufficient amount of liquid as it passes around the spray nozzle.

Concentric Float and Mixing Chambers.—If one compares the carburetors shown at Fig. 278, B and C, one will find that there may be two distinct forms. In that shown at B the mixing chamber is set to one side of the float compartment, while at C the mixing chamber is concentric with the compartment in which the float is carried. The reason for putting the mixing chamber in the center of the float is to insure a constant level of fuel in the standpipe regardless of the way the carburetor is tipped. With a mixing device having two chambers, as shown at B, the level in the float compartment and the spray nozzle will be at the same height only when the carburetor is on the level. In ascending or descending hills either the float chamber will be higher than the mixing chamber or the reverse conditions obtain.

At such times that the mixing chamber is higher than the float container the level of fuel in the jet will be lower than it should be. If, at the other hand, the float chamber is higher than the jet the fuel will overflow and the mixture will be excessively rich. With a carburetor constructed as depicted at C, the spray nozzle is at a central point and the level will not vary appreciably if the carburetor

tilts one way or the other. This insures an even gas supply which in turn produces uniform motor action. The engine is not alternately starved or flooded, and the mixture proportions remain practically the same.

In most cases carburetor designers believe it desirable to incorporate separate adjustments for gasoline and air, in order that all temperature variations be compensated for. When an automatic air valve is provided and the spray-nozzle opening is controlled by a needle valve it is possible to obtain a wide variety of mixtures. With this form of construction two adjustments are provided which may be used separately or worked in unison as conditions demand. Gas mixtures having proportions best adapted for low and medium speeds are usually obtained by regulating the gasoline valve, while the best high-speed adjustments are secured by altering the tension of the valve spring which regulates the air supply by restricting or increasing the lift of the air valve.

Mixing Chamber Forms Commonly Used.—One of the most important points to be considered is to provide a mixing chamber of such form that a direct passage will be provided for the charge to enter the cylinder. Any sharp angles or turns are apt to cause trouble because the gas speed will be retarded and an opportunity afforded for the condensation of fuel on sharp corners. A number of representative

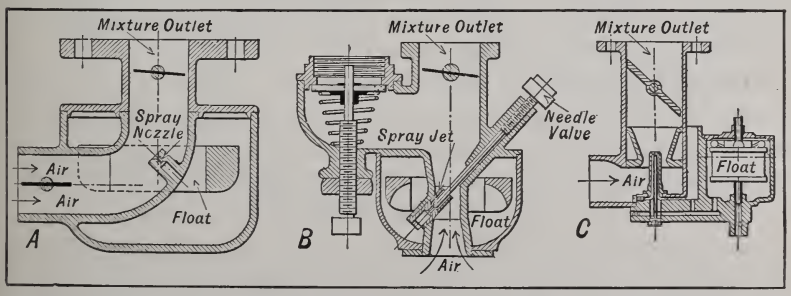


Fig. 279.—Showing Forms of Mixing Chambers and Spray Nozzle Location in Simple Carburetors.

forms of mixing chambers are shown at Fig. 279. That at A has been very popular and the gradual curve permits the gases to flow easily. The spray nozzle is inserted at the point where the gases turn and there is no possibility of the entering air stream passing the gasoline supply pipe without picking up some fuel.

Mixing Chamber Forms.—The form of mixing chamber shown at B is a preferred form, as the passage for the gas is direct to the engine

pipes and there is no opportunity for the collection of liquids at any sharp corner. It is apparent that the diameter of the air-pipe bore is less around the spray nozzle than it is at the point above the gasoline supply jet. This gives a Venturi effect, which is known to produce automatic mixture variations. The Venturi tube construction is valuable because it insures high gas velocity at low engine speed.

The theory of Venturi tube or constricted air passage can be easily understood if one considers the basic facts properly. When any fluid, either liquid or gaseous, passes through a tube the volume passing will be the same at all points if the bore of the pipe is constant. If gas flows through a pipe having a variable section the quantity of gas or liquid flowing through the tube remains the same, but the velocity is inversely proportional to the area of the section at different points. Therefore, if the air passage is contracted at a certain point the speed of the air stream will be greater where the area of the opening is less. As will be evident the air passage is usually constricted at the spray nozzle for reasons previously outlined.

In the form of mixing chamber shown at A no auxiliary air device is provided, but in that depicted at B an auxiliary air valve is provided at one side of the mixing chamber. The form of air passage outlined at C is not as satisfactory as the simpler forms, which provide for more direct gas flow. In this the entering air is forced to turn a sharp corner, and the resistance this offers will seriously retard the speed of the entering air stream. The form of mixing chamber outlined at B is that commonly used.

Problem of Float-Bowl Design.—Next in importance to the mixing chamber form is the problem of float-chamber design, and the mechanism which regulates the height of the fuel in the spray nozzle should be as simple and as positive in action as possible. The float and needle should be so arranged that the gasoline will be regulated in such a manner that as soon as the proper level is reached the gasoline orifice should be shut off positively. If the mechanism is made simple it is not so likely to get out of order as when more complicated methods of valve operation are provided.

The floats are made in two forms. They may be a hollow sheet-metal construction, or cork. When a hollow metal float is employed care is taken to insure that it will be absolutely tight and that fuel cannot enter its interior. Cork floats are usually coated with a shellac varnish to minimize the danger of the cork absorbing fuel. The metal float is more expensive than the cork, and if it leaks it will fill with liquid and cause the carburetor to flood. The cork float may absorb sufficient fuel to change its weight enough so that the gasoline level

will be too high. It is also contended that particles may become detached from the cork float and enter the passage leading from the float compartment to the spray nozzle and clogging it or passing on further and constricting the bore of the jet.

The simplest form of float mechanism is depicted at Fig. 280, A. Here the float is pivoted at one end and carries the needle at the other.

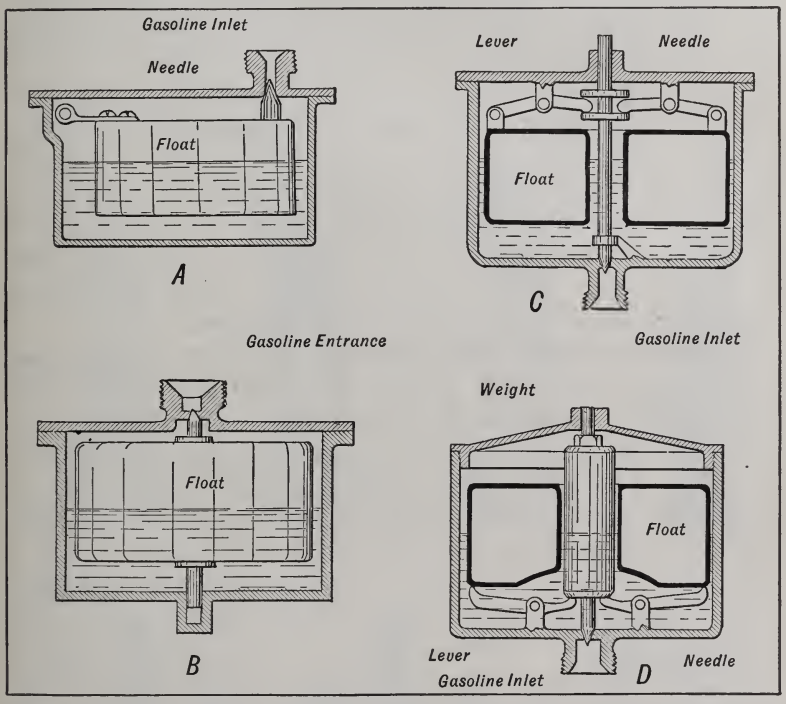


Fig. 280.—Types of Float Chambers in Common Use, Defining Various Methods of Controlling Fuel Supply Valve.

The needle closes the gasoline orifice when the level of fuel is at the right height. As soon as the level falls the float drops and the needle valve leaves its seat and permits gasoline to enter. When sufficient has been admitted to restore the level to the proper point the float rises and the gasoline opening is stopped up by the needle. The form shown at B is a modification of the simpler construction outlined at A. In this the fuel-supply needle is carried at the center of the circular float instead of at one end. The disadvantage of these simple forms in which the gasoline enters at the top of the float chamber is that the weight of the entering fuel which falls on the float's surface prevents the float from rising as quickly as it should, and the fuel

supply is not cut off until the level is somewhat higher than it should be.

The form shown at C utilizes a hollow metal float which operates the shut-off needle through toggle linkage. As the float falls the levers reverse the movement and the needle valve is lifted, this admitting fuel through the hole at the bottom of the float chamber. A balanced float construction is outlined at D. The needle-valve stem carries a weight which tends to keep it seated in a positive manner, and with this form of weighted valve one is not apt to have the erratic fuel supply that might be caused by vibration of power plant or road on the simpler forms depicted at A and B. The float is not balanced by the weight unless the level is at the proper height, and when the fuel level falls the weight of the float which is increased in value by the system of leverage raises the needle and weight. As in the previous case, shown at C, the function of the leverage is to reverse the direction of movement. That is, the needle valve is raised from its seat when the float falls and is seated when the float rises.

Gasoline Spray Nozzle Form Important.—At Fig. 281 various forms of simple spray nozzles and auxiliary air valves are depicted. The simplest form is presented at A, this consisting of a standpipe having a single small hole at the top through which the fuel is discharged in a solid stream in much the same manner as water through a hose. On some foreign carburetors the standpipe is provided with a tapered plug, having series of grooves cut in its surface for the passage of fuel, as shown at B. The advantage of this construction is that the gasoline is atomized and is discharged in a number of fine streams instead of the coarser single stream. When the gasoline is discharged in a form of a mist it produces a much better mixture than when ejected in a single stream which must be broken up and divided into fine particles before it will form a homogeneous mixture. The disadvantage of the grooved plug is that the fine passages are apt to become clogged from very small particles of foreign matter in the fuel. In fact, pieces of dirt which would pass out with the stream of gasoline from the nozzle shown at A will clog the fine passages of the plug shown at B.

The amount of fuel delivered through the simple standpipe is regulated by the size of the hole, while the quantities of liquid sprayed from the nozzle shown at B can be varied to obtain different mixtures by changing the number of grooves in the plug seat. The spray nozzles illustrated at C and D are forms in which the gasoline supply is regulated by a needle valve, that at C using an overhead valve, while that at D has the needle valve adjusted from the bottom. The former construction is preferred when it is possible to apply it because it

has a tendency to divide the stream of fuel into a spray or mist which is more easily vaporized.

The spray nozzles shown at C and D are used more often than those depicted at A and B because of the ease with which the gasoline proportions may be varied by screwing the needle in or out of its seat, thus reducing the size of the opening when one desires to diminish the amount of fuel, or screwing it out and allowing more fuel to pass when richer mixtures are desired.

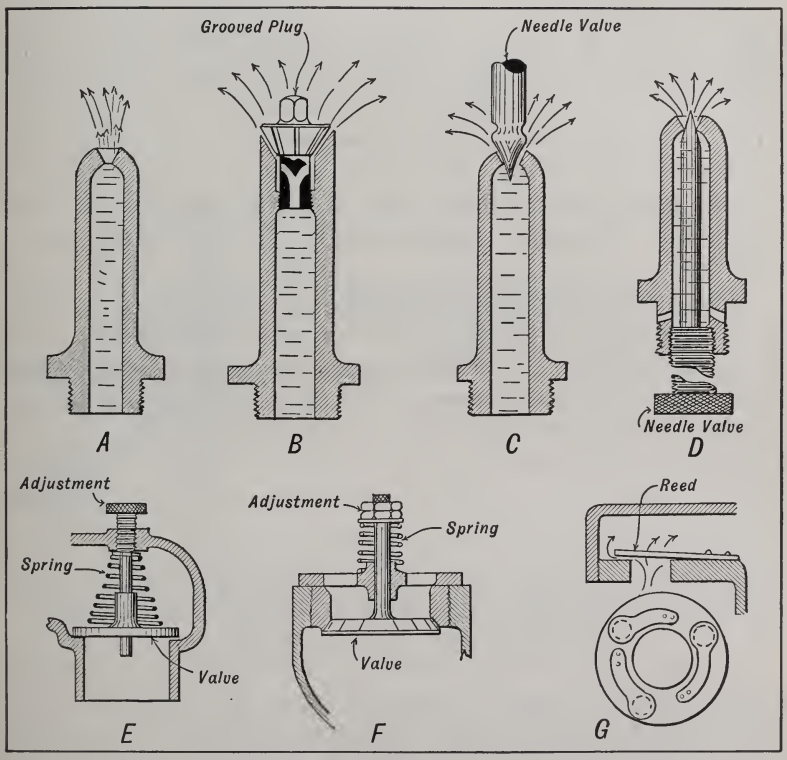


Fig. 281.—Spray Nozzle Forms and Methods of Supplying Auxiliary Air to Modern Carburetors.

Typical Auxiliary Air Valve Forms.—Considerable difference of opinion exists in air valve construction as well, and many methods of admitting auxiliary air are used. The ordinary mushroom or poppet valves depicted at Fig. 281, E and F, are more widely applied. The former is a flat seat type kept seated by a compression spring while that at F is the ordinary form of automatic valve having a bevel seat.

The disadvantage of the poppet valve is that its action is not regular, and it is apt to chatter or vibrate rapidly if the suction is not constant.

Ball and reed valves have been applied on many forms of carburetors, and it is claimed for these that they will provide an increasing supply of air as the engine speed augments without chattering or fluctuation. When a series of openings are provided instead of one large port and each of the smaller holes is regulated by an individual reed or ball it is possible to so vary the strength of the reeds, or the weight of the ball, that the air supply will be progressive.

When poppet valves are used it is customary to make these of leather or fiber so that they will not be noisy when they seat. The method defined at G is one in which reeds are used, three being provided, so graduated in strength that one alone opens at medium speed, then the other two leave their seats progressively as the engine speed augments and the suction effect becomes greater. The various forms of spray nozzles and auxiliary valves commonly used will be further described in connection with the features of the leading types of vaporizers.

Methods of Gas-Supply Regulation.—The methods of regulating the amount of gas supplied the cylinder vary to some extent, though the general system is to introduce some form of butterfly or shutter valve in the mixture pipe between the mixing chamber and the valve chamber. These valves are operated by rod connection to hand lever placed on top of the steering post or accelerator pedal on foot boards, and the amount of gas passing from the carburetor into the cylinder depends upon the amount of opening provided by the valve. When it is fully opened the gas may fill the cylinders easily, though as its position changes the area of the mixture passage is gradually decreased and the amount of gas passing through reduced.

In some cases the hand throttle is supplemented by an automatic governor which is designed to shut off the gas supply should the engine speed increase beyond a certain predetermined point. A carburetor fitted with both hand-operated throttle and shutter actuated by a governor from the engine is shown at Fig. 282. The hand throttle is a simple disk valve attached to a stem passing through the mixture pipe at a central point. When in the position shown the passage is fully opened. The governor throttle is a shutter valve placed in a special pocket above the hand-operated disk. It is worked by lever and rod connection by a centrifugal governor.

The governor consists of two weights pivoted in such a manner that they lie close to the governor shaft when engine speeds are low. As the speed of the governor shaft increases the weights tend to fly out

from center due to centrifugal force, and as they are thrown out they pull a sliding collar back against a spring. The sliding collar actuates a lever which closes the governor-throttle valve by the rod connecting it to the governor. The governor is driven from the engine by some form of driving gear, or it may be located on the cam shaft. The amount the weights fly out is regulated by the spring, and as its tension is increased it will take a higher engine speed to throw the weights out sufficiently to close the governor throttle. When the spring is weakened the governor weights fly out at lower speeds and the governor throttle is closed sooner.

Such a device is useful in preventing racing of the engine under certain conditions. For instance, if the car was climbing a hill on one of the lower gear ratios which would permit the engine to run quite

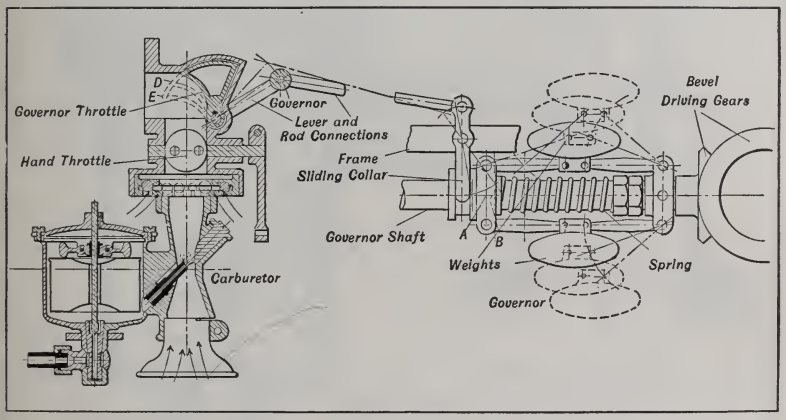


Fig. 282.—Method of Regulating Fuel Mixture Supplied to the Cylinders by Means of a Centrifugal Governor which Automatically Reduces the Quantity when Engine Speed Exceeds a Certain Predetermined Limit.

fast and the clutch pedal was depressed so that the drive would be momentarily interrupted, the tendency of the engine, thus relieved of its load, would be to run at an extremely high rate of speed. If the operator was fully occupied in steering and shifting gears he could not regulate the hand-throttle valve and the result would be that the engine would run dangerously fast. When a governor is fitted, as soon as the engine speed tends to become excessive, the weights fly out and the supply of gas is diminished automatically.

A governor is also useful on commercial cars where it is desired to keep the vehicle speed within certain limits. As speed is directly dependent upon the number of engine revolutions, the governor can

be set in such a way that the engine will run up to a certain point and no faster. Governors are not so widely used at the present time as they were in the past, owing to improvements in carburetor control devices. All governors do not operate on the centrifugal principle. Some are hydraulic, others are worked by compressed air. The fly ball governor described is the most common, and it shows clearly the principle of action and utility of such devices. Governors are sometimes operated by a flexible shaft from a road wheel. A compact form of governor of this type is shown at Fig. 283.

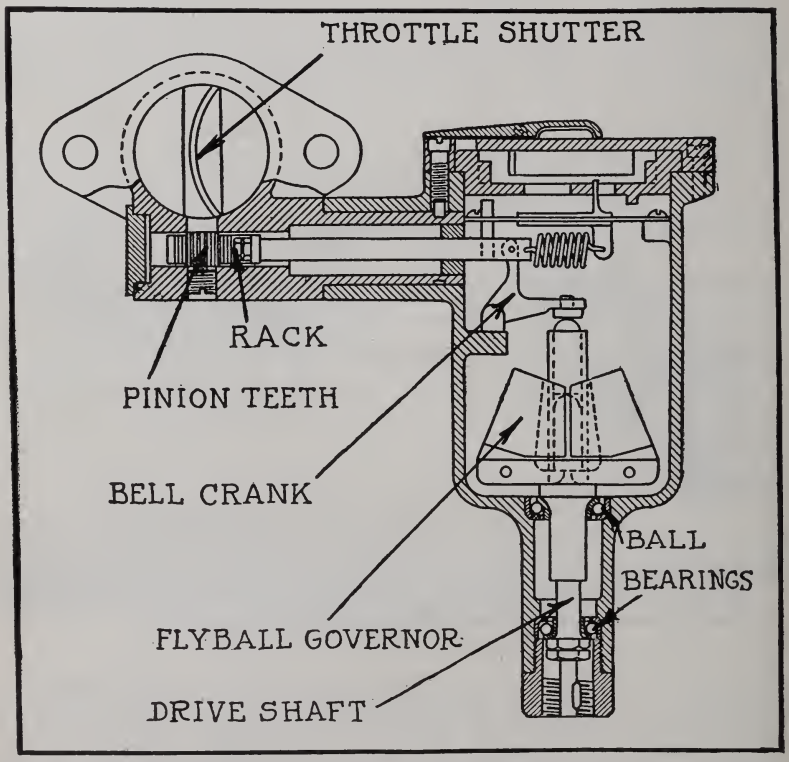


Fig. 283.—Centrifugal Governor Used to Cut Down Gas Supply Operated by Flexible Shaft.

Hydraulic Governor.—A hydraulic governor is used in some models of the Packard truck, this consisting of a chamber carrying a diaphragm against which the stream of cooling water from the circulating pump of the cooling system impinges. When the speed of the engine becomes too great the flow of cooling water is more rapid and

the pressure against the diaphragm will operate linkage to close the throttle and slow down the engine.

Kramer Governor.—Controlling the speed of the motor by utilizing the velocity of the inrushing gases is the feature of a new governor known as the Kramer. As is shown in Fig. 284, as the speed of the motor grows higher, the increasing velocity of the gases past the floating disk in the intake passage raises this disk and closes the damper placed below it. Thus when the speed of the gases reaches a predetermined amount the butterfly begins to close and the speed drops. These two members are contained in a suitable casing which is inserted between the carbureter and intake manifold. Since it is

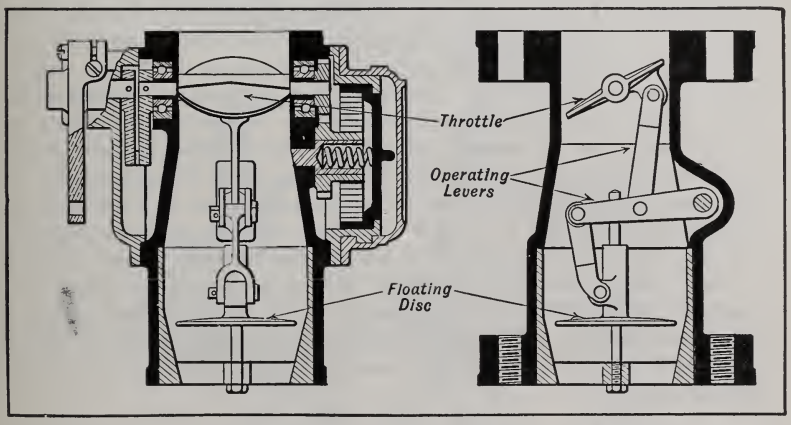


Fig. 284.—Sections Through Kramer Engine Governor, Showing Operating Disk Controlled by the Speed of the Incoming Gases.

compact and self-contained, it may be easily attached to any motor. There are no revolving parts and little to get out of order or wear. It is stated that all governors are thoroughly tested and set for a maximum speed of about 1,000 revolutions per minute. The governor may be simply adjusted to any speed desired. This gives a direct control of the piston speed of the motor, as the speed of the intake gases is a direct function of the piston speed. This is, of course, within the limits of ordinary running, where the volumetric efficiency of the motor does not vary sufficiently to alter the proportions to an appreciable extent. Ball bearings of the single row type are used on the shaft of the butterfly valve and a clock spring regulates its action. The throttle shaft is ground true to 1-1000 inch. Hardened steel bushings are used in the links.

CHAPTER VI

Construction of Modern Carburetors—Schebler Model E—New Schebler Metering Pin Type—Kingston—Ford Carburetor—Holley Carburetors—Mercedes—Stromberg One-Nozzle Type—Compound Nozzle Zenith Carburetor—Duplex Carburetor—Stromberg Type "M.B." Carburetor—Claudel—Stewart Metering Pin Type—Scott-Robinson-Rayfield Mixed Type—Multiple Nozzle Vaporizers—Stromberg Two-Jet Type—Novel F. I. A. T. Design—Sauer Economy—Tillotson Two-Jet Type—Ball and Ball Two-Stage Carburetor—Marvel-Buick Carburetor—Krice Annular Spray Carburetor—Master Multiple Jet Form—Utility of Gasoline Strainers—How Kerosene May be Utilized—Holley Kerosene Carburetors—Compound Manifolds—Supplying Kerosene by Direct Injection—Vaporizer Using Water Spray—Bi-fuel Carburetors—Bennett Kerosene Carburetor—Good Kerosene Vaporizer—Partial Combustion Type Carburetor—Fuel Mixing Valve—A Camphor Vaporizer—Pre-heating Fuel—Air Cleaner—Primers for Easy Starting—Vapor Humidifiers—Fuel Economizing Devices—How High Altitude Affects Power—The Diesel System—Intake Manifold Construction—Compensating for Varying Atmospheric Conditions—Disposition of Exhaust and Gases—Exhaust Silencers—Ejector Type Exhaust Manifold—Utility of Cut-out Valve Explained—Multiple Exhaust System Advantages.

Construction of Modern Carburetors.—As the gasoline used in foreign countries is an imported product and is therefore more costly than it is in the United States, the foreign carburetors have been developed with a main object in view of securing maximum fuel efficiency, and minimum fuel consumption is sought rather than greater flexibility. In this country conditions have been such that the economical aspect has been somewhat neglected because at the present time the cost of fuel is really one of the lesser items to be considered in operating the average pleasure car. Economy in fuel consumption is just beginning to receive serious consideration in the United States owing to the rising cost of fuel. Vehicle engines using considerable fuel, such as truck and tractor types, are being developed with a view of using distillate or kerosene. The varying conditions to be met in the effort made to secure power, gasoline economy, and flexibility have resulted in a wide variety of instruments. It is apparent that these must operate on definite principles common to all,

but at the same time considerable difference of opinion exists among designers and details of construction differ in almost all forms.

Schebler Carburetor.—The Schebler Model "E" carburetor is a concentric float type, and is one of the simplest and most satisfactory of the many forms that have received wide application. The primary air inlet is through an air bend at the bottom of the carburetor, as shown at Fig. 285, and an auxiliary air inlet controlled by the usual

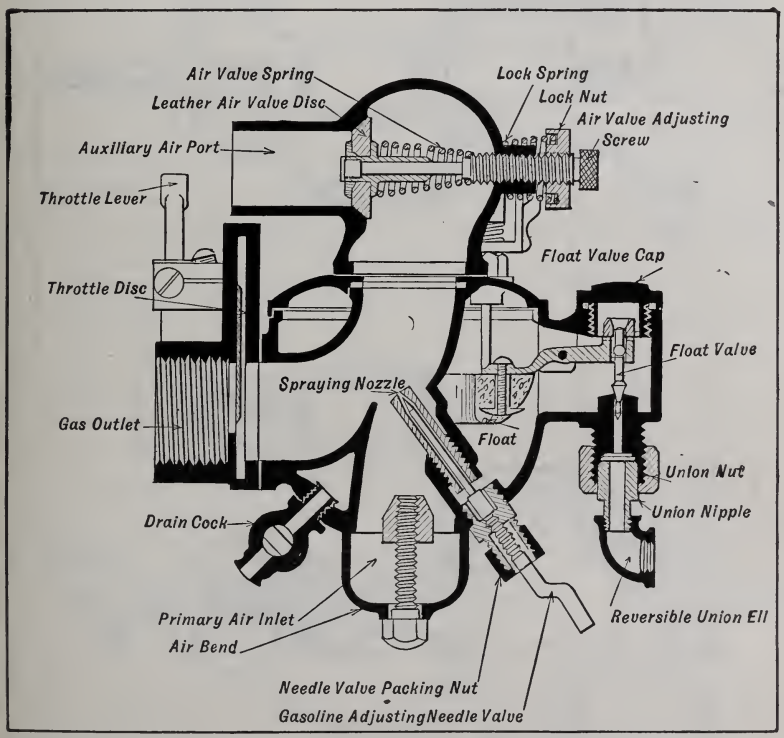


Fig. 285.—Schebler Carburetor Construction Outlined. This is One of the Simplest Forms that Has Been Extensively Used.

form of poppet valve is provided at the top of the mixing chamber. The spraying nozzle is inserted at an angle and the amount of fuel sprayed into the mixture is regulated by a gasoline-adjusting needle. The gasoline shut-off valve in the float chamber is operated through a lever fulcrumed at its central point, the float being attached at one end while the float-control valve is carried at the other. An upward movement of the float closes the valve, which is opened as the float falls. The gasoline needle is depended upon for varying the mixture

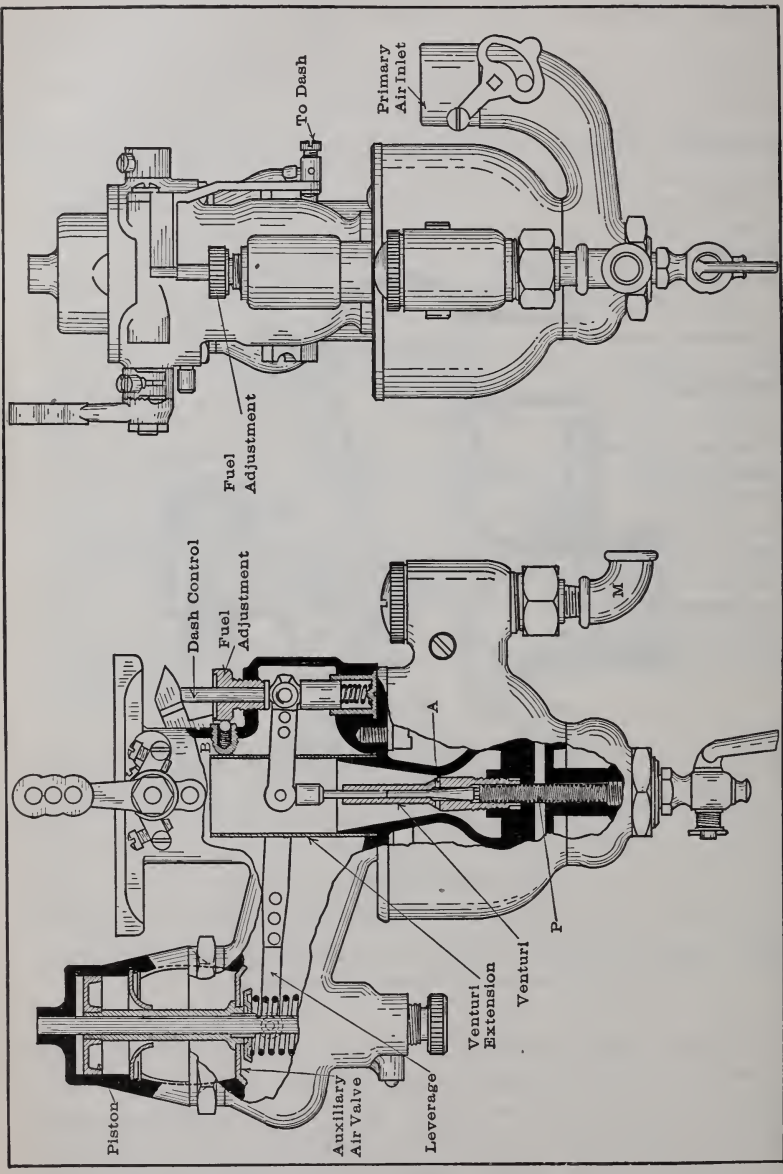


Fig. 286.—New Model of Schebler Carburetor with Metering Valve and Extended Venturi. Note Mechanical Connection Between Air Valve and Fuel Regulating Needle.

for low speed, while the auxiliary air valve takes care of high-speed mixture adjustments.

New Schebler Carburetor.—A new Schebler carburetor, which has been widely fitted to 1916 and 1917 cars, is shown at Fig. 286. It will be noticed that a metering pin or needle valve opens the jet when the air valve opens. The long arm of a leverage is connected to the air valve, while the short arm is connected to the needle, the reduction in leverage being such that the needle valve is made to travel much less than the air valve. For setting the amount of fuel passed or the size of the jet orifice when running with the air valve closed, there is a screw which raises or lowers the fulcrum of the lever and there is also a dash control having the same effect by pushing down the fulcrum against a small spring. A long extension is given to the Venturi tube which is very narrow around the jet orifices, which are horizontal and shown at A in the drawing. Fuel enters the float chamber through the union M and the spring P holds the metering pin upward against the restraining action of the lever. The air valve may be set by an easily adjustable knurled screw shown in the drawing and fluttering of the valve is prevented by the piston dash pot carried in a chamber above the valve into which the valve stem projects. The primary air enters beneath the jet passage and there is a small throttle in the intake to increase the speed of air flow for starting purposes. The carburetor is adapted for the use of a hot-air connection to the stove around the exhaust pipe and it is recommended that such a fitting be supplied. The lever which controls the supply of air through the primary air intake is so arranged that if desired it can be connected with a linkage on the dash or steering column by means of a flexible wire.

Kingston.—The Kingston device, which is shown in section at Fig. 287, with important parts clearly depicted, is similar in principle to that previously described, inasmuch as it has a concentric float and mixing chamber and a lever-control float valve. The main air opening is through an air bend at the bottom of the carburetor, and the mixing chamber is constricted at the top of the spray nozzle to produce a Venturi tube effect. The auxiliary air ports are controlled by a series of balls of varying weight which open progressively as the motor suction increases. Fuel regulation is by an overhead needle valve, while the amount of mixture passing to the cylinders through the gas outlet is regulated by a simple throttle disk which operates on the same principle as the damper of a stove pipe. This differs from the throttle arrangement of the carburetor shown at Fig. 285, as that member is composed of a movable plate which has an up-and-

down motion instead of the oscillating motion of the damper form. The throttle of the former type is known as a "butterfly valve," while that shown at Fig. 287 is a simple shutter type. A special form of Kingston carburetor that has been used for Fords is shown at Fig. 288, in which all important parts are outlined.

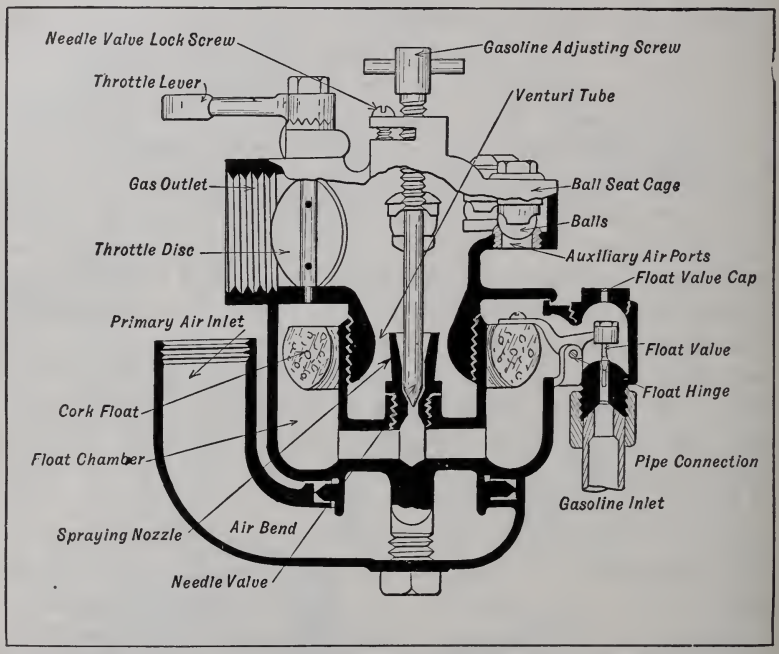


Fig. 287.—Kingston Automatic Carburetor Admits Auxiliary Air Through Ball Controlled Ports at Side of Mixing Chamber.

The Ford Gasoline Carburetor.—Owing to the popularity of the Ford automobile, which has been sold in very large numbers and which are in use in practically all parts of the world, it seems desirable to illustrate the interior construction of one type of vaporizer used on these cars. This is a "puddle" type that is exceptionally simple in construction. The gasoline is admitted to the float bowl through the usual form of gasoline supply valve regulated by a cork float, which determines the proper level of fuel in the float chamber. The mixing chamber is a peculiar form, so designed that all air entering through the main air intake must pass over the small pool of gasoline at the bottom of the mixing chamber before it can reach the engine. The amount of gasoline supplied the mixture may be varied by a regulating needle valve, and the amount of gas reaching

the cylinders is controlled in the usual manner by a butterfly throttle valve. At low engine speeds, as when starting, the air cannot fail to pick up gasoline vapor no matter how slow it passes over the top of the spray nozzle. At higher speeds, when the mixture would be too rich, due to the high velocity of the air flow, a number of auxiliary air valves of the ball type open progressively as the suction increases and admits more air to the mixture to dilute it. The only adjustment possible on this device is by the needle valve, which may be locked in position when the proper adjustment has been reached by a suitable locking screw. The general details of construction may be clearly grasped by reference to illustration at Fig. 288.

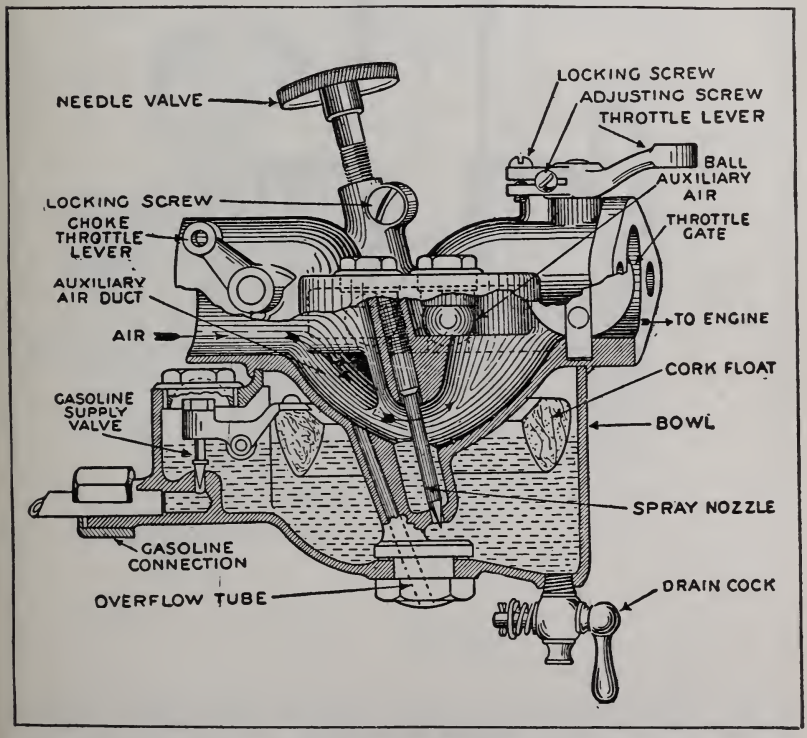


Fig. 288.—Part Sectional View of Special Kingston Carburetor Used on Some Model T Ford Cars.

Holley Carburetor.—Another simple type of vaporizer which has given very good results in practice is shown in section at Fig. 289. This is a concentric float design having the auxiliary air port closed by a flat-seated valve. The gasoline control member is a balanced valve having a counterweight which tends to prevent vibration. The mix-

ture proportions are regulated by a gasoline-adjusting needle valve at the bottom of the carburetor and the air valve spring tension adjustment. The mixture delivered to the cylinders of the motor is regulated by a simple form of throttle disk.

A later and improved form of Holley carburetor is shown in section at Fig. 290. In this the main air enters through a pipe at the

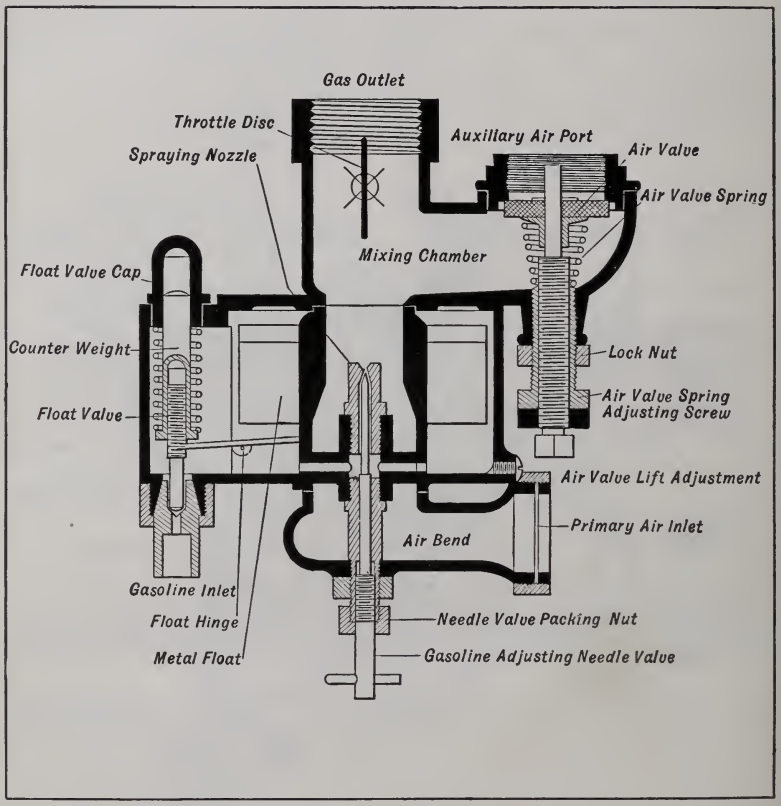


Fig. 289.—Holley Carburetor with Spring Controlled Poppet Valve to Regulate Auxiliary Air Passage.

side of the carburetor which communicates with an annular chamber surrounding the mixing tube. The gasoline collects in a small basin at the top of the partition separating the float bowl from the mixing tube. The gasoline supply is regulated by the usual form of needle valve at the bottom of the float bowl. In this carburetor the only moving part is the float and the auxiliary air valve or auxiliary air

openings have been eliminated by a special construction of the spray nozzle.

Referring to the lettering on the drawing the action of this form of carburetor can be easily understood. The fuel from the tank enters the float chamber A to the gasoline filter screen B, and the level is regulated by the inlet valve C, which is actuated by the usual float

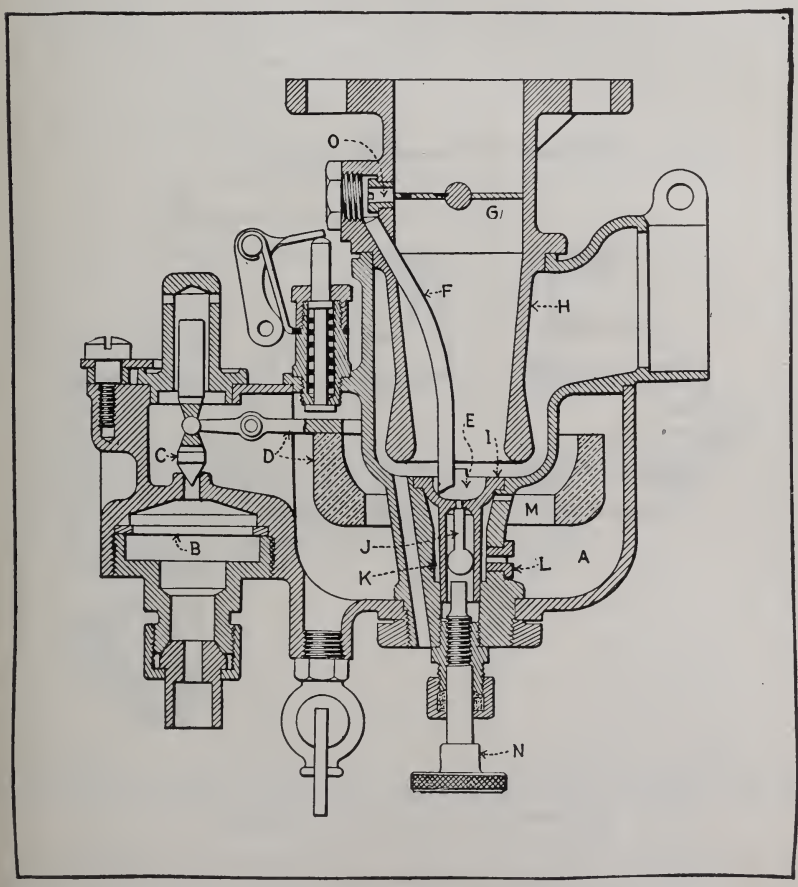


Fig. 290.—Latest Model of Holley Carburetor with By-Pass Tube to Provide Easier Starting.

and lever combination D. When the motor is not running the level is halfway up the cup E and submerges the lower end of the low-speed tube F. When starting the engine the throttle G is nearly closed and gasoline and air are drawn through F with very high velocity owing to the degree of suction, thus forming a rich mixture and mak-

ing starting easy. The tube F continues to supply the motor at low speeds, but as the throttle valve opens the small tube gradually emerges into the larger one and all the mixture supplied at motor speeds above 300 R. P. M. passes through the main mixing tube H.

The spray nozzle I has a slot J which is supplied by two separate channels, the series of holes M and the plug L, the latter having a limited hole. At low engine speeds both operate, M predominating, but as the speed increases the fuel level automatically drops, because the needle C must lift higher with the increase in amount furnished

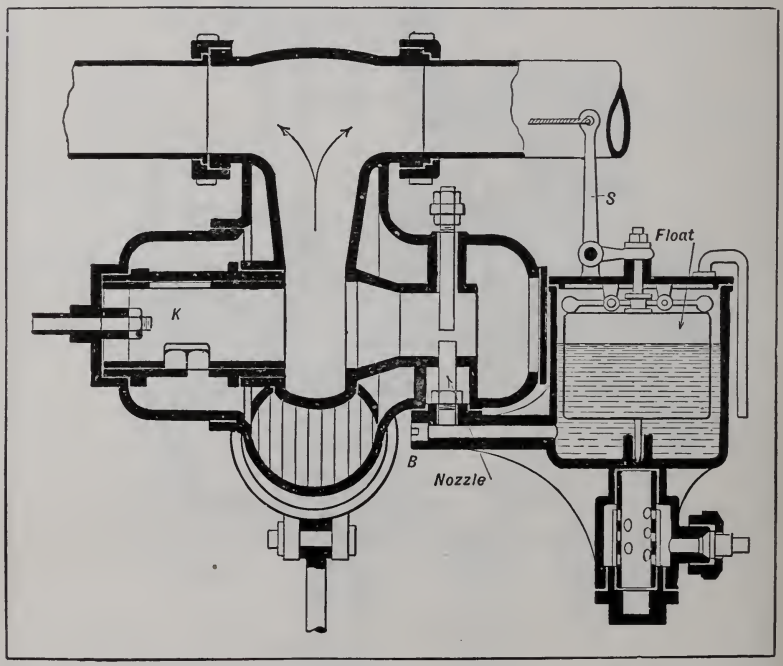


Fig. 291.—Mercedes (German) Carburetor, which Has Retained Substantially the Same Form as when First Designed.

The leverage is about three to one, so that the float drop is three times the movement of the needle, and the holes M are uncovered to the atmosphere above the fuel surface, which passes through the slot J and maintains the uniformity of the mixture. The gasoline feed at low speeds is adjusted by the size of the plug opening O, extreme high speeds by the area of the orifice in plug L, and the intermediate ratios through the automatic action provided by the series of holes M, the slot J and the nozzle I, and the adjusting needle. The advantages claimed by the designer are: permanent adjustment, positive starting,

due to high vacuum and air velocity directly applied to the source of fuel supply; positive action at low and idling speed due to rich mixture; greater economy and rapid acceleration, owing to more homogeneous and better-proportioned vaporization. A richer mixture is automatically obtained for hill climbing and hard pulling because the fuel level rises with slower motor speed and feeds the spray nozzle through two channels instead of one.

Mercedes.—A typical foreign type of simple carburetor is shown at Fig. 291, this being the vaporizing device used on Mercedes cars. This is a float-feed type having a float chamber carried at one side of the mixing chamber. The spray nozzle is a simple type which extends in a tube having one end open to the main supply pipe and the other to the annular chamber through which the air is inspired. The mixture supply is regulated by a sliding throttle valve K, which also provides the auxiliary air in increasing proportions as the amount supplied the cylinders is increased. The only way the gasoline proportions may be altered is by varying the spray nozzle or changing the level of the float.

Pierce Device.—The carburetor shown at Fig. 292 is that used on Pierce cars, and is illustrated because it presents a number of novel features. While the construction in the main follows conventional practice inasmuch as the spray nozzle is concentric with the float, it employs a novel method of auxiliary air valve control and a form of throttle which is not generally used. The auxiliary air ports are regulated by reeds which are backed by supplementary springs to prevent excessive motion. The reeds open progressively as the suction increases. The throttle chamber contains a barrel-shaped throttle member which has openings cut in it registering with the gas outlet and the orifice communicating with the mixing chamber. The gasoline supply is regulated by a needle valve which may be adjusted to regulate the size of the opening in the nozzle. The mixing chamber is water-jacketed, and as the stream of hot water from the engine is kept circulating through the water space the heat tends to promote more positive vaporization of fuel and insure thorough mixture of gasoline and air.

G. and A. Automatic Carburetor.—The Grouvelle and Arquemberg carburetor depicted at Fig. 293 is a foreign type that has been applied with some degree of success in this country. The float chamber is carried to one side of the mixing chamber and the usual Venturi tube construction is followed. No gasoline regulation is possible without changing the spraying nozzle, and as the auxiliary air supply is regulated by a series of ball valves this adjustment cannot be va-

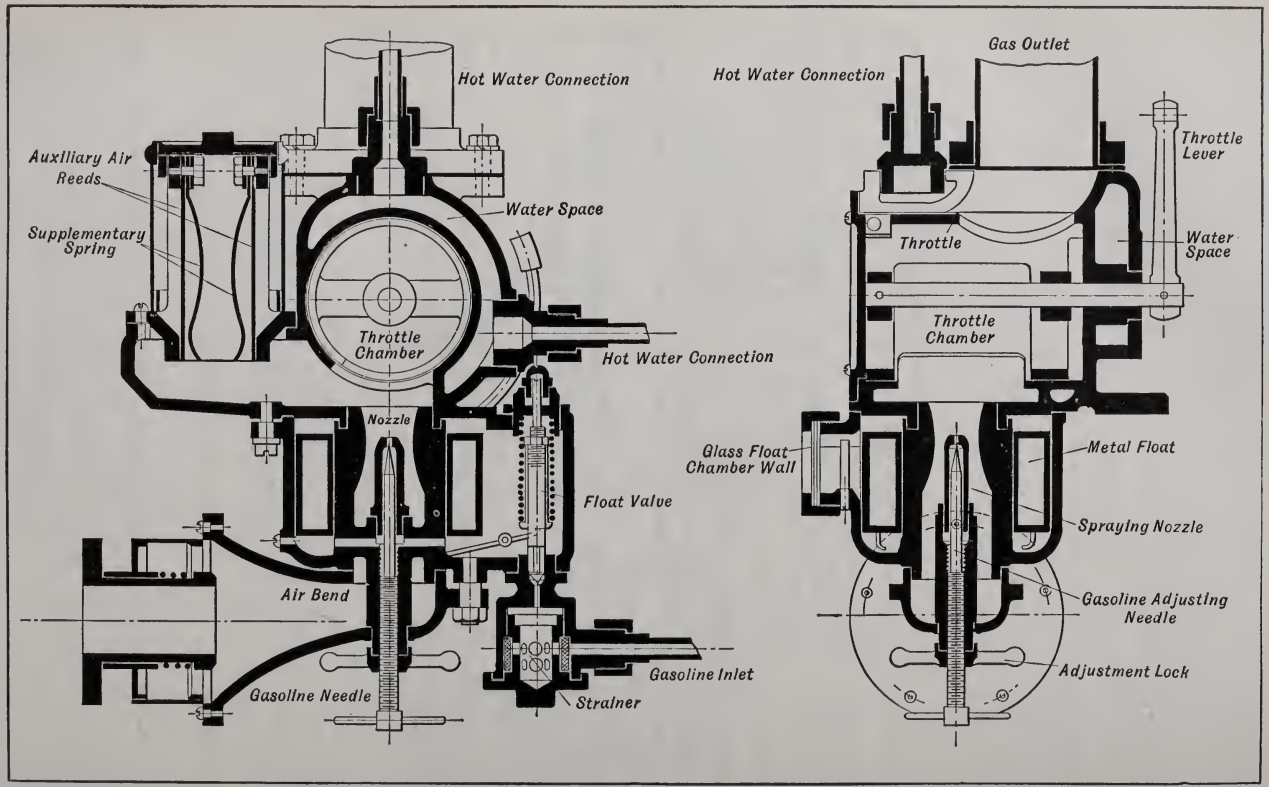


Fig. 292.—Views of Efficient Vaporizer Used on Pierce-Arrow Cars, Showing Method of Fuel Regulation, Auxiliary Air Control by Reeds and Mixture Supply Regulation by Cylindrical Throttle Valve.

ried. The mixing chamber is water-jacketed and the amount of fuel admitted to the cylinders is regulated by a simple disk valve. It is advanced by the makers of this apparatus that once fitted to an engine it will need no further attention and is entirely automatic in its action. The combination of the Venturi tube and the floating ball auxiliary air control are said to provide mixtures of suitable propor-

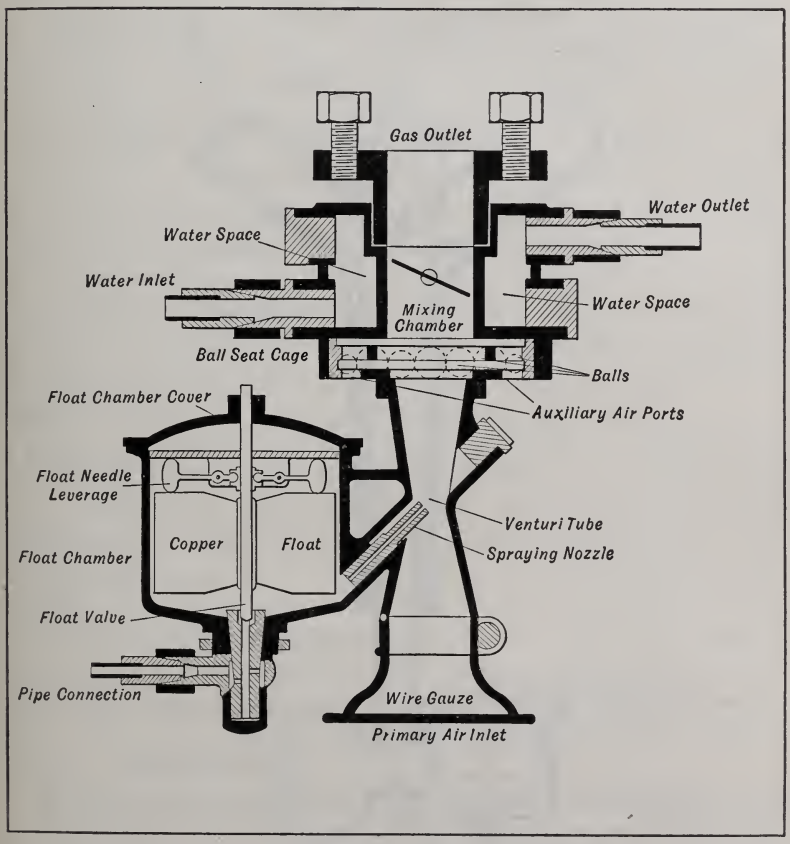


Fig. 293.—Grouvelle and Arquemberg (French) Carburetor with Venturi Tube Mixing Chamber and Air Port Control by Floating Balls.

tions for all engine speeds without using adjustable members, which are liable to get out of order and cause trouble.

Peerless.—Another simple form of carburetor in which the Venturi tube effect is depended upon is shown at Fig. 294, which represents the combined inlet manifold and carburetor used on four-cylinder Peerless models of several years ago. The float chamber is

carried to one side of the mixing chamber and the auxiliary air valve and throttle are located at the top of the air tube. The float chamber and spray nozzle construction are conventional, but the combined throttle and air valve construction is unique. The air valve is a light sheet

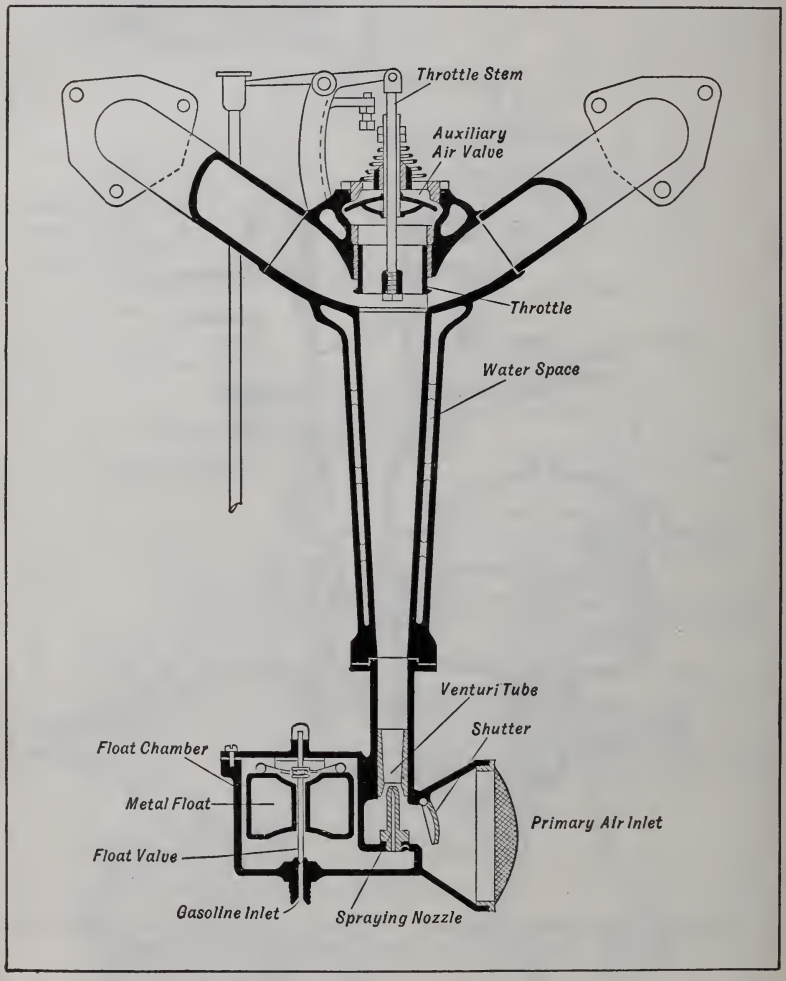


Fig. 294.—Early Peerless Carburetor, which was Combined with Induction Manifold, Spray Nozzle and Float Chamber at the Bottom and Air Valve at Top of Long Mixing Chamber.

metal member located at the extreme top of the mixing chamber and held to its seat by a cone-shaped helical spring. The air valve is guided by the throttle stem. The throttle consists of a cylindrical member

connected to a hub by four ribs, and when it is desired to shut off the gas the lower portion of the throttle seats against the top of the air tube, thus effectively shutting off the branches which lead to the cylinder from the central member.

Owing to the small bore of the mixing chamber a rich gas is inspired at low motor speeds, and when the suction effect increases the auxiliary air supply enters through the throttle and meets the incoming column of rich gas to dilute it sufficiently to obtain a properly proportioned mixture. The course of the gas is direct, rising vertically from the top of the spray nozzle to the throttle where it branches to the two inlet pipes forming the letter Y.

The air tube is water-jacketed its full length to insure vaporization of comparatively low grade fuel. The main air entrance is through a funnel-shaped opening provided with a fine mesh screen, past a hinged shutter and then around the spray nozzle. The function of the shutter is to promote easy starting, as it may be dropped so the air pipe is almost shut off when it is desired to promote high gas velocity past the top of the spray nozzle. The mixture proportions are altered by changing the tension of the air valve spring which directly affects the degree of opening and the amount of auxiliary air inspired.

Breeze.—A simple form of automatic carburetor is shown at Fig. 295. This utilizes a concentric mixing chamber of the Venturi tube type. The auxiliary air port is controlled by a flat seat valve and the gasoline spray is regulated by an overhead needle adjusting tube. The air entrance through an air bend at the bottom of the carburetor flows past the spray nozzle and out through the gas outlet which is controlled by a butterfly throttle valve. A feature of this instrument is the detachable strangling tube which may be removed in case the proper adjustments cannot be obtained by the air valve and gasoline needle and replaced by one of larger or smaller bore as conditions demand.

Stromberg One-Nozzle Type.—The features of the new Stromberg are the balanced air valve, which, if its action were not known, would be referred to as an auxiliary air valve, and the method of using the air which is taken through this air valve in such a way as to give, with a single nozzle, the gasoline flow previously obtained with separate low-speed and high-speed nozzles. Briefly, the balanced valve in operation diverts a portion of the air flow taken through the main inlet and this diverted air passes through the carburetor body to a point at the upper end of the Venturi tube. The air passage at this point is formed like the entrance for a larger Venturi tube and acts in such a way as to cause the air which has entered through the bal-

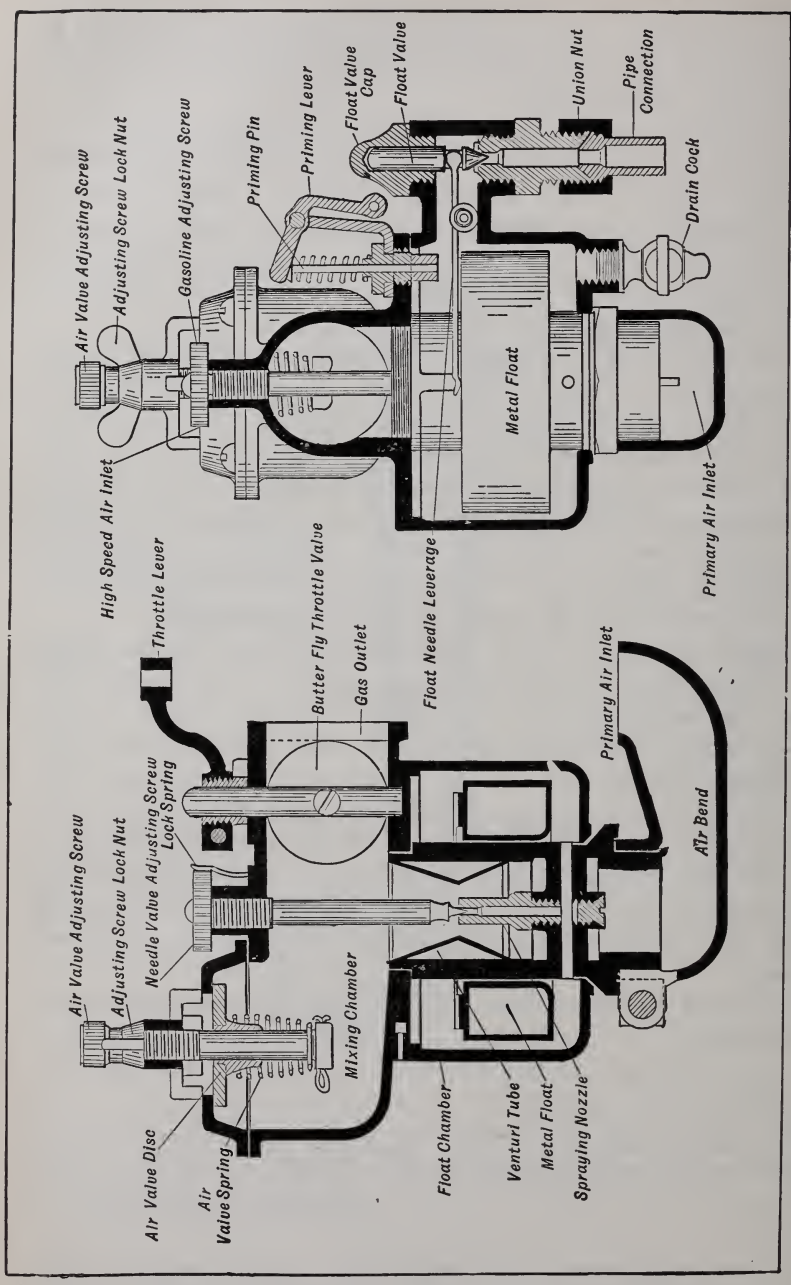


Fig. 295.—Showing Details of Breeze Carburetor, a Simple Automatic Instrument. Note Fuel Adjustment Needle Valve Over Spray Nozzle.

anced valve to exert additional suction in the primary Venturi tube. This additional suction and the added gasoline feed are in proportion to the auxiliary air admitted, so that while there is only one nozzle and one air inlet there are really two air currents exerting a compound action on the gasoline jet. By studying the cross-sectional diagram of this new instrument given at Fig. 296 the action when in

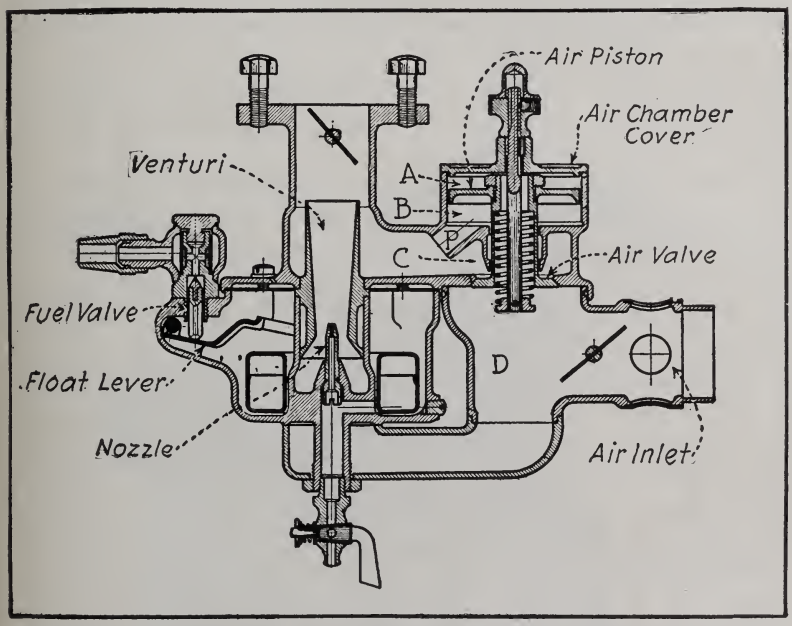


Fig. 296.—Cross-Sectional Diagram of Stromberg One-Nozzle Carburetor.

operation will become clear. The single nozzle is shown located in the lower portion of the Venturi tube, around the base of which is the brass float operating a fuel valve in the conventional way. The portion of the instrument to the right of the balanced valve is not new to Stromberg practice. However, the balanced valve shown in the upper right of the illustration is new construction.

The mechanism consists of a sleeve having at its lower end the valve proper and at its upper end a piston about twice the size of the valve, so that the piston and valve move together. Within the sleeve is a spring held in place by a rod and nut, which holds the valve up to its seat. It will be noticed there is a small passage P, which connects the chamber B above the valve with C below it. The chamber A above the piston always contains air under atmospheric pressure, except when the dash control valve or air intake shutter is used,

because of its communication with the chamber D through the space around the spring and up through the valve sleeve. The vacuum in B is substantially the same as that in C, which is, of course, determined by the demand of the motor and the strength of the air valve spring. A light spring is used so that this vacuum is always very small, perhaps 8 ounces. As a result the air valve tends to move upward by difference in pressure between C and D, while the piston tends to move downward by the difference in pressure between A and B. As the piston is approximately twice the area of the valve, the whole valve opens downward, but the balance between the chambers is such that the pulsations of motor suction are deadened and the valve flutter thus eliminated.

When the carburetor is in action and the engine running idle, the valve is slightly off its seat. The single nozzle feeds the gasoline and the primary Venturi supplies nearly all the air. As the engine speed is increased or the throtte opened, a greater demand is made on the air valve, which opens, admitting additional air. When this additional air reaches the top of the Venturi it increases the suction in the Venturi and draws additional fuel, so that the supply taken is in proportion to the amount of air which passes through the valve. In other words, as the air valve opens there is an increase in the supply of gasoline as well as the air sent to the motor, thus the result obtained is like that given by a carburetor with two fuel nozzles and two air inlets. The balanced valve does not flutter, but operates gradually as the pressures vary. At low engine speeds the position of the valve regulates the mixture, but above 25 miles an hour, according to the Stromberg engineers, the valve may be open all the way without noticeably affecting the running of the engine except to admit a slightly greater charge. In practice only hot air is used and it is taken from a tube connecting with a stove surrounding a portion of the exhaust manifold.

Compound Nozzle Zenith Carburetor.—The Zenith carburetor, shown at Figs. 297 and 298, has become very popular because of its simplicity, as mixture compensation is secured by a compensating compound nozzle principle that works very well in practice.

To illustrate this principle briefly, let us consider the elementary type of carburetor or mixing valve, as shown in Fig. 299, A. It consists of a single jet or spraying nozzle placed in the path of the incoming air and fed from the usual float chamber. It is a natural inference to suppose that as the speed of the motor increases, both the flow of air and of gasoline will increase in the same proportion. Unhappily, such is not the case. There is a law of liquid bodies which

states that the flow of gasoline from the jet increases under suction faster than the flow of air, giving a mixture which grows richer and richer—a mixture containing a much higher percentage of gasoline at high suction than at low. The tendency is shown by the accompanying curve (Fig. 299, B), which gives the ratio of gasoline to air at varying speeds from this type of jet. The mixture is practically constant only between narrow limits and at very high speed. The

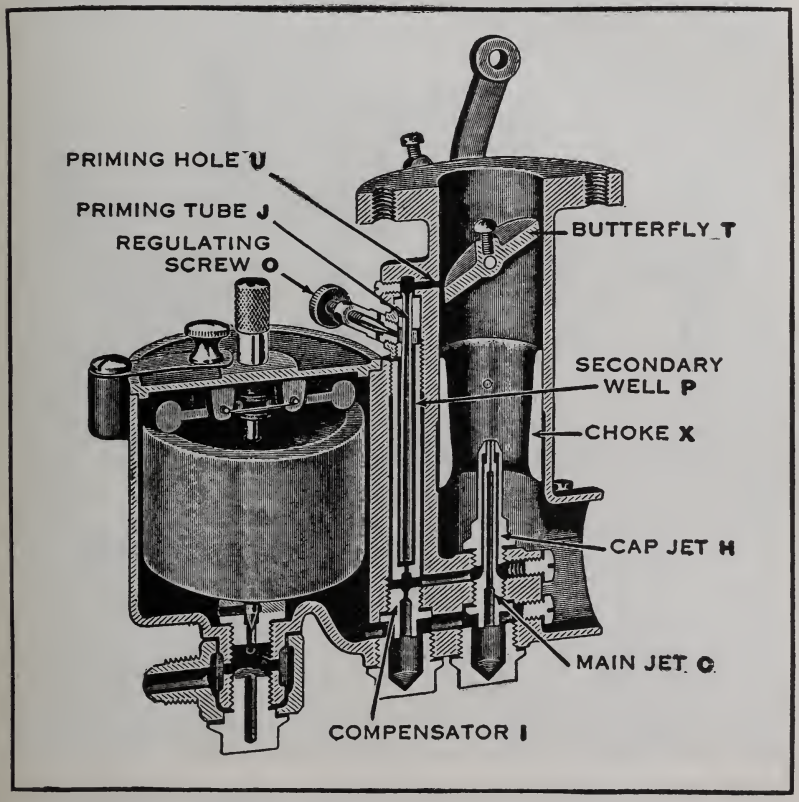


Fig. 297.—Sectional View of Zenith Compound Nozzle Carburetor.

most common method of correcting this defect is by putting various auxiliary air valves which, adding air, tends to dilute this mixture as it gets too rich. It is difficult with makeshift devices to gauge this dilution accurately for every motor speed.

Now, if we have a jet which grows richer as the suction increases, the opposite type of jet is one which would grow leaner under similar conditions. Baverey, the inventor of the Zenith, discovered the principle of the constant flow device which is shown in Fig. 299, C. Here

a certain fixed amount of gasoline determined by the opening I is permitted to flow by gravity into the well J open to the air. The suction at jet H has no effect upon the gravity compensator I because the suction is destroyed by the open well J. The compensator, then, delivers a steady rate of flow per unit of time, and as the motor suction increases more air is drawn up, while the amount of gasoline remains

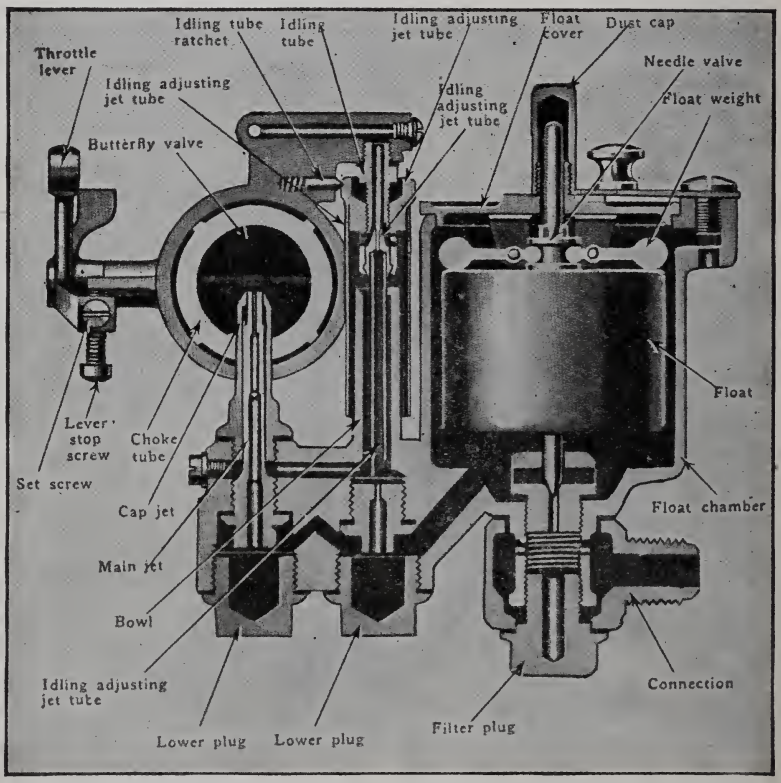


Fig. 298.—Sectional View of Horizontal Type Zenith Compound Nozzle Carburetor.

the same and the mixture grows poorer and poorer. Fig. 299, D, shows this curve.

By combining these two types of rich and poor mixture carburetors the zenith compound nozzle was evolved. In Fig. 299, E, we have both the direct suction or richer type leading through pipe E and nozzle G and the "constant flow" device of Baverey shown at J, I, K and nozzle H. One counteracts the defects of the other, so that from the cranking of the motor to its highest speed there is a constant ratio of air and gasoline to supply efficient combustion.

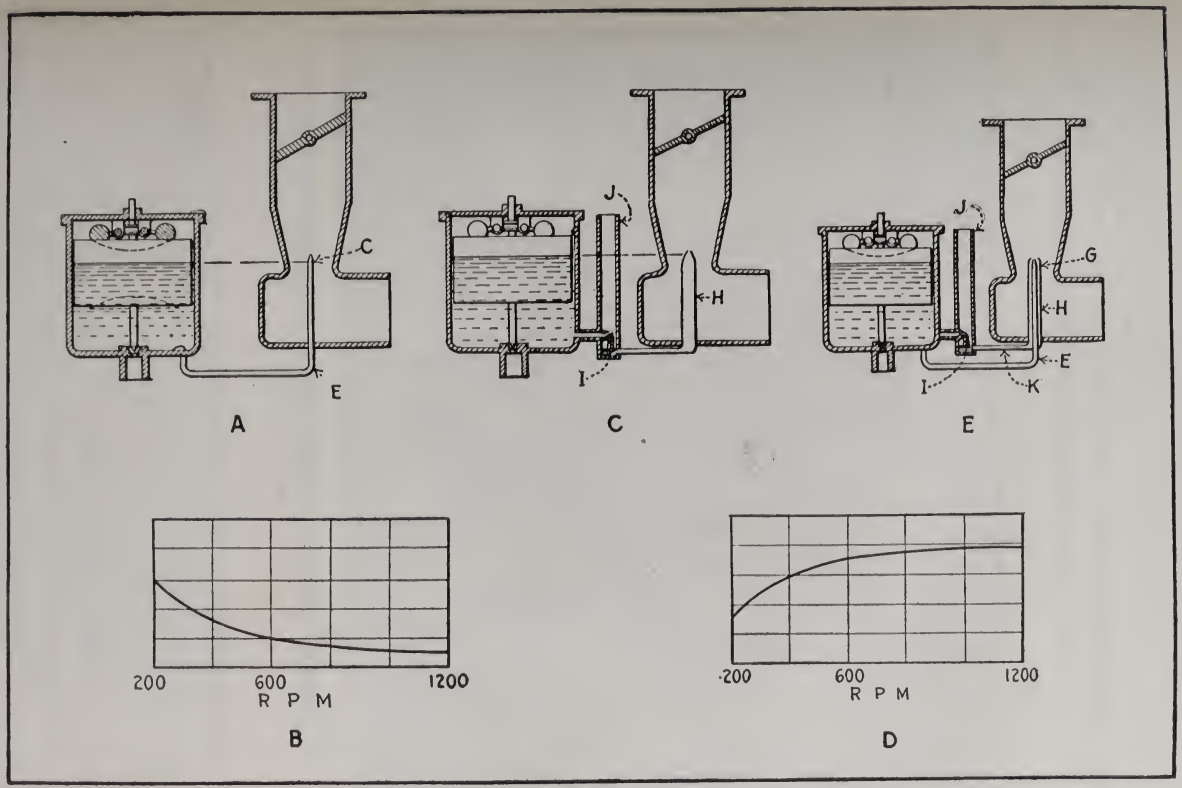


Fig. 299.—Diagrams Illustrating Action of Zenith Compound Nozzle Carburetor.

In addition to the compound nozzle the Zenith is equipped with a starting and idling well, shown in the cut of Model L carburetor at P and J. This terminates in a priming hole at the edge of the butterfly valve, where the suction is greatest when this valve is slightly open. The gasoline is drawn up by the suction at the priming hole and, mixed with the air rushing by the butterfly, gives an ideal slow speed mixture. At higher speeds with the butterfly valve opened further the priming well ceases to operate and the compound nozzle drains the well and compensates correctly for any motor speed.

With the coming of the double motor containing eight or twelve cylinders arranged in two V blocks, the question of good carburation

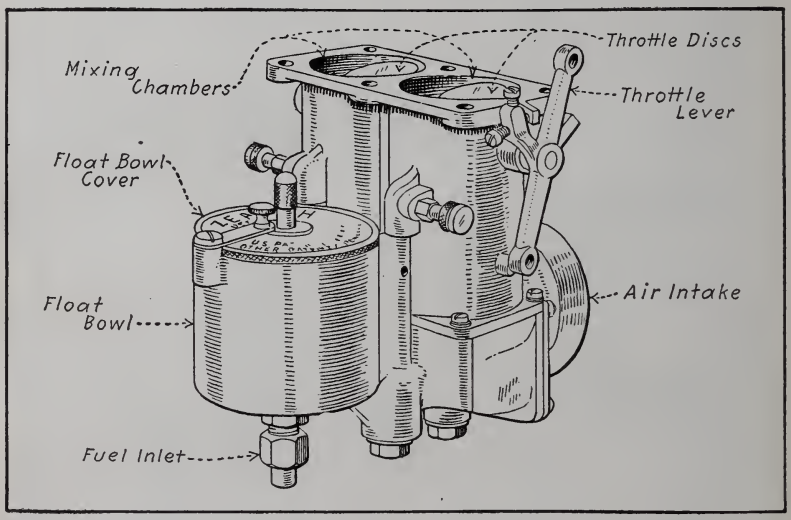


Fig. 300.—Duplex Vertical Type Zenith Carburetor for Eight- and Twelve-Cylinder V Engines.

has been a problem requiring much study. The single carburetor has given only indifferent results due to the strong cross suction in the inlet manifold from one set of cylinders to the other. This naturally led to the adoption of two carburetors in which each set of cylinders was independently fed by a separate carburetor. Results from this system were very good when the two carburetors were working exactly in unison, but as it was extremely difficult to accomplish this co-operation, especially where the adjustable type was employed, this system never gained in favor. The next logical step was the Zenith Duplex, shown at Fig. 300. This consists of two separate and distinct carburetors joined together so that a common gasoline float

chamber and air inlet could be used by both. It does away with cross suction in the manifold because each set of cylinders has a separate intake of its own. It does away with two carburetors and makes for simplicity.

Stromberg Type "M.B." Carburetor.—This new Stromberg carburetor, shown at Fig. 301, differs from older styles in that it is a plain

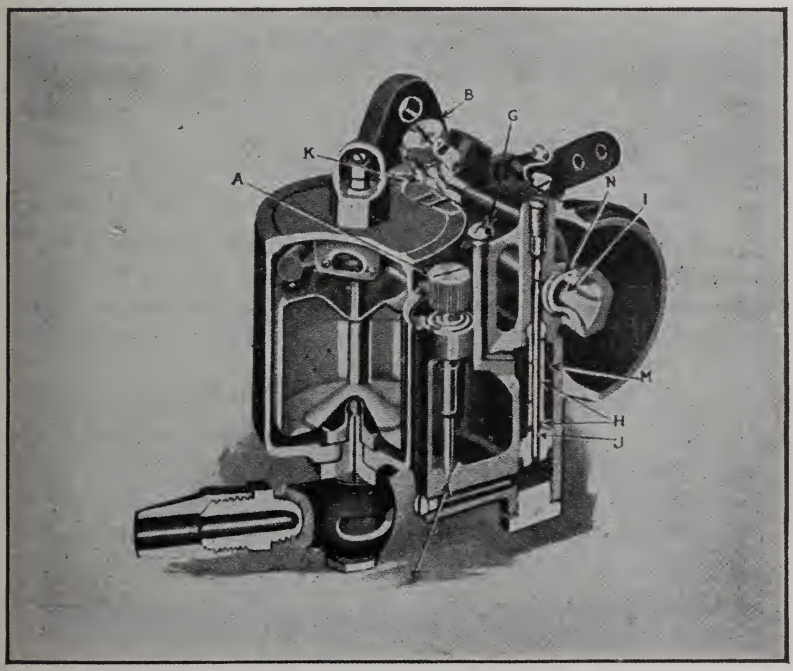


Fig. 301.—Sectional View of Stromberg Type "M.B." Carburetor.

tube type, having the air passages fixed in size, while the gasoline is automatically and accurately measured by the air flow itself for all speeds and loads. This uniform operation is made possible by the air bled nozzle construction. For high speeds the gasoline, after passing the orifice "F," is mixed with air taken through the bleeder "G" and holes in "H" to form a highly atomized mixture which passes through passage "N" to 8 discharge holes in the small Venturi "I." For low speeds the gasoline does not enter the Venturi at all, but is taken through the hole "J" to above the throttle, entering through the idling jet "K." The accelerating well "M" serves as a reservoir, which discharges on acceleration, and refills on deceleration, thus giv-

ing extreme flexibility, without requiring any abnormally rich adjustment of the steady running mixture. There are two adjustments on this new Stromberg: "A," the main adjustment, controls the gasoline supply from the float chamber and regulates the mixture through the whole driving range. Turning nut "A" anti-clockwise, or to the left, raises the needle and gives more gas; clockwise, less. If an entirely new adjustment is necessary turn nut "A" clockwise (to the right), until needle just seats, then open "A" 3 complete turns (to the left), which should give a mixture considerably rich. After starting and warming up the motor this adjustment may be regulated as necessary for the best driving mixture. The gasoline for Idle is taken in above the throttle and controlled by dilution with air from the inside of the carburetor, as regulated by screw "B," which should be between one-half and one and one-half turns to the left, or anti-clockwise, from the seating position. After the motor is warm this may be regulated as necessary, turning to the right, or clockwise, for more gas and to the left, or anti-clockwise, when less gas is required. Note that Idle adjustment is effective only when throttle is nearly closed.

For starting and warming up with the present day fuel, it is absolutely necessary to use the dash or steering post control until proper operating temperature is attained. Ordinarily the motor will start readily with the control closed one-half to three-quarters way. In very cold weather it may be necessary to pull the control up all the way, but this should be done only for an instant, as this cuts off all the air and delivers raw gasoline only. In starting with electric starter the throttle should be nearly closed, or it may be opened and closed while the starter turns the motor over. For hand cranking in cold weather the control should be almost completely closed, while the throttle should be one-fourth to one-third open. After starting the control should be adjusted as necessary and, allowing the motor a moment to steady itself, should be set at a point where the motor will have full power and yet not too rich a mixture for smooth running. As the engine warms up the control may be lowered. Instead of setting the mixture permanently rich it is much better to use a moderate setting and then to give intelligent attention to the operation of this control. For winter use it is advisable to partly cover the radiator, as a water temperature of 130° Fahrenheit, or above, is absolutely necessary if a motor is to show its normal flexibility and power. Under such conditions the full supply of hot air should, of course, be used. In the warm months the season adjustment shutter on the hot air horn may be opened to admit cold air.

The Claudel (French) Carburetor.—This carburetor is of extremely simple construction, because it has no supplementary or auxiliary air valve and no moving parts except the throttle controlling the gas flow. The construction is already shown in Fig. 302. The spray jet is eccentric with a surrounding sleeve or tube in which there are two series of small orifices, one at the top and the other near the bottom. The former are about level with the spray jet opening. The sleeve surrounding the nozzle is closed at

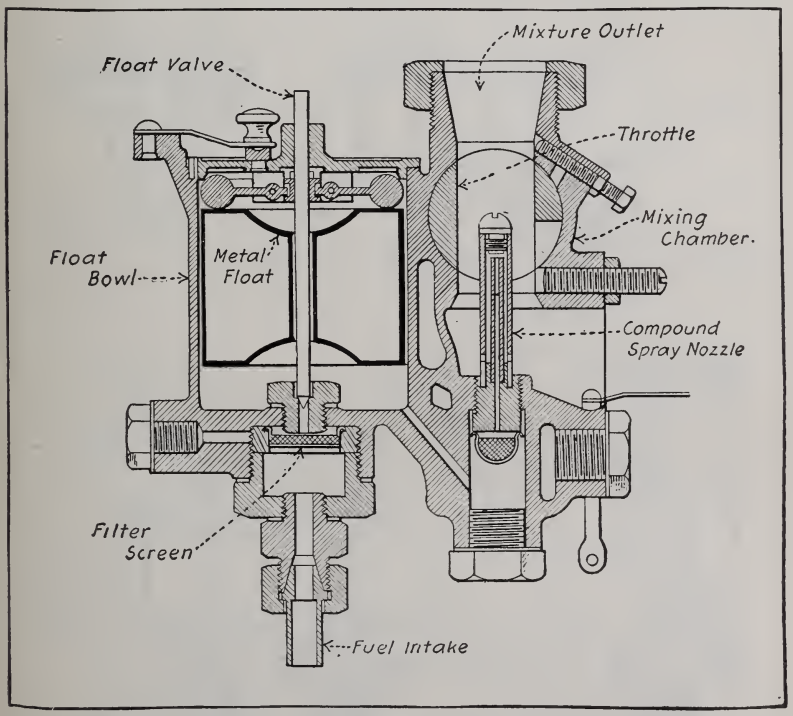


Fig. 302.—Sectional View of the Claudel (French) Carburetor.

the top. The air, passing the upper holes in the sleeve, produces a vacuum in the sleeve, thereby drawing air in through the bottom holes. It is this moving interior column of air that controls the flow of gasoline from the nozzle. Owing to the friction of the small passages, the speed of air flow through the sleeve does not increase as fast as the speed of air flow outside the sleeve, hence there is a tendency for the mixture to remain constant. The throttle of this carburetor is of the barrel type, and the top of the spray nozzle and its surrounding sleeve are located inside the throttle.

Stewart Metering Pin Carburetor.—The carbureter shown at Fig. 303 is a metering type in which the vacuum at the jet is controlled by the weight of the metering valve surrounding the upright metering pin. The only moving part is the metering valve, which rises and falls with the changes in vacuum. The air chamber surrounds

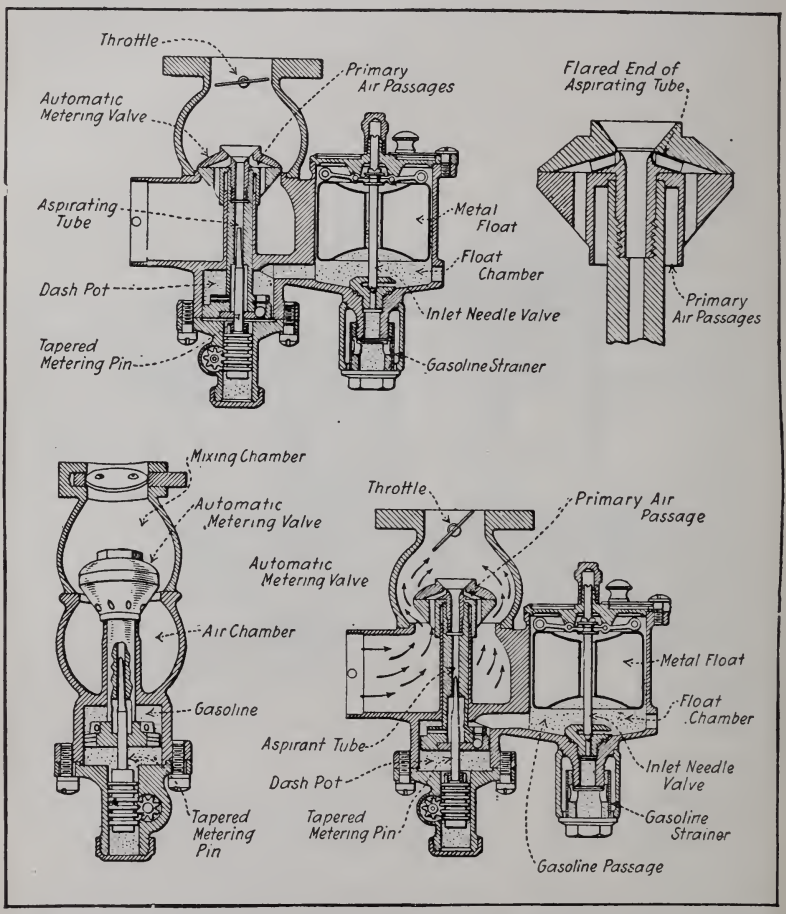


Fig. 303.—Diagrams Showing Action of the Stewart Metering Pin Carburetor.

the metering valve, and there is a mixing chamber above. As the valve is drawn up the gasoline passage is enlarged on account of the predetermined taper on the metering pin, and the air passage also is increased proportionately, giving the correct mixture. A dashpot at the bottom of the valve checks flutter. In idling the valve rests on its seat, practically closing the air and giving the necessary idling

mixture. A passage through the valve acts as an aspirating tube. When the valve is closed altogether the primary air passes through ducts in the valve itself, giving the proper amount for idling. The one adjustment consists in raising or lowering the tapered metering pin, increasing or decreasing the supply of gasoline. Dash control is supplied. This pulls down the metering pin, increasing the gasoline flow.

The duplex type for eight and twelve cylinder motors is the same in principle as model 25, but it is a double carburetor synchronized as to throttle movements, adjustments, etc. A duplex for aeronautical motors is made of cast aluminum alloy.

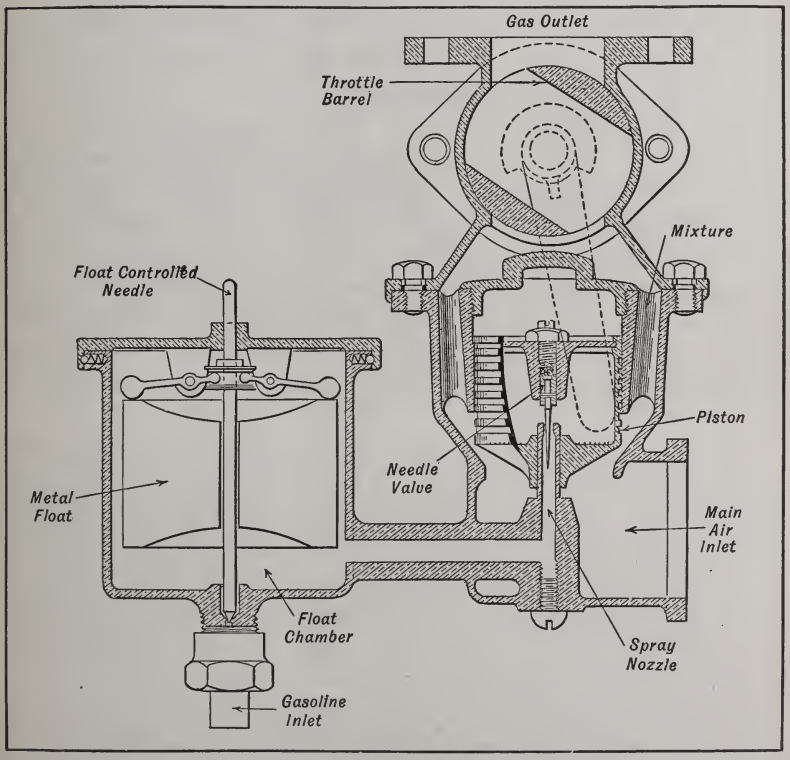


Fig. 304.—Sectional View of the Scott-Robinson (English) Metering Pin Carburetor.

Scott-Robinson.—The carburetor shown at Fig. 304 is an English design, known as the "Scott-Robinson," and is a variable jet type in which the air velocity and the flow velocity of the gasoline are automatically maintained at a constant speed. This is accomplished by

a dashpot arrangement in which a piston carrying a needle valve is mounted. As the suction increases, the piston rises and more gasoline is sprayed into the mixture at the same time as more air is admitted through the main air inlet around the spray nozzle because of the increase in area of the air passage by the rising of the piston in the dashpot. As the amount of suction depends upon the throttle opening, and as the dashpot piston will be drawn up higher as the suction becomes greater, more air and gasoline in a definite fixed ratio will be admitted to the mixing chamber. The normal position of the piston is down to a point approximately as shown in the illustration. The tapering needle valve has partly constricted the spray nozzle and the sides of the piston practically close the main air opening.

Rayfield Mixed Type Carburetor.—This is not a new 1917 model, but there have been some detail refinements, designed to give quicker acceleration and take care of the lower grades of fuel. While the model G is the prominent one of the line, there is a model L, which is the same in every respect, except that it is not water-jacketed as is the horizontal type of the model L. The chief improvement lies in the rearrangement of the metering pin, which is operated by the upper air valve. Previously this pin was held against the air valve by a spring, and the valve had to overcome the reaction of the spring to operate it. Now the metering pin rides on the dashpot piston, which is on the lower end of the air valve stem, and moves upward and downward with the valve, but without any greater effort by the valve.

Rayfield uses a metering pin, as shown at Fig. 305, which is lifted as the throttle opens in the main jet through a linkage, and so establishes a right to be classified as a metering pin type, but it goes further: It incorporates an auxiliary nozzle, which also has a metering pin which is depressed when the auxiliary air valve opens. Thus, by having two distinct nozzles, it establishes its right also to be classified as an expanding type of instrument. But Rayfield goes still further in that it combines a pumping action on the gasoline in the auxiliary nozzle whereby a very rich mixture is furnished for acceleration whenever the air valve is opened suddenly. This is accomplished by the piston on the lower end of the air valve stem, this piston working in a dashpot above the piston and is admitted to the space below the piston by the disk valve in the piston. When the air valve suddenly opens, forcing the piston downward, this disk valve is closed automatically, forcing or pumping the gasoline upward through the fuel passage into the nozzle, where it is sprayed into the inrushing air. Only when the valve opens is this pumping function occurring. At

other times the gasoline issues through this auxiliary nozzle according to the suction of the motor. Thus Rayfield is a compound of two metering pins in conjunction with the pumping function for acceleration. The dashpot also prevents any fluttering action of the valve, since the gasoline flow dampens sudden opening or closing.

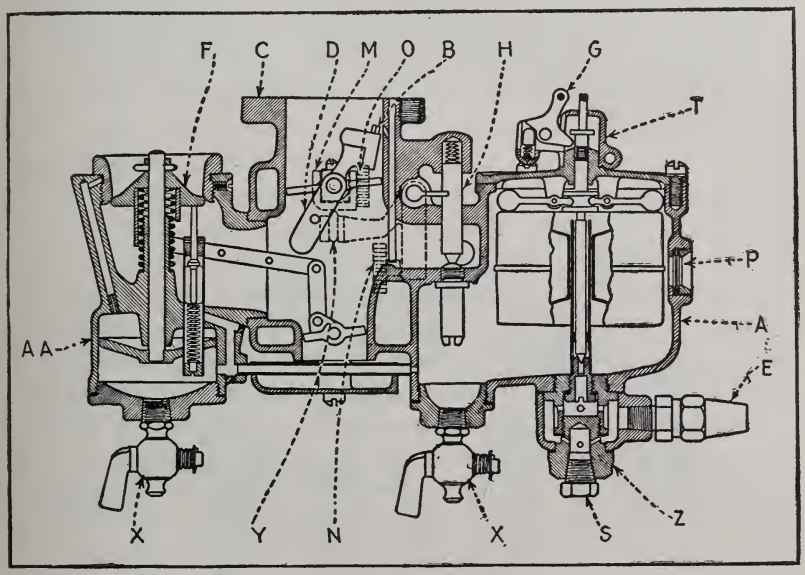


Fig. 305.—Sectional View of the Rayfield Mixed Type Carburetor.

Rayfield Adjustment for Various Speeds.—Adjusting low speed.—With throttle closed and dash control down, close nozzle needle H by turning low-speed adjustment N to the left until the block Y begins to leave cam M; then turn to the right about two complete turns. Open throttle not more than one-quarter by advancing lever marked G on steering wheel. Prime the carburetor by pulling steadily a few seconds on lever G (see cut of carburetor). Start motor and allow it to run until warm, then with retarded spark (see lever marked S on steering wheel), close throttle until motor runs slowly without stopping. Turn low speed adjustment N to the left until motor slows down, then to the right, a notch at a time, until the motor idles smoothly. If the motor does not throttle low enough, turn stop screw B to the left until the motor runs as slowly as desired. Adjusting the high speed.—With dash control down, advance the spark about one-quarter and open the throttle rather quickly. Should this cause the motor to back-fire, the mixture is lean. Correct this by turning the high-speed adjustment O to the right, one notch at a time, until

the throttle may be opened quickly without causing back-firing. If "loading" or "choking" is experienced when the motor is running under heavy load with throttle wide open, the mixture is too rich. This may be overcome by turning high-speed adjustment O to the left. Adjustments made for high speed will in no way affect low speed. Low-speed adjustment N must not be used to get a correct mixture at high speed; it is to be used only when motor is running idle. Before attempting to start, when the motor is cold, open throttle not more than one-quarter, enrich the mixture by pulling up dash control full distance and prime carburetor by pulling lever G (see cut) a few seconds. To stop motor, pull up dash control, open throttle about one-quarter and switch off ignition. This leaves a rich mixture in the motor to insure easy starting. The dash control, when properly used, will facilitate starting, furnish a richer mixture when the motor is cold, and maintain a correct mixture under the most extreme atmospheric conditions. No changes should be made in carburetor adjustments, as the dash control will take care of cold weather as well as cold motor conditions. Raising dash control enriches the mixture by lifting nozzle needle, but ordinarily should be down for running. Do not change nozzles, nor alter the float level, as these are taken care of at the factory and are correct. The automatic air valve F should always be seated when motor is throttled down to its lowest speed. The float chamber A and dash AA should be drained occasionally through drain cocks X to remove water and sediment which may have accumulated. To clean the trap at the bottom of float chamber, remove nut Z. The parts may then be slipped apart and cleaned. When reassembling these parts be sure that the nut N is drawn up firmly to insure a tight joint. If it is desired merely to drain the trap remove plug S. Never attempt to clean the carburetor while the motor is running.

Multiple Nozzle Vaporizers.—To secure properly proportioned mixtures some carburetor designers have evolved forms in which two or more nozzles are used in a common mixing chamber. The usual construction is to use two, one having a small opening and placed in a small air tube and used only for low speeds, the other being placed in a larger air tube and having a slightly augmented bore so that it is employed on intermediate speeds. At high speeds both jets would be used in series. Some multiple jet carburetors could be considered as a series of these instruments, each one being designed for certain conditions of engine action. They would vary from small size just sufficient to run the engine at low speed to others having sufficient capacity to furnish gas for the highest possible engine speed when used in

conjunction with the smaller members which have been brought into service progressively as the engine speed has been augmented. The multiple nozzle carburetor differs from that in which a single spray tube is used only in the construction of the mixing chamber, as a common float bowl can be used to supply all spray pipes. It is common practice to bring the jets into action progressively by some form of mechanical connection with the throttle or by automatic valves.

Stromberg Two-Jet Type.—A simple form of multiple-jet carburetor is shown at Fig. 306, this being an adaptation of the Strom-

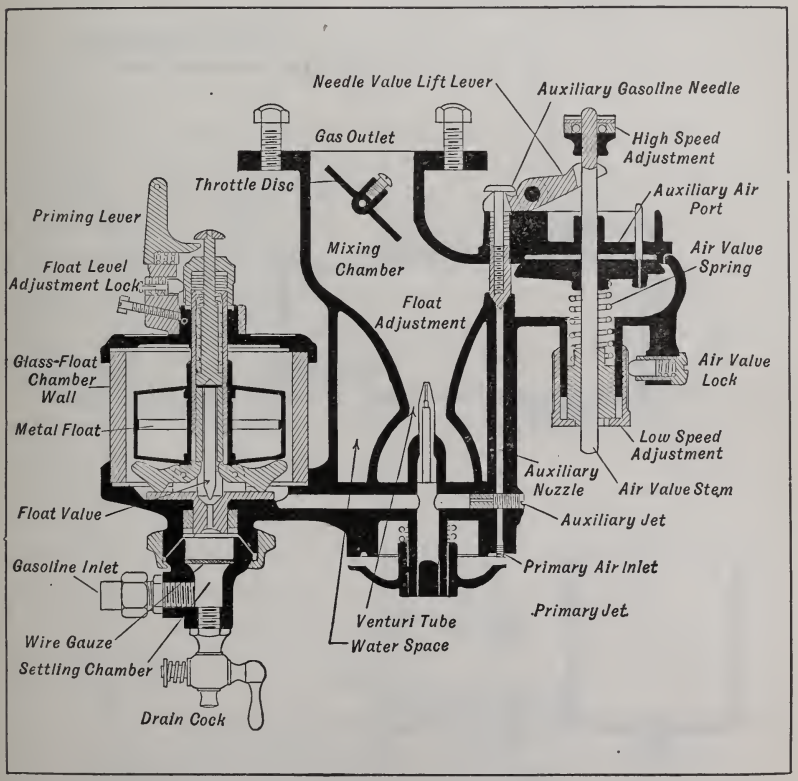


Fig. 306.—Details of the Stromberg Double Jet Carburetor, which Provides Extra Fuel Through Auxiliary Spray Jet when Motor Demands it.

berg carburetor. It does not differ materially from the single-jet construction except that there is an auxiliary nozzle which is closed by a spring-controlled auxiliary gasoline needle. This is operated by a needle valve life lever which in turn is affected only when the auxiliary air valve is drawn down a certain distance by the motor

suction. At low and intermediate speeds the mixture is supplied through the primary jet in the main mixing chamber. When the engine speed augments to such an extent that the auxiliary air valve is opened to a certain point the adjusting nut on the end of the valve stem bears against the long arm of the lever and lifts the auxiliary gasoline needle from its seat. More gasoline is then sprayed into the mixture, which has become too thin because of an oversupply of air through the auxiliary valve and proper mixture proportions are maintained.

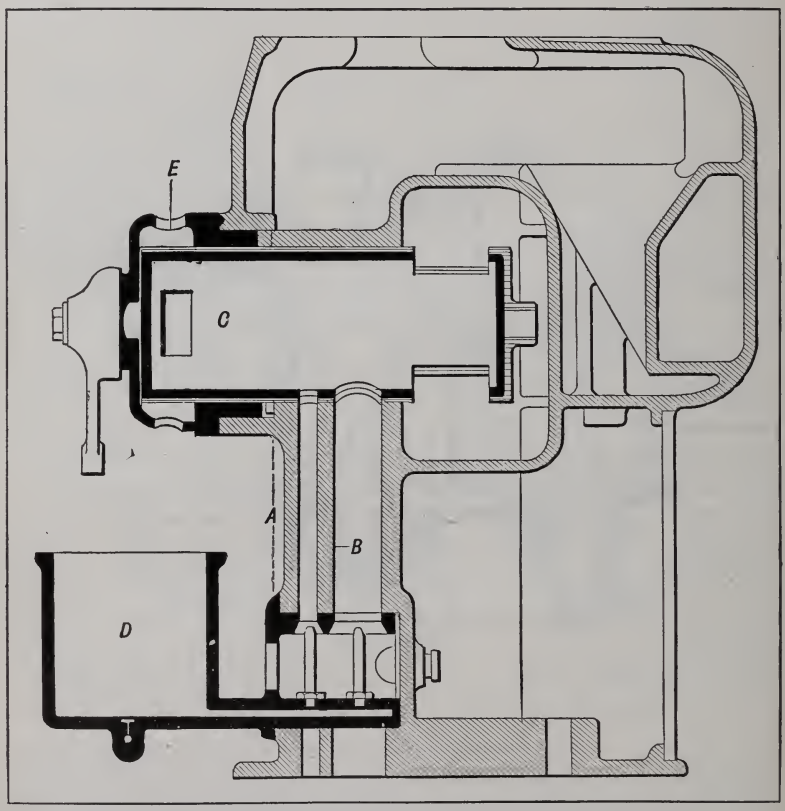


Fig. 307.—Carburetor Incorporated in F. I. A. T. (Italian) Cylinder Casting is a Multiple Jet Type Having Two Spray Tubes.

Novel F. I. A. T. Design.—The form shown at Fig. 307 is a novel one in several respects. It is the type where a common float bowl supplies both spray nozzles. The small nozzle A is used at low speeds and is brought into communication with the throttle chamber C by a

small port in the throttle shell. When the throttle is opened still further to secure higher speed of the motor, the mixing nozzle B, which is a larger one, is brought into play and assists the nozzle A, which would be inadequate if used alone. The auxiliary air enters through the openings E, which are also controlled by ports in the throttle shell. One of the most distinctive features of this carburetor is the manner in which it is incorporated with the cylinder unit casting, it being installed at a point between the pairs of the cylinders. The induction manifold is formed integral with the cylinder casting and no outside manifold is used or needed. The throttle assembly is formed as a unit and inserted into a suitably machined opening, while the float chamber and spray nozzle assembly is inserted at the lower portion as another unit.

Saurer Economy Type.—A simple form of two-jet carburetor having an automatic control of the mixing chamber is shown in section at Fig. 308. In this a clack valve is used to close off the secondary mixing chamber at low speeds. All the air is drawn through a common opening and delivered to an annular air chamber which surrounds the mixing chamber. This permits one air inlet to serve both primary and secondary mixing chambers. At low throttle openings only the primary nozzle is utilized and the amount of gasoline supplied can be adjusted to a degree which will insure a mixture of such proportions as will produce steady running with minimum gasoline consumption.

When the throttle is opened to increase engine speed the degree of suction is increased and at a time that the primary nozzle is not adequate to supply a full charge of gas the clack valve opens automatically and the secondary nozzle is brought into play. The valve is joined to a piston which works in a dashpot by means of a crank and connecting rod in order that its movement will be gradual. The coil spring back of the dashpot piston tends to keep the valve closed until the higher degree of vacuum or suction causes the valve to open against the spring resistance. If the throttle were suddenly closed the tendency of the valve might be to close very rapidly and to prevent too rapid movement of this member the piston is moved against an air cushion at the bottom of the dashpot cylinder. As this member must oscillate to a certain extent when the shutter works back and forth it is journaled at its lower end to permit a certain degree of movement. As will be evident both spray nozzles furnish mixture at high engine speeds. The view shown at A depicts clearly the construction of the clack valve and how its motion is controlled by the crank, connecting rod and piston in the dashpot cylinder. The view

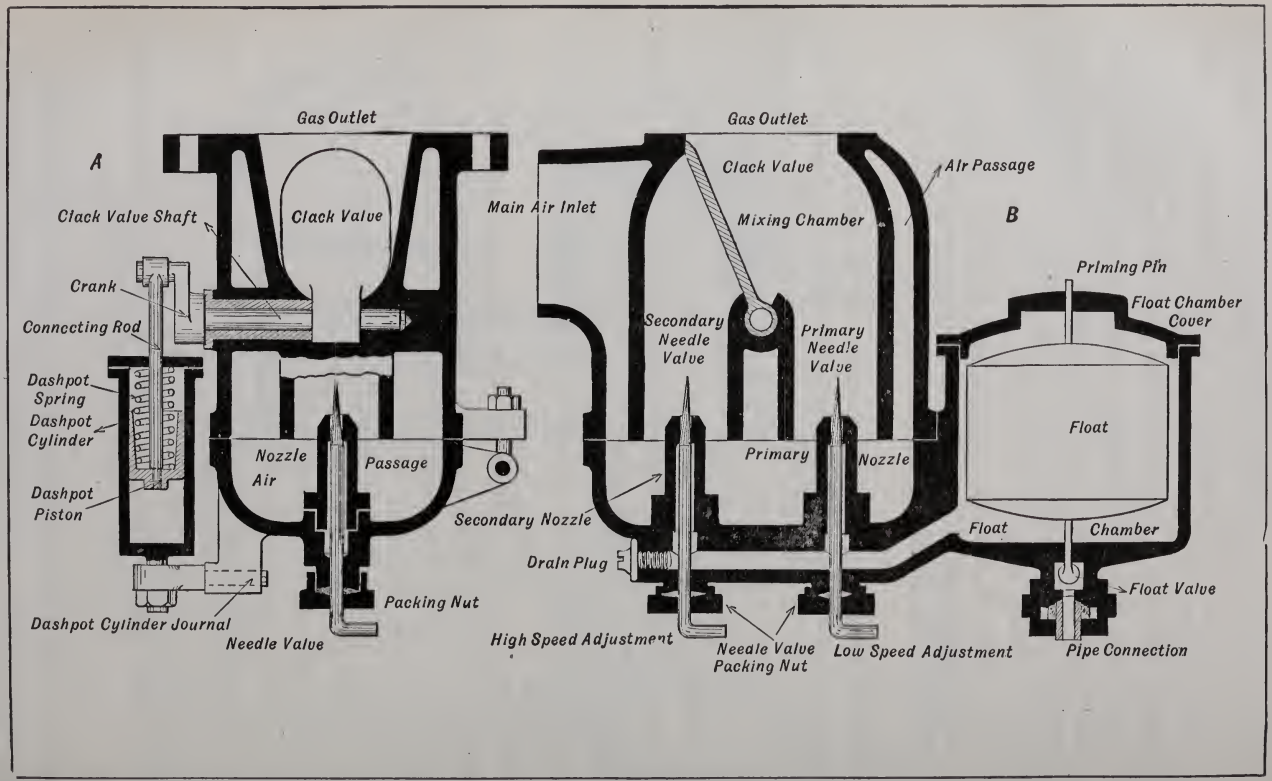


Fig. 308.—Sectional Views Defining Principles of Construction Incorporated in Saurer (Swiss) Economy Carburetor, a Two-Jet Form Having Automatic Control of the Mixture.

at B depicts clearly the arrangement of the float and mixing chambers, and the method of supplying both primary and secondary nozzles with air through one main air inlet and with gasoline from a common source.

Tillotson Two-Jet Type.—This is a double jet, variable Venturi carburetor. A partially uniform vacuum is maintained at the fuel nozzle by two flexible reeds mounted on a cage designed so that the maximum opening takes care of the volume required to fill the combustion chamber at maximum piston speed. When the reeds are

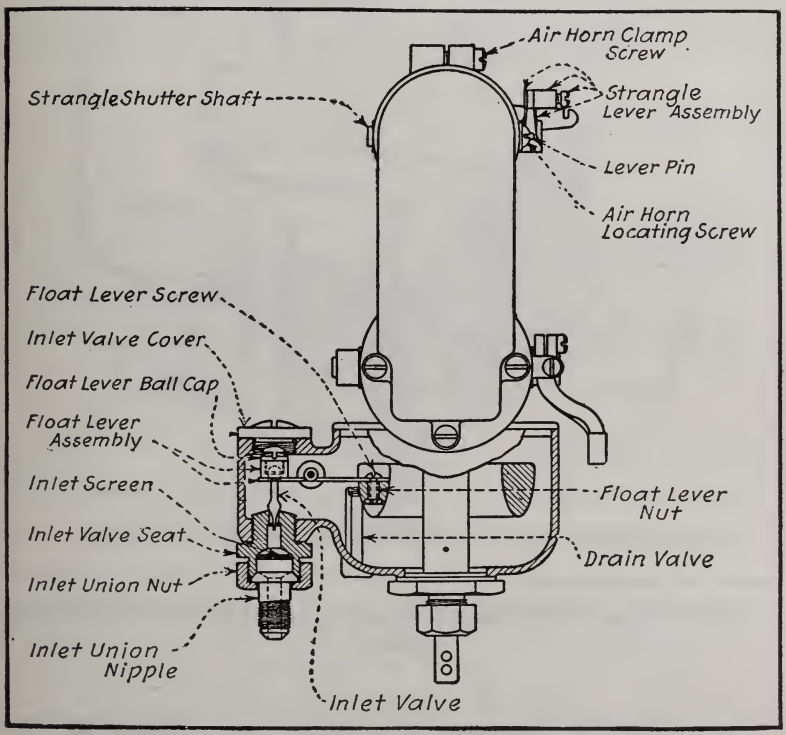


Fig. 309.—Part Sectional View, Showing Construction of Tillotson Carburetor Float Chamber.

seated they provide the highest possible vacuum at slower engine speeds. They are placed so that as they move they form a virtually variable Venturi. A secondary nozzle comes into operation at higher engine speeds and is not in use at the lower speeds. The body design of the carburetor permits only one air intake, and thus it is quite simple to pre-heat the entire air supply. The particular feature is that the heavier fuel is taken care of by the pre-heated air and that

the velocities through the variable Venturi are as high as possible. The construction is clearly shown in the sectional views at Figs. 309 and 309, A.

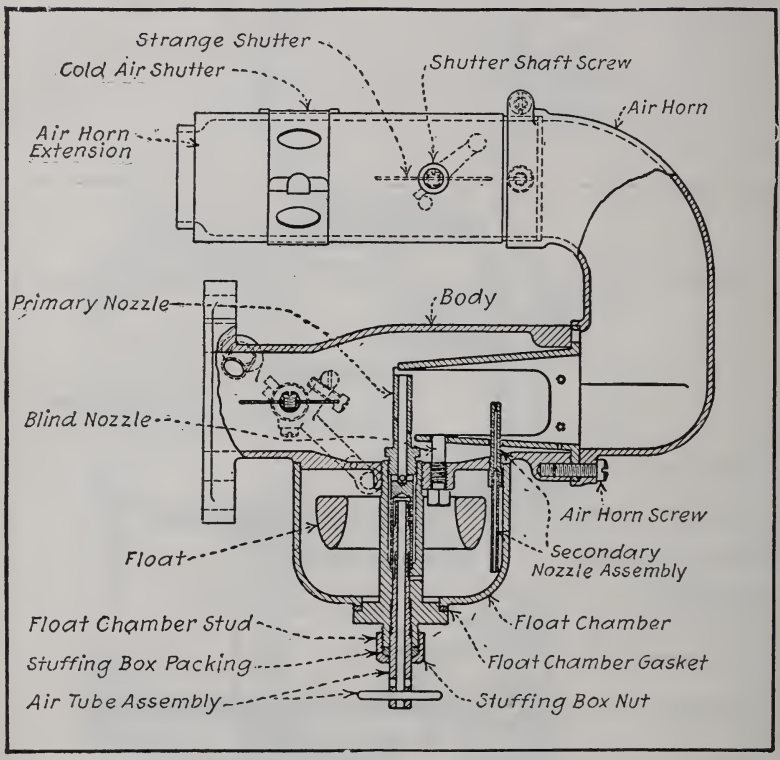


Fig. 309A.—Sectional View, Showing Construction of Tillotson Carburetor Mixing Chamber.

There is but one adjustment necessary in the Tillotson instrument —the low-speed adjustment or needle valve. The air supply is controlled by automatic valves.

1. To regulate the carburetor first run the motor until it is warmed up.

2. Retard the spark and set the throttle so that the motor is running at a car speed approximating fifteen miles per hour.

3. Turn the needle valve to the left or right until the best results are attained. When this adjustment is made the valve should be from one to one and one-half turns off its seat. For the most economical adjustment the valve should be gradually turned into the

carburetor until the motor starts to miss and then slowly turned out again until firing becomes perfect.

Sunderman Carburetor.—As outlined at Fig. 310, this two-jet device is very simple in construction and exceptionally compact, which makes it possible to sell it at a very low price. As shown in the illustration, the rectangular float chamber F, fitted with a primer, is adjacent to the mixing chamber, which is simply a square passage. The fuel is admitted to this passage through the jet J for low speeds and when idling and when the speed is increased the taller jet J automatically comes into play so that both jets are operating at once.

Air is drawn through the valve V, which is regulated by the tension on the spring controlled by the adjusting collar A. In the illus-

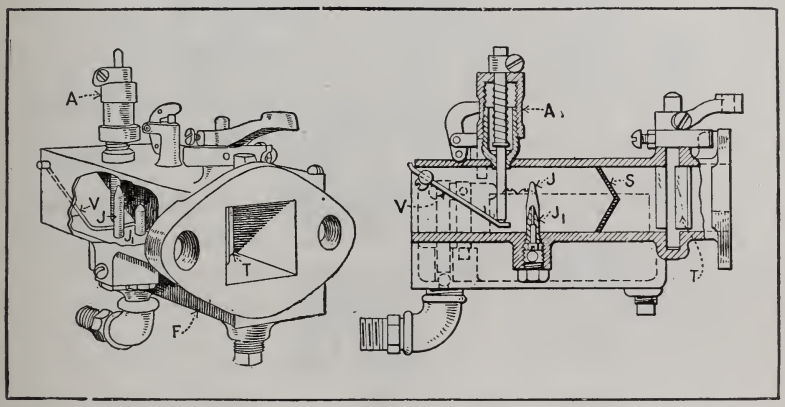


Fig. 310.—The Sunderman Safety Carburetor is a Simple Device.

tration the air intake door is shown in the position it assumes when the motor is idling and fuel is being fed through the short jet J only. As the air rushes into the vacuum behind the intake door it sweeps the globules of fuel from the jets and the resulting vapor is further disintegrated into a homogeneous mixture by passing through the screen S, after which it passes the throttle T on its way through the manifold to the combustion chamber.

Besides a high degree of fuel economy, the makers claim that the carburetor gives great flexibility with consequent minimized gear shifting. The screen S prevents back-firing with its attendant dangers and the elimination of a gasoline adjustment by the use of the regulating jets renders adjustment extremely simple. In fact, the makers state that when the carburetor is once set correctly further changes will be unnecessary.

The object of any multiple nozzle carburetor is to secure greater flexibility and endeavor to supply mixtures of proper proportions at all speeds of the engine. It should be stated, however, that while devices of this nature lend themselves readily to practical application it is more difficult to adjust them than the simpler forms having but one nozzle. When a number of jets are used the liability of clogging up the carburetor is increased, and if one or more of the nozzles is choked by a particle of dirt or water the resulting mixture trouble is difficult to detect. One of the nozzles may supply enough gasoline to permit the engine to run well at certain speeds and yet not be adequate to supply the proper amount of gas under other conditions. In adjusting a multiple jet carburetor in which the jets are provided with gasoline regulating needles, it is customary to consider each nozzle as a distinct carburetor and to regulate it to secure the best motor action at that throttle position which corresponds to the conditions under which the jet is brought into service. For instance, that supplied the primary mixing chamber should be regulated with the throttle partly closed, while the auxiliary jet should be adjusted with the throttle fully opened.

Ball and Ball Two-Stage Carburetor.—This is a two-stage vaporizing device, hot air being used in the primary or initial stage of vaporization and cold air in the supplementary stage. Referring to the sectional illustration at Fig. 311, it will be seen that there is a hot-air passage with a choke valve; the primary Venturi appears at B; J is its gasoline jet, and V is a spring-loaded idling valve in a fixed air opening. These parts constitute the primary system. In the secondary system A is a cold-air passage, T a butterfly valve and J a gasoline jet discharging into the cold-air passage. This system is brought into operation by opening the butterfly T. A connection between the butterfly T and the throttle, not shown, throws the butterfly wide open when the throttle is not quite wide open; at all other times the butterfly is held closed by a spring. The cylindrical chamber at the right of the mixing chamber has an extension E of reduced diameter connecting it with the intake manifold through a passage D. A restricted opening connects the float chamber with the cylindrical chamber so that the gasoline level is the same in both. A loosely fitting plunger P in the cylindrical chamber has an upward extension into the small part of the chamber. O is a small air opening and M is a passage from the cylindrical chamber to the mixing chamber. Air constantly passes through this when the carburetor is in operation. The carburetor is really two in one. The primary carburetor is made up of a central jet in a Venturi passage. The float chamber is eccen-

tric. In the air passage there is a fixed opening, and additional air is taken in by the opening through suction of a spring-opposed air valve. The second stage, which comes into play as soon as the carburetor is called upon for additional mixture above low medium speeds, is made up of an independent air passage containing another air valve. As the valve is opened this jet is uncovered, and air is led past it. For easy starting an extra passage leads from the float bowl passage to a point above the throttle. All the suction falls upon

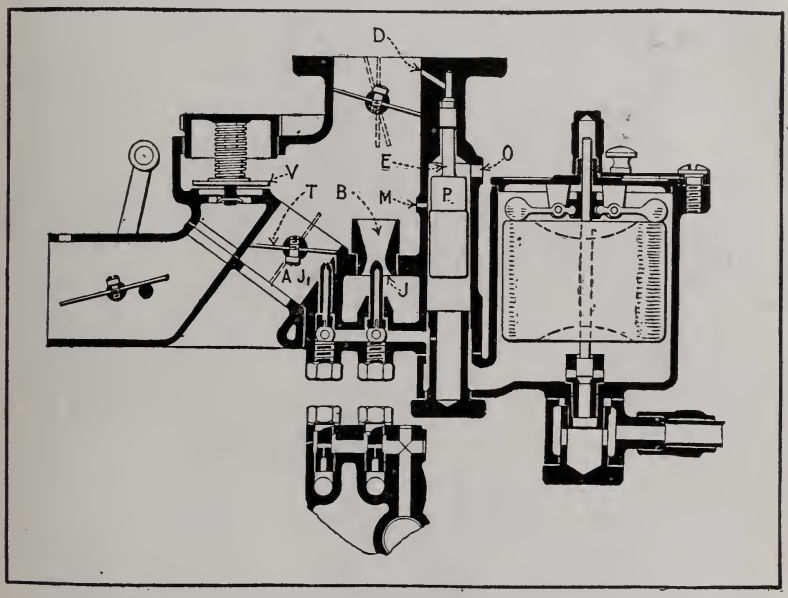


Fig. 311.—Sectional View, Showing Construction of Ball and Ball Two-Stage Carburetor.

this passage when the throttle is closed. The passage contains a plunger and acts as a pick-up device. When the vacuum increases the plunger rises and shuts off the flow of gasoline from the intake passage. As the throttle is opened the vacuum in the intake passage is broken, and the plunger falls, causing gasoline to gather above it. This is immediately drawn through the pick-up passage and gives the desired mixture for acceleration.

Marvel-Buick Carburetor.—The construction of this popular vaporizing device is clearly shown in the sectional view at Fig. 312, while the various external parts are outlined in the exterior view at the bottom of the same plate. The mixing chamber contains the spray nozzles in which the liquid gasoline stands at a constant level,

the Venturi tube or atomizer, which surrounds the low-speed nozzle, and an automatic air valve which controls the amount of air admitted

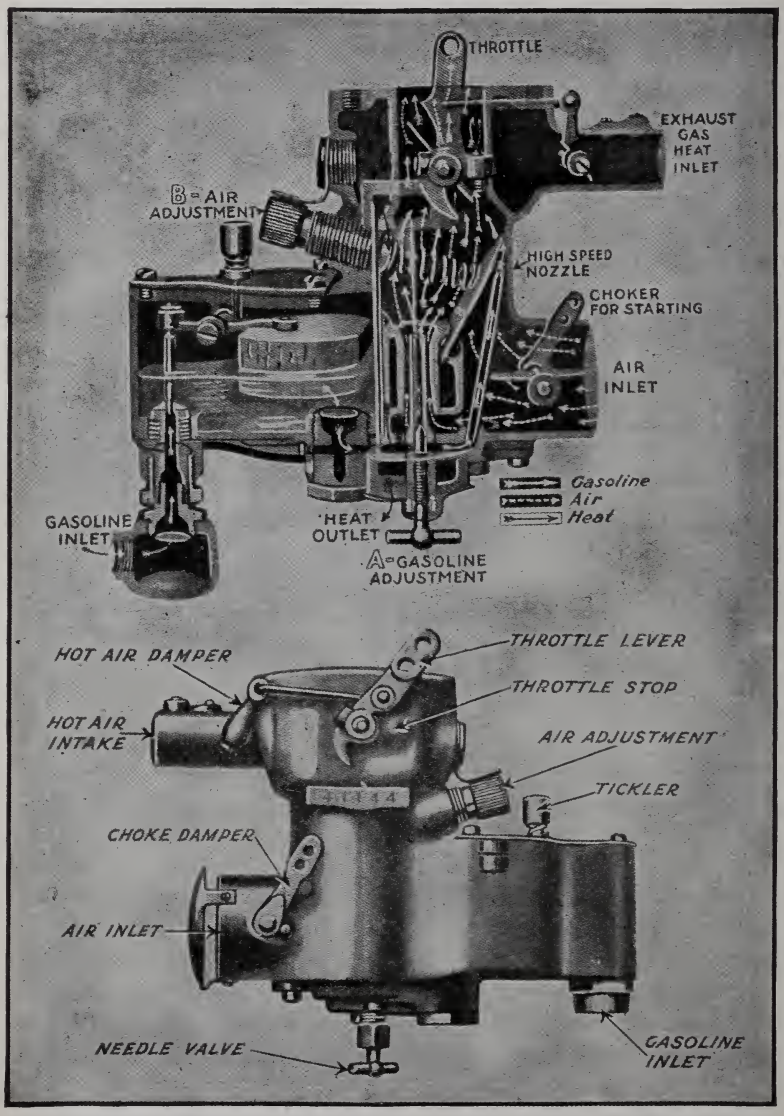


Fig. 312.—Views Showing Construction of the Marvel-Buick Carburetor.

with the measured quantity of gasoline. The throttle valve is located in the upper portion of the mixing chamber, which is also surrounded

by a jacket through which hot exhaust gas from the motor is circulated to warm the mixture on its way to the cylinders. The air inlet is located near the bottom of the mixing chamber and is connected by means of a large flexible tube to the hot-air muff around the exhaust pipe. A needle valve or gasoline adjustment, A, is inserted in the bottom of the low-speed spray nozzle to regulate the flow of gasoline and an air-adjusting screw, B, regulates the tension on the spring which holds the air valve to its seat.

The float chamber is connected, through a strainer, with the gasoline supply from the vacuum tank, and by another passage with the spray nozzles located in the mixing chamber. It contains a cork float attached to a float valve in such a manner that when the liquid fuel has risen to a certain height in the spray nozzles and float chamber, the valve closes, preventing the entrance of any more fuel until the level falls again. By means of a tickler or flusher in the cover of the float chamber, the float may be artificially depressed to flood the carburetor when necessary for testing the connections.

In adjusting the carburetor the object is always to obtain the most economical mixture possible consistent with the required performance. The carburetor is carefully adjusted and set before the car leaves the factory, and in most cases the best thing the driver can do is to let it alone. However, it sometimes becomes necessary to disturb the setting, and when this happens the instrument may be readjusted, as follows:

1. Turn gasoline adjustment A to the right until it is completely closed.

2. Turn air adjustment B until end of the adjusting screw is exactly even with the point of the ratchet set spring above it.

3. Open gasoline adjustment A by giving needle valve one full turn to the left.

4. Start the motor as usual, if necessary allowing it to run for a few minutes with the air regulator button on the cowl board pulled part way out, until it is thoroughly warmed up, and air regulator can be pushed clear in.

5. With the spark retarded, turn gasoline adjustment A to the right, cutting down the amount of fuel until motor idles smoothly.

6. Advance the spark and turn air adjustment B to the left a little at a time, until motor begins to slow down, indicating that air valve spring is too loose. Then turn it back to the right just enough to make the motor run well.

To test the adjustments advance spark and open throttle quickly. The motor should accelerate instantly. If it misses or pops back open

gasoline adjustment A slightly by turning needle valve to the left. Do not touch air adjustment B again unless it appears absolutely necessary. The best possible adjustment has been secured when gasoline adjustment A is turned as far as possible to the right, and air adjustment B as far as possible to the left, without interfering with correct engine action.

Krice Annular Spray Carburetor.—This device, shown in section at Fig. 313, differs from the ordinary concentric float and mixing

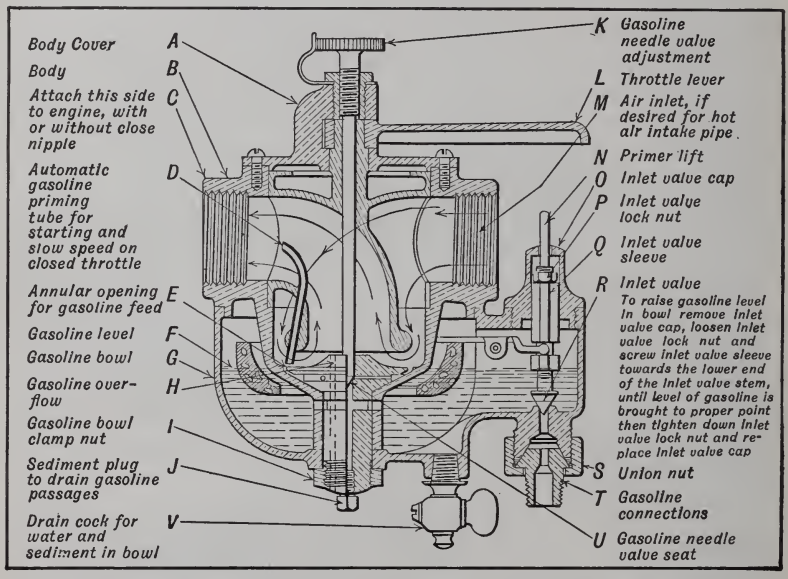

Body Cover A
Body B
Attach this side to engine, with or without close nipple C
Automatic gasoline priming tube for starting and slow speed on closed throttle D
Annular opening for gasoline feed E
Gasoline level F
Gasoline bowl G
Gasoline overflow H
Gasoline bowl clamp nut I
Sediment plug to drain gasoline passages J
Drain cock for water and sediment in bowl V
K Gasoline needle valve adjustment
L Throttle lever
M Air inlet, if desired for hot air intake pipe
N Primer lift
O Inlet valve cap
P Inlet valve lock nut
Q Inlet valve sleeve
R Inlet valve
To raise gasoline level in bowl remove inlet valve cap, loosen inlet valve lock nut and screw inlet valve sleeve towards the lower end of the inlet valve stem, until level of gasoline is brought to proper point then tighten down inlet valve lock nut and replace inlet valve cap
S Union nut
T Gasoline connections
U Gasoline needle valve seat

Fig. 313.—Sectional View of the Krice Annular Spray Carburetor.

chamber types only in the principle of supplying fuel vapor to the mixture. In most carburetors the method of delivering gasoline into the mixing chamber is by means of a spray or solid jet of gasoline controlled by a needle valve. In the accompanying half-section drawing is shown the application of the annular, or round spraying crevice, which, in fact, should hardly be called a spray device inasmuch as the gasoline as it emerges from this crevice, being only eight to ten thousandths of an inch wide, creeps up the side walls of the mixing chamber instead of being sprayed, and thus spreads the gasoline ready for fast vaporization. This action of the gasoline creeping up the wall of the mixing chamber in a Krice carburetor is very similar to wine as seen in a glass, for when slightly tilted the fluid will form a thin film on the glass and the bulk of it will form into drops and ooze

down slowly. Place a drop of gasoline on any smooth, flat non absorbent surface and another on the point of a pencil, nail, or other similar article. Blow the breath steadily over both. It will be seen that the gasoline on the flat surface will evaporate in a fraction of the time taken by the solid drop on the nail point. The solid drop of gasoline must be first broken up into fine particles, atomized and be converted into a vapor before it becomes an explosive gas. The method employed in the Krice annular spray carburetor is like that of the experiment of the gasoline on the flat surface. It accomplishes the same result much faster in vaporizing the gasoline, because it is spread over a large surface exposed to a column of rapidly passing air.

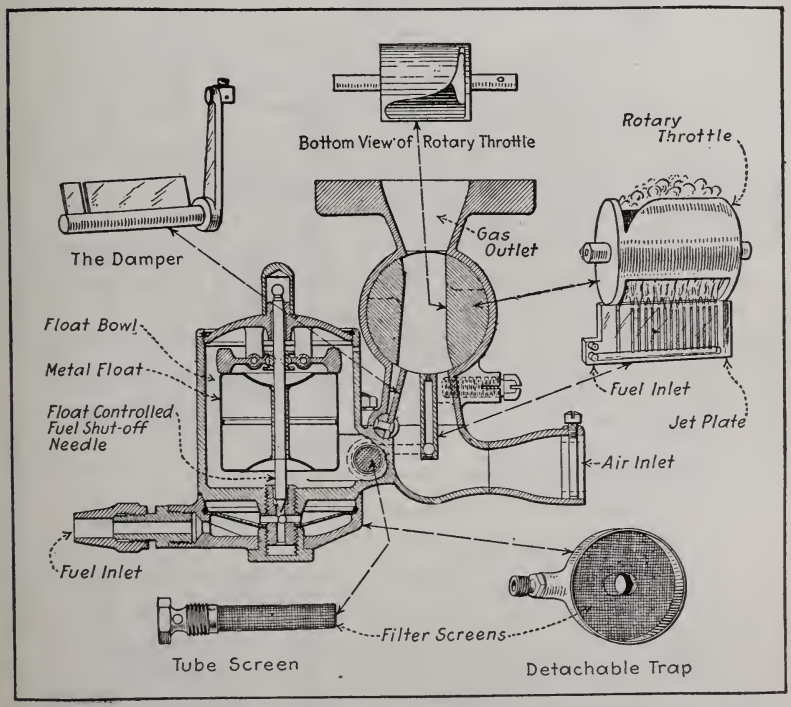


Fig. 314.—Sectional View Showing Construction of Important Parts of the Master Multiple-Jet Carburetor.

Note the arrows in the accompanying illustration. They show the direction of the air as it enters the carburetor and passes on into the mixing chamber and finally into the engine intake. It will be seen that the air is drawn around the mixing chamber in such a way that for a large interval of its passage the air comes in direct contact with the cup-shaped wall covered with a film of gasoline. Unlike the

process of gasoline vaporization used in other carburetors of the spray nozzle type and illustrated with the gasoline drop on the point of a nail, the Krice carburetor eliminates these features and instead the air in its passage is made to pick up a dry gas which is thoroughly mixed in its travel through the carburetor into the engine. It is claimed that through this method of carburetion a dry, thin mixture is instantly produced and forms an efficient gas for combustion with small fuel consumption.

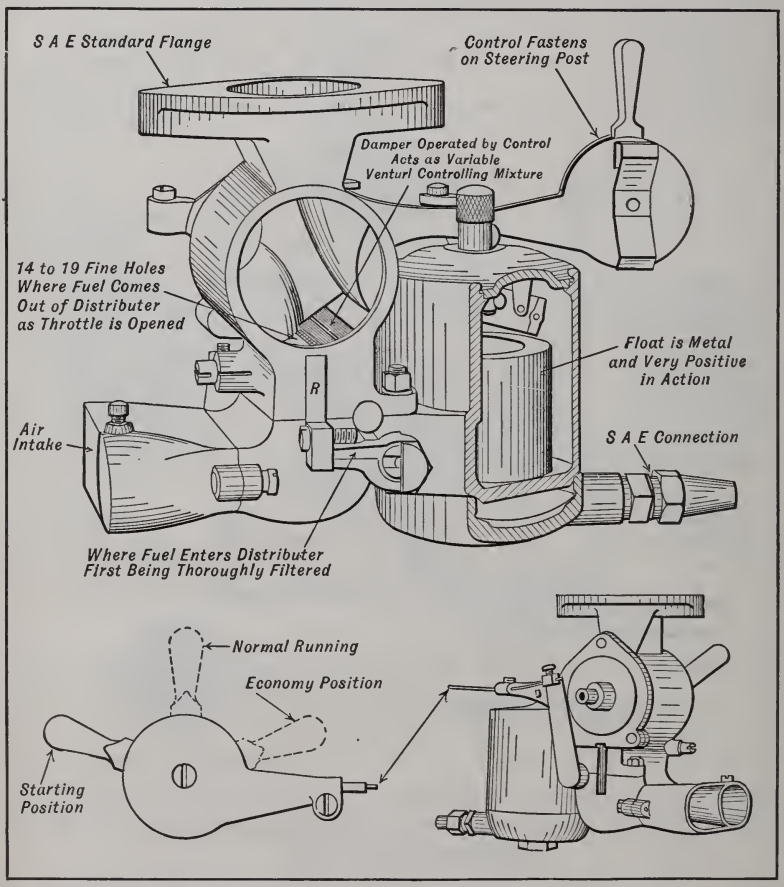

S A E Standard Flange
Control Fastens on Steering Post
Damper Operated by Control Acts as Variable Venturi Controlling Mixture
14 to 19 Fine Holes Where Fuel Comes Out of Distributer as Throttle is Opened
Float is Metal and Very Positive in Action
R
Air Intake
S A E Connection
Where Fuel Enters Distributer First Being Thoroughly Filtered
Normal Running
Economy Position
Starting Position

Fig. 315.—The Master Carburetor, a Popular Pattern on Racing Engines.

Master Multiple-Jet Carburetor.—This carburetor, shown in detail in Figs. 314 and 315, has been very popular in racing cars because of exceptionally good pick-up qualities. Its principle of operation is the breaking up of the fuel by a series of jets, which vary in number

from fourteen to twenty-one, according to the size of the carburetor. These are uncovered by opening the throttle, which is curved—a patented feature—to secure the correct progression of jets. The carburetor has an eccentric float chamber, from which the gasoline is led to the jet piece from which the jets stand up in a row. The tops of these jets are closed until the throttle is opened far enough to pass them, which it does progressively. The air opening is at the bottom, and the throttle opening is such that a modified Venturi is formed. The throttle is carried in a cylindrical barrel with the jets placed below it, and the passage from the barrel to the intake is arranged so that there is no interruption in the flow. For easy starting a dash-controlled shutter closes off the air, throwing the suction on the jets, thus giving a rich mixture.

The only adjustment is for idling, and once that is fixed it need never be touched. This is in the form of a screw and regulates the position of the throttle when at idling position. The dash control has high-speed, normal and rich-starting positions. In installing the Master carburetor the float chamber may be turned either toward the radiator or driver's seat. If the float is turned toward the radiator, however, a forward lug plate should be ordered; otherwise it will be difficult to install the control. The throttle lever must go all the way to the stop lug or maximum power will not be secured. In adjusting the idle screw it is turned in for rich and out for lean.

Utility of Gasoline Strainers.—Many carburetors include a filtering screen at the point where the liquid enters the float chamber in order to keep dirt or any other foreign matter which may be present in the fuel from entering the float chamber. This is not general practice, however, and the majority of vaporizers do not include a filter in their construction. It is very desirable that the dirt should be kept out of the carburetor because it may get under the float control fuel valve and cause flooding by keeping it raised from its seat. If it finds its way into the spray nozzle it may block the opening so that no gasoline will issue or may so constrict the passage that only very small quantities of fuel will be supplied the mixture. Where the carburetor itself is not provided with a filtering screen a simple filter is usually installed in the pipe line between the gasoline tank and the float chamber.

Some simple forms of filters and separators are shown at Fig. 316. That at A consists of a simple brass casting having a readily detachable gauze screen and a settling chamber of sufficient capacity to allow the foreign matter to settle to the bottom, from which it is drained out by a pet cock. Any water or dirt in the gasoline will settle to the

bottom of the chamber, and as all fuel delivered to the carburetor must pass through the wire gauze screen it is not likely to contain impurities when it reaches the float chamber. The heavier particles, such as scale from the tank or dirt and even water, all of which have greater weight than the gasoline, will sink to the bottom of the cham-

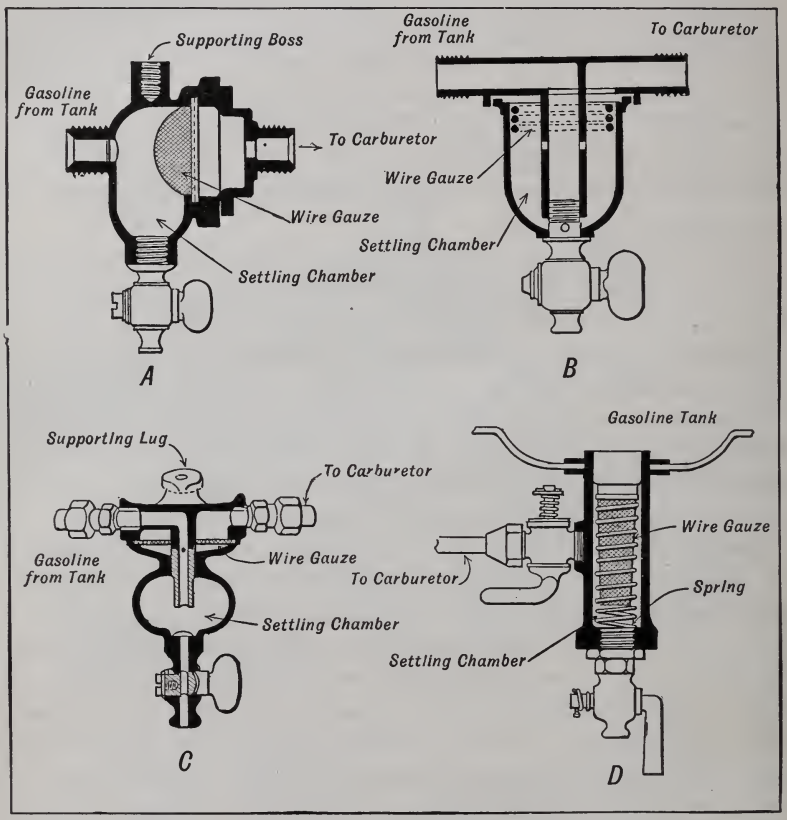


Fig. 316.—Types of Strainers Interposed Between Vaporizer and Gasoline Tank to Prevent Water or Dirt Passing into the Carbureting Device.

ber, whereas light particles, such as lint, will be prevented from flowing into the carburetor by the filtering screen.

The filtering device shown at B is a larger appliance than that shown at A, and should be more efficient as a separator because the gasoline is forced to pass through three filtering screens before it reaches the carburetor. The gasoline enters the device shown at C through a bent pipe which leads directly to the settling chamber and from thence through a wire gauze screen to the upper compartment

which leads to the carburetor. The device shown at D is used on Chalmers motor cars and is a combination strainer, drain, and sediment cup. The filtering screen is held in place by a spring and both are removed by taking out a plug at the bottom of the device. The shut-off valve at the top of the device is interposed between the sediment cup and the carburetor. This separating device is incorporated with the gasoline tank and forms an integral part of the gasoline supply system. The other types shown are designed to be interposed between the gasoline tank and the carburetor at any point in the pipe line where they may be conveniently placed.

How Kerosene May be Utilized.—The carburetion of kerosene seems to be partially solved at the present time, and there are several forms of carbureting devices which permit one to utilize this fuel. It is important that the vaporizer employed be one that can be readily adapted to present day forms of motors. It is a fact that with lower grade fuels, as kerosene or benzol, a motor of lower compression than one can use successfully with gasoline and some means for heating the entering mixture are needed. When kerosene is used as fuel the conditions are similar to those which obtain with gasoline except the temperature at which vaporization commences. The heavier liquid requires more heat to cause it to vaporize, it being necessary to preheat kerosene to about two hundred degrees Fahrenheit before it will evaporate and form a mixture with air. It is necessary to provide a heated passage to further vaporize the mixture as it leaves the spray nozzle and as direct an entrance to the motor should be provided as possible. It is necessary to maintain a high velocity of the kerosene vapor in order to prevent condensation.

The carburetor depicted at Fig. 317 is an early Holley form adapted to use kerosene. It consists of a conventional form concentric jet, float-feed vaporizer, to which the kerosene is fed at the lower end and a mixing chamber having an auxiliary air valve is carried at the upper end of the device. In connection with this appliance a simple form of gasoline vaporizing valve is mounted at the upper end near the gas outlet, and is used to supply mixture enough to promote easy starting of the motor. The exhaust gases from the motor are passed through a jacket which surrounds the mixture tube leading from the kerosene vaporizer and which goes through the float bowl to heat the fuel therein.

The liquid in the fuel container is heated to about two hundred degrees before it is sprayed in the motor, and it is contended that if kerosene is kept near its boiling point it will leave the spray nozzle just as readily as gasoline will at ordinary temperature. It would be

extremely difficult to start an engine on kerosene unless the vaporizing device was raised in temperature to a point that would permit of ready vaporization of fuel. In the device shown at Fig. 317 if the

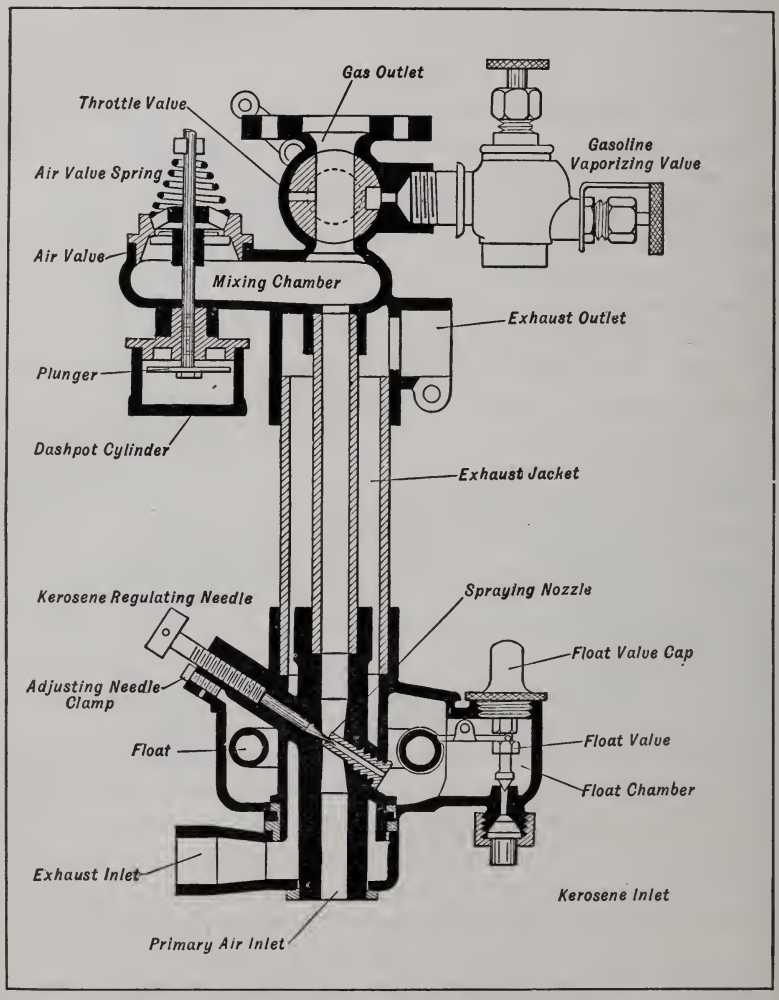


Fig. 317.—Combined Gasoline and Kerosene Carburetor of Holley Design. May be Used with Either Fuel.

motor is to be started cold the mixture supplied by the gasoline vaporizing valve is directed into the cylinder by a three-way valve which closes off the kerosene compartment and provides a by-pass for the gasoline mixture through the gas outlet. After the engine has run

for a time, usually two or three minutes, the kerosene vaporizer has been raised in temperature to the proper point and a shift from one fuel to another is easily made by throwing the three-way valve over so that the gasoline vaporizer is shut off from the gas outlet and direct communication is provided by the large opening in the throttle valve between the motor cylinder and the mixing chamber of the kerosene carburetor.

Compound Manifolds.—When kerosene vapor is used with the usual type of induction manifold it is liable to condense if conditions are unfavorable to rapid volatilization. This "loading up," as it is called, is due to the low velocity and temperature of the mixture which passes through comparatively large passages, and while it can be reduced to a certain extent by making the area of the manifold cross section smaller, this is not desirable, because at high speeds it would not be possible to supply an adequate amount of mixture to the cylinders unless the full cross section of the intake pipe is used. To minimize condensation the combination manifold construction shown at Figs. 318 and 319-B has been recommended. This consists of

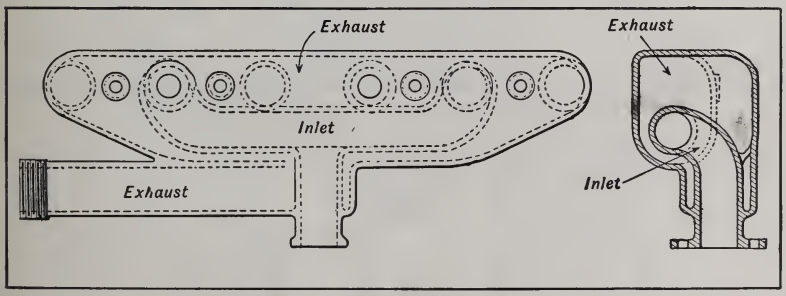


Fig. 318.—Combined Intake and Exhaust Manifold Suggested as Suitable for Use with Kerosene and Air Mixture. The Hot Exhaust Gases Heat the Inlet Pipe Walls and Produce More Perfect Vaporization.

forming the intake and exhaust manifold in one casting, the thought being to heat the inlet manifold by the hot inert products of combustion to such a point that the kerosene vapor would be turned into a gas and all liquid particles vaporized. It is recommended that a manifold of this type be used in connection with carburetors using low-grade fuel. Even when gasoline is used it is considered good practice to use water-jacketed manifolds as shown at Fig. 319-A and in illustrations at Figs. 320 and 321. The hot manifold assists in vaporizing any globules of liquid that may be present in the mixture and makes a drier gas.

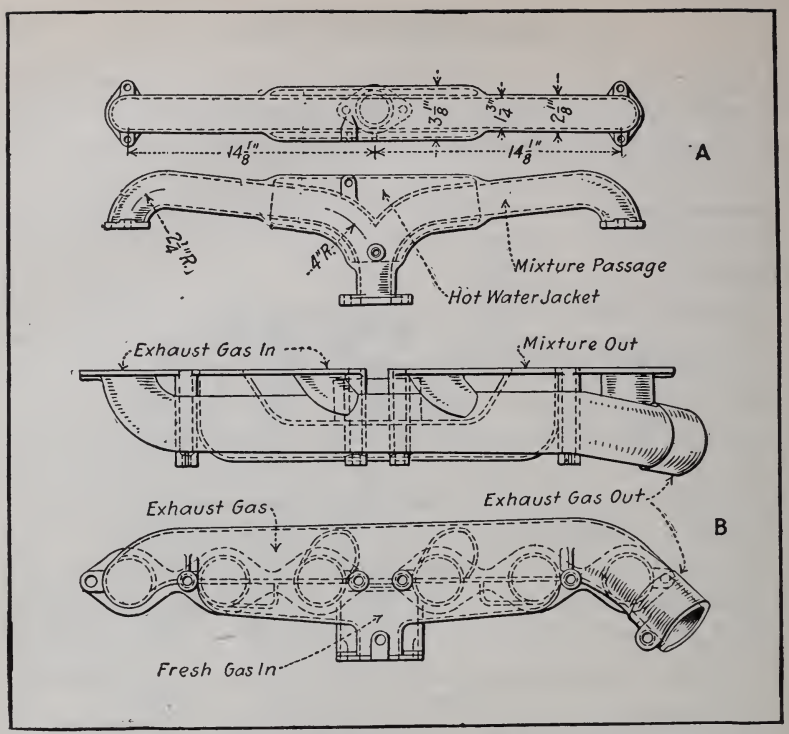


Fig. 319.—Water-Jacketed Inlet Manifold at A and Exhaust Gas-Heated Inlet Manifold at B Facilitate Vaporization of Low-Grade Fuel.

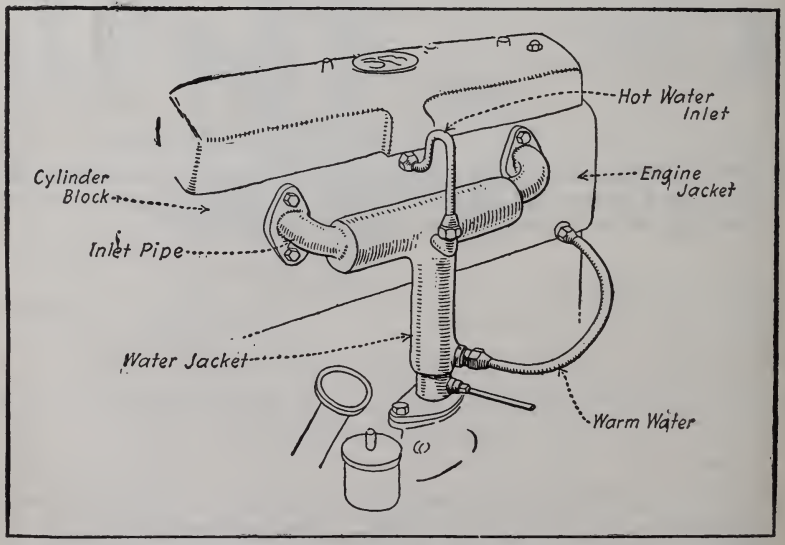


Fig. 320.—Showing Application of Water-Jacketed Inlet Manifold on Scripps-Booth Engine.

It is stated that the heated vapor from the kerosene vaporizer with its quota of air comprises about one-fourth of the total volume of the charge, the balance of the air being supplied by the auxiliary valve at the top of the kerosene vaporizer. When the proper degree of compression obtains in the motor and the kerosene is properly heated before attempt is made to vaporize it, the action of the carburetor described is claimed to be very similar to that of a gasoline vaporizer.

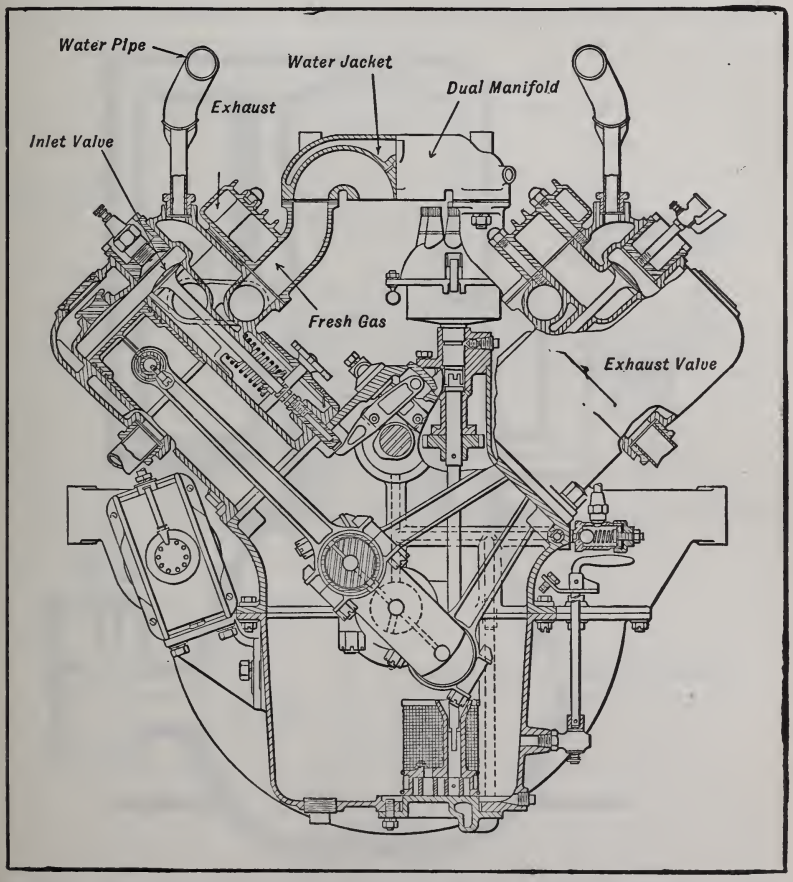


Fig. 321.—End Sectional View of Peerless Eight-Cylinder V Motor, Showing Dual Water-Jacketed Manifold.

It is claimed that it is possible to convert the usual gasoline motor by adding a spacer of proper thickness under the cylinder to reduce the compression to the point where kerosene can be used successfully. The degree of compression recommended as most suitable for use with kerosene vapor furnished by a carbureting device is between fifty and

sixty pounds a square inch. Another important consideration is that the initial heating of the motor parts by use of gasoline gas be complete before one attempts to use kerosene. If the heavier liquid is supplied to the engine before the carburetor has been raised to the proper degree of temperature, poor combustion of kerosene results and carbon deposits, or gummy residue, is deposited in the interior of the combustion chamber.

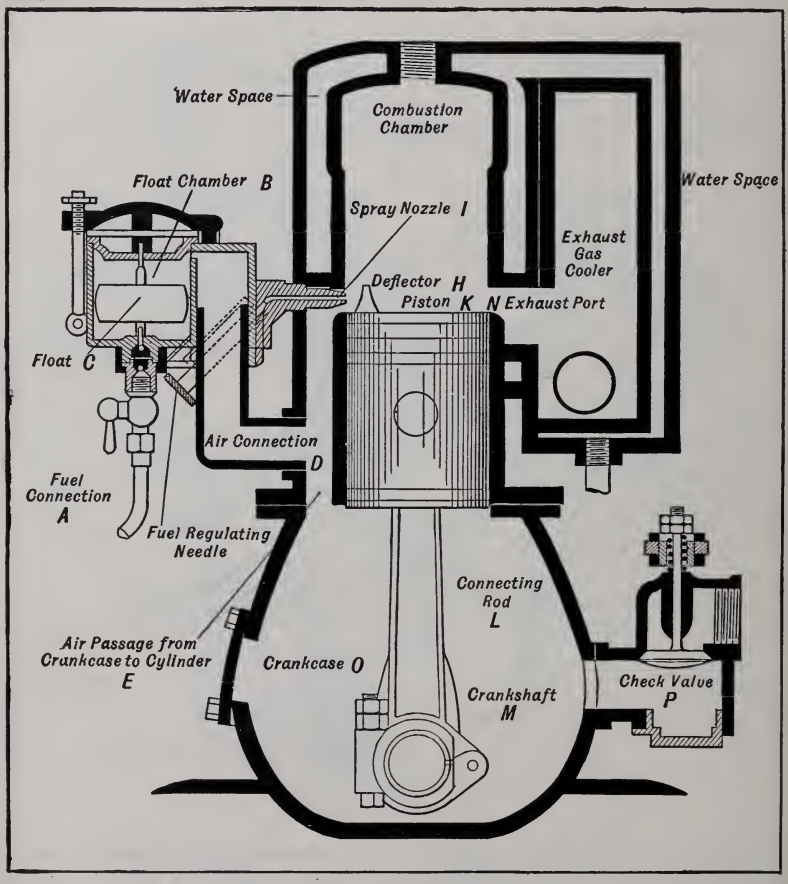


Fig. 322.—Showing Two-Cycle Motor, with Device for Direct Injection of Heavier Petroleum Distillates into Cylinder.

Supplying Kerosene by Direct Injection.—The most logical method of utilizing fuels which have a low vaporizing point and which must be raised in temperature before they will give off vapor is to supply to the motor cylinder by direct injection. Several types of stationary

power plants and some used in marine applications have been designed to use the cheaper fuels which cost less than gasoline, such as kerosene, benzol, or crude oil. The view at Fig. 322 is a section through a Detroit two-port two-cycle engine which has been adapted to use kerosene by direct injection. The engine is of the conventional pattern, having an automatic inlet valve at the side of the crank case to admit air on the upward stroke of the piston. If this engine was used with gasoline the carburetor or mixing valve would be attached to this check valve cage and the engine would operate on the two-port principle.

In the design under discussion the fuel supply device consists of a float feed arrangement attached to a spray nozzle placed in the transfer port in such a way that it discharges the fuel against the deflector plate on the piston top. The float keeps the kerosene level in the float chamber to a height equal to the point of the spray jet. The amount of kerosene supplied can be regulated by the usual needle valve which controls the nozzle opening.

Assume for the purpose of making the explanation clearer that the cylinder is full of fresh gas and that the piston is traveling upward. It will close the transfer passage and the exhaust port and will compress the charge above it. As the piston continues to move upward a vacuum is created in the crank case O which draws in a current of air through the spring-controlled automatic valve P, and fuel into the fuel-feeding chamber. At the top of the compression stroke the gas is ignited by an electric spark and the resulting explosion causes a downward movement of the piston. As this member moves toward the end of its stroke the air in the crank case and the fuel-supply chamber is under compression. As the exhaust port is uncovered by the piston as it continues to go down the inert products of combustion, which have a pressure of forty to fifty pounds per square inch, stream out of the open port until but a very small portion of burned gas which is at atmospheric pressure remains at the cylinder.

As the piston continues to move down it uncovers the spraying nozzle I. The compressed air in the crank case rushes into the cylinder F and strikes the deflector H which directs it to the top of the cylinder and drives before it the remainder of the burned gases out of the open exhaust port. Simultaneously with this function the pressure in the fuel chamber B relieves itself by spraying a stream of fuel through the nozzle I. As this stream of liquid strikes the hot deflector plate it is immediately vaporized, and as it is in the center of the incoming air stream it mixes with it to form an inflammable mixture.

A disadvantage of this method of fuel injection is that it does not

provide for the flexibility of engine action which is so essential in automobile service. This disadvantage does not militate against it to any great extent in stationary or marine application where the motor speed does not need to be varied within a wide range and where constant speeds are more often used. This method of automatic fuel injection is not practical when a four-cycle engine is used, and if fuel is to be supplied in this manner a small plunger pump driven by the engine is usually employed to force it into the combustion chamber under considerable pressure.

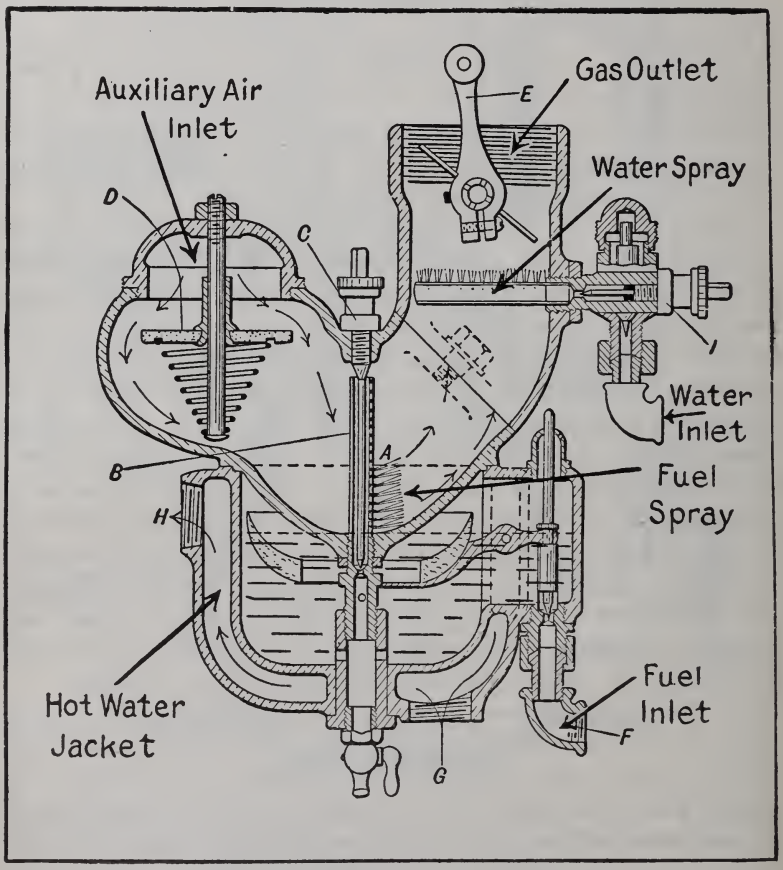


Fig. 323.—Sectional View of Typical Kerosene Vaporizer Employing Water Spray to Insure Against Preignition.

Action of Kerosene Vaporizer Utilizing Water Spray.—In order to insure proper combustion of kerosene when used in carburetors of the conventional form, it is necessary to start the engine on gaso-

line, until all parts are thoroughly heated. If proper means are taken to heat the carburetor and the intake manifold to prevent condensation of kerosene, it may be used just as soon as the various working parts have been properly heated. A float feed carburetor of conventional design arranged to burn kerosene is shown at Fig. 323. It will be noted that the float chamber is surrounded by a jacket, through which hot water can enter at G and pass out at H, this heating all parts of the float chamber. The kerosene enters the device through the connection F and passes into the float chamber through the usual form of float-controlled valve.

In the ordinary automatic carburetor, as the speed increases and the tendency is to draw in more fuel, an automatic air valve opens to admit an auxiliary supply of air to dilute the vapor. The carburetor illustrated utilizes the auxiliary valve in a different manner. The spray nozzle, instead of being the conventional form, is a small standpipe having numerous fine holes on one side and it is called a spray turret. At the bottom of the spray member the float bowl upper wall is shaped in such a way that a small pool of liquid fuel is allowed to collect in the bottom. The main air intake is divided and is alone sufficient only to run the motor idle. The air that enters the primary intake passes directly over the pool of fuel and a rich mixture is obtained for starting on. The auxiliary air enters through the opening D, and before it enters the cylinders it must pass the spray turret. This lifts the fuel up in the standpipe, where it is drawn through the small holes in the form of a spray. The greater the amount of air that is passing through, the higher the fuel rises in the spray turret, until with the throttle wide open it is sprayed from all the holes in the standpipe. The condition with a partially opened throttle is shown in sectional view and it will be noticed that the kerosene spray is coming through only the holes at the lower part of the standpipe. The amount of liquid sprayed into the mixture is regulated by the needle valve C. In order to burn kerosene successfully water is introduced into the mixture through the auxiliary spray nozzle I. This supplies an extra amount of oxygen and insures a more complete combustion of the kerosene vapor than would be the case if just air was used.

Another Holley Kerosene Carburetor.—At this time a number of kerosene carburetors have been evolved and some have received practical application on various makes of cars. The carburetor shown at Fig. 324 is a late design by George M. Holley and is intended to be used in connection with kerosene after the motor has been started by means of the auxiliary gasoline vaporizer which is shown

at Fig. 325. Speaking of kerosene carburetors in general and the Holley device in particular, the inventor has offered the following facts:

"As a commercial proposition, the four most striking features of the kerosene carburetor are: First, the low cost of fuel, which at

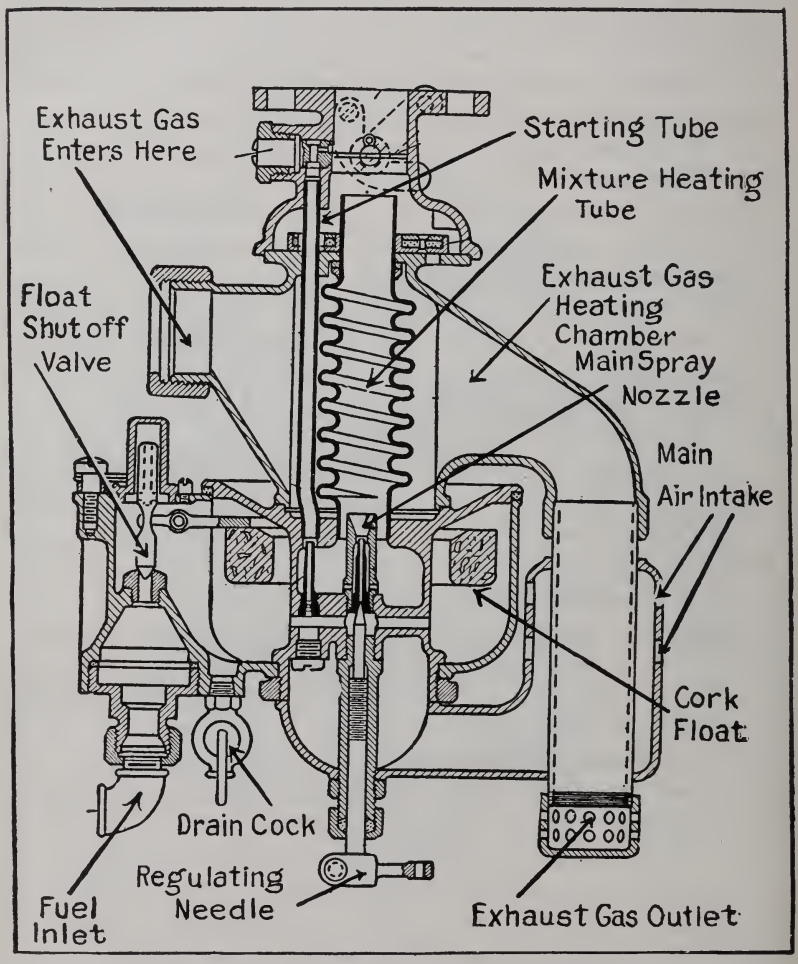


Fig. 324.—Improved Form of Holley Kerosene Vaporizer.

present averages one-half as much as with gasoline. With a car using gasoline at the rate of one gallon per twenty miles, with gasoline costing 18 cents, the cost for fuel is .90 cent per mile. With a car using kerosene at the rate of one gallon for twenty miles, with kero-

sene costing 9 cents, the cost of fuel is .43 cent per mile. This makes the fuel cost 52% lower with kerosene than with gasoline. Second, increased power, ranging in value from 5% to 8%. Third, a saving of about one-half in the amount of lubricating oil required, as kerosene is itself a lubricant. Fourth, less spark-plug trouble on account of kerosene carbon being drier and finer than that deposited from the gasoline combustion.

"Its two most serious deficiencies would seem to be the necessary use of two fuels, one sufficiently volatile to permit the motor to start when cold, and the other, or cheaper, for regular running after the engine has become heated. There is also the necessity, if a kerosene carburetor is applied to automobile motors already manufactured, of reducing the compression to 40 pounds to prevent knocking under extreme conditions. It requires but a few minutes' operation to heat an engine sufficiently on gasoline so the kerosene vaporizer may be

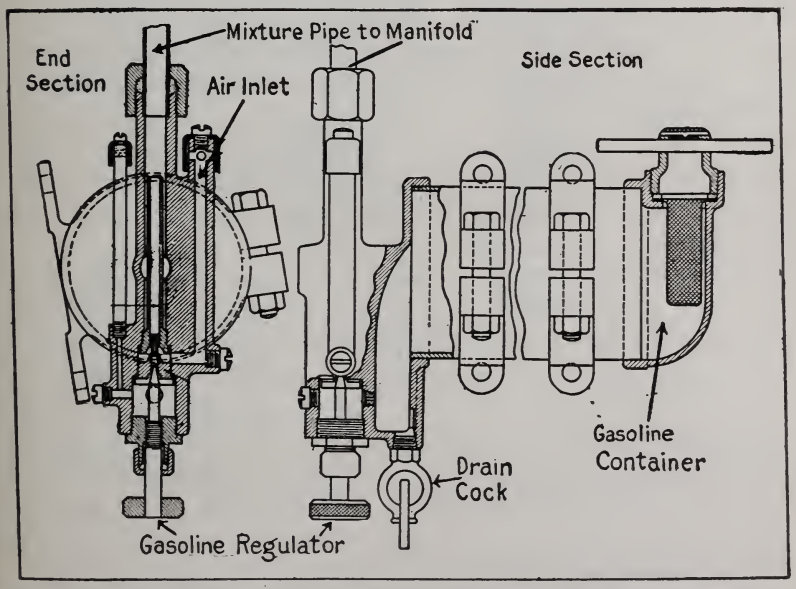


Fig. 325.—Gasoline Carburetor and Container Used in Connection with Holley Kerosene Vaporizer for Starting Purposes.

used. The starting device which is shown at Fig. 325 consists of a floatless gasoline carburetor with a starvation type atomizing nozzle at one end. The device is controlled from the dash and works in connection with the kerosene carburetor, which is always in action. When starting, about 75% of the mixture supplied is gasoline vapor,

and as the throttle of the kerosene carburetor is opened, as in driving a car, this proportion is decreased according to the throttle opening, so that at driving speeds, even when starting from a standstill, 50% of the mixture is kerosene vapor and the balance gasoline gas. This starting device accomplishes two things, prompt starting and absolute prevention of smoking in starting. After the engine has been run for several minutes on the mixture of gasoline and kerosene vapor, the gasoline shut-off valve may be closed and the kerosene carburetor only employed to supply the mixture.

"The kerosene carburetor is primarily a vaporizer, as the heat of the exhaust is utilized to convert atomized kerosene into a true vapor. The exhaust gas enters a jacket which is disposed around a spiral mixture heating tube and is discharged to the air through a pipe having a number of fine holes at one end. In order to insure that only warm air will be taken into the mixture, the main air intakes are in a pipe which surrounds the exhaust pipe serving as an outlet from the exhaust gas jacket. The mechanism of the float is practically the same as in a gasoline carburetor, as the float-controlled lever regulates the amount of fuel admitted so that a certain level is maintained at all times. When the engine is running with the throttle valve practically closed a rich mixture is supplied through a small auxiliary jet placed at one side of the main spray nozzle. As the throttle is opened the mixture from the main spray nozzle flows through the corrugated mixture heating tube, which is constructed in that form so as to obtain the greatest possible heated surface for a given length. An auxiliary air-valve is provided which surrounds the top of the mixture heating tube, which is closed on low throttle, but which opens to admit auxiliary air supply to the mixture as the suction increases. The amount of kerosene sprayed through the main nozzle may be adjusted by a regulating needle valve at the bottom of the carburetor. It is believed practical at the present time to equip any automobile with this type of kerosene carburetor if the user does not object to handling an accessory in the form of a gasoline starter."

The objectionable pounding which is present at certain times when kerosene is employed is considerably minimized by the use of the water spray, as in the device shown at Fig. 323, A, or by admitting a small portion of the exhaust gases into the mixture through a by-pass from the exhaust pipes to the mixture pipes. It is claimed that either of these methods will eliminate the knocking sounds without lowering the compression and, consequently, the thermal efficiency of the motor.

Bi-Fuel Carburetors.—A form of carburetor which is being experimented with abroad is shown at Fig. 326. This is known as the bi-fuel, because two independent float chambers and spray nozzles are provided, one being utilized for gasoline, the other for kerosene. In order to vaporize the heavy fuel mixture a portion of the hot water from the cylinder jacket is by-passed through a chamber in which the mixture heating tubes are placed as outlined in the sectional view.

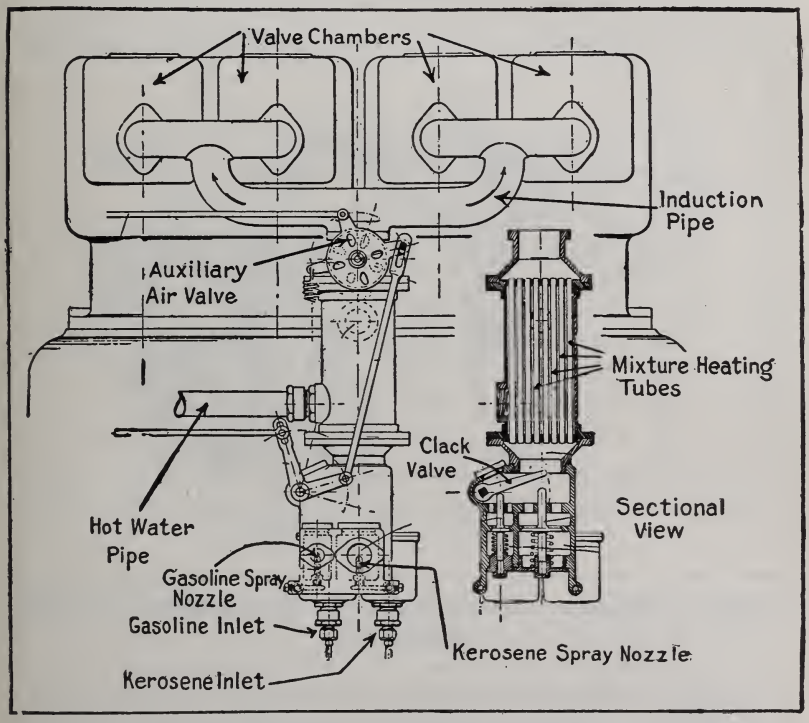


Fig. 326.—A Bi-Fuel Carburetor of English Design.

Two throttle valves of the spring-control poppet type are provided and are operated by means of an auxiliary lever or clack valve which is adapted to depress the throttles from their seats in order to permit the mixture to flow from the spray nozzle to the mixture heating tubes. Auxiliary air is admitted into the mixture by an oscillating shutter valve placed at the top of the carburetor just below the inlet manifold.

An American bi-fuel carburetor, which consists of two independent carburetors joined to a valve fitting so either one may be connected

to the inlet manifold, is shown at Fig. 327. A water injector attachment is provided on the kerosene carburetor.

Schebler Water Attachment.—The Wheeler and Schebler engineers, in speaking of the water-feed attachment for a simple Schebler type carburetor shown at Fig. 328, say:

"Many years of experience and experiments have proven to us that the successful use of kerosene is not a problem of the carburetor alone, but involves both the carburetor and a proper design of motor. It is absolutely necessary and must be understood that kerosene can

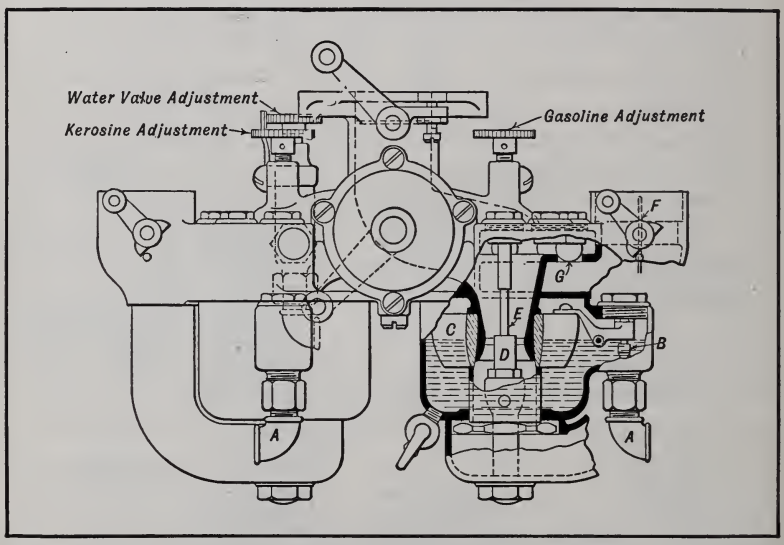


Fig. 327.—The Kingston Double Carburetor for Use with Either Low or High Grade Fuel.

only be burned with the application of the proper amount of heat to the manifold. It is also advisable on some sizes of motors to heat the incoming air to the carburetor, and we find that it rarely occurs that too much heat can be applied to the air supply. The intake manifold must be kept as hot as possible, preferably by the exhaust heat, for if heat is not applied there will be a precipitation on the walls of the manifold. Heat on the manifold has two objects: First, to aid evaporation of the heavier parts of the fuel; second, to neutralize the refrigeration produced by the evaporation, so that the incoming change of gas introduced into the motor is in an intimate mixture and at a uniform temperature. Users of kerosene have always found it advisable to use water to prevent pounding under heavy loads, and also, water injection prevents excessive deposits of carbon.

In our water or kerosene throttle attachment, there is a small drill hole in the carburetor side of the throttle, through which may be introduced a stream of water controlled by any suitable type of needle valve. While the motor is pulling a load this needle valve which controls the supply of water from any suitable source should be opened only sufficiently to remove the pound. When motor is stopped water must be shut off. The motor must be started and warmed up on gasoline and then can be switched over to kerosene."

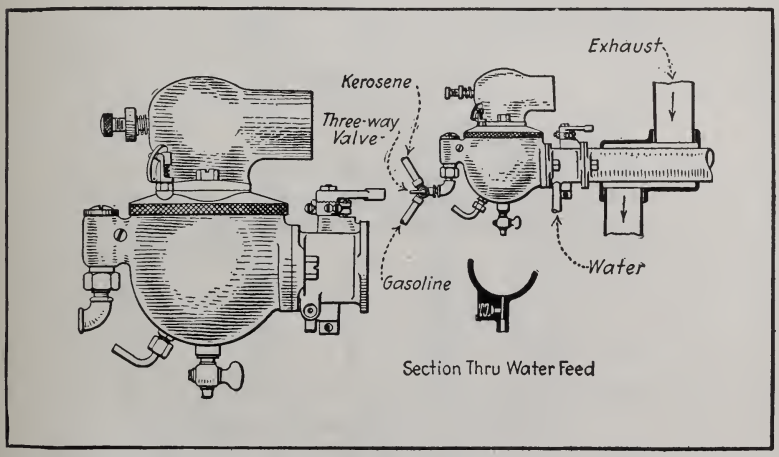


Fig. 328.—Showing Application of Water Attachment to Shebler Carburetor to Permit Use of Low Grade Fuel.

Bennett Kerosene Carburetor.—The Bennett carburetor, shown at Fig. 329, is now being used on a great number of tractors as standard equipment, and this instrument is constructed to take care of the peculiar heat requirements of kerosene. Briefly, heat is applied at two places. The main air has a variable temperature, decreasing as the load increases. The sprayed kerosene, mixed with the main air, then passes through a chamber which is kept at a fairly constant, high temperature by the exhaust, and after this cold air is added in quantities depending upon the suction prevailing at the moment. The following description is taken from the *Automobile:*

"Referring to the sectional drawing, the air enters at A, passes around the pipe E, which is the outlet for part of the exhaust of the engine, and gets beneath the nozzle through the holes B. Then the air passes upward through vertical holes around the jet and up into the chamber C. This chamber is surrounded by the exhaust gas entering at E and passing out at E-1. D is not a valve, but merely a

bridge piece, so the air mixed with the sprayed kerosene goes from C directly to the throttle.

"As soon as the suction increases, as when the throttle is opened, the flat valve F begins to lift. This operates the lever G and raises the spindle H, thereby enlarging the kerosene nozzle, which is adjustable for permanent setting by the threaded needle valve K.

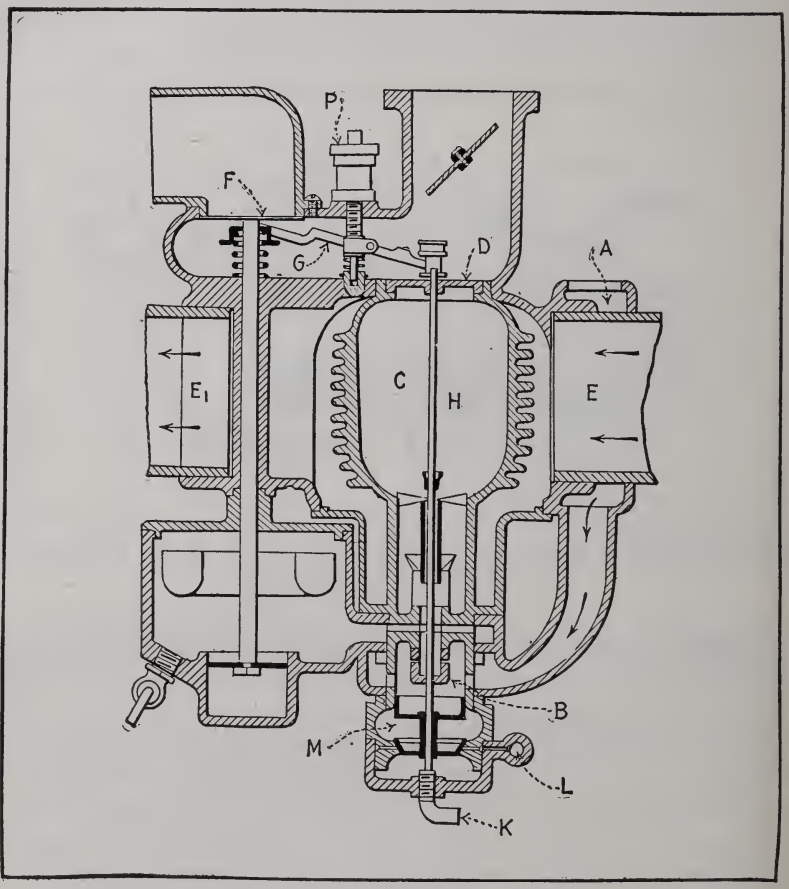


Fig. 329.—Sectional View of the Bennett Kerosene Carburetor.

"Now, right at the bottom of the carburetor there is a small hole L, which lets in air under the little double piston M, and when the suction is strong enough, the double piston lifts and so closes the holes B. When the piston has risen high enough to close the holes B, the hot air is cut off altogether by the rim of the upper part of the piston, but enough cold air to spray the fuel enters through L and

gets to the nozzle through holes in the head of the upper part of the double piston. It will be noticed that the air valve F has its stem carried down into a kerosene well at the bottom of the float chamber, this acting as a dashpot. Also adjustment of the amount of expansion of the fuel jet in proportion to the air valve lift can be made by the screw P. The effect of these different mechanisms is that, at low speeds, the hot air starts the vaporization of the kerosene, which is completed by contact of the mixture with the hot walls of the chamber C. When the engine is running hard the chamber would get so hot that cracking might occur, therefore the hot air supply is cut off to allow the original mixture to enter C while cold. Actually in normal working it is stated that the gas leaves the carburetor at the throttle at 230 degrees Fahrenheit when idling and at 110 degrees Fahrenheit when at full load.

"So far this carburetor has not been applied to automobile work, but exclusively to tractors, where it is in use on engines with two and four cylinders. Of course the idling speed of a tractor engine is higher than that of an automobile motor, and the maximum speed is much lower, which means that the range is smaller, but the principles of the Bennett carburetor seem so closely in accord with theory that it should not be difficult to design a modification which would suit automobiles. For starting purposes gasoline is fed to the carburetor instead of kerosene, a small tank of the lighter grade fuel being carried for this purpose. With most engines a few minutes' running heats the vaporizing chamber sufficiently to allow a change over to be made to kerosene. In operation on tractor engines the Bennett carburetor gives full flexibility and there seems to be no smoke at low speeds, the engine idling just as well, when warm, on kerosene as on gasoline. On opening the throttle there is no hesitation or choking, the engine gets away without any symptom to show that the fuel is of heavy grade."

Good Kerosene Vaporizer.—A recently devised vaporizer, which has been tested by Prof. Lucke of Columbia University and described by him in a paper read before the S. A. E., is shown at Fig. 330. The Good vaporizer uses a heating device which consists of a very long Venturi contained within the exhaust header. This Venturi is made as long as the design of the header permits, and mixture is fed to this Venturi by an ordinary carburetor. This naturally delivers a very wet and unsatisfactory sort of gas, but this is changed to a warm dry mixture at the far end of the vaporizing tube, whence it is taken directly to the intake header. In the section shown in Fig. 330 it will be noticed that the intake manifold is arranged directly beneath

the exhaust, so that the gas does not have to pass around the cylinders in order to get to the intake valves. Dr. Lucke states that this assembly permits precisely the same delicacy of throttle control and as good idling as can be had with gasoline. An essential feature is the placing of the throttle between the spray nozzle of the carburetor and the vaporizing Venturi. The effect of the throttle is to disturb the nature of the gas and of the heated Venturi to remove the effects of such disturbance. One of the main virtues of the Good instrument is the great length of the Venturi, because this permits a very high

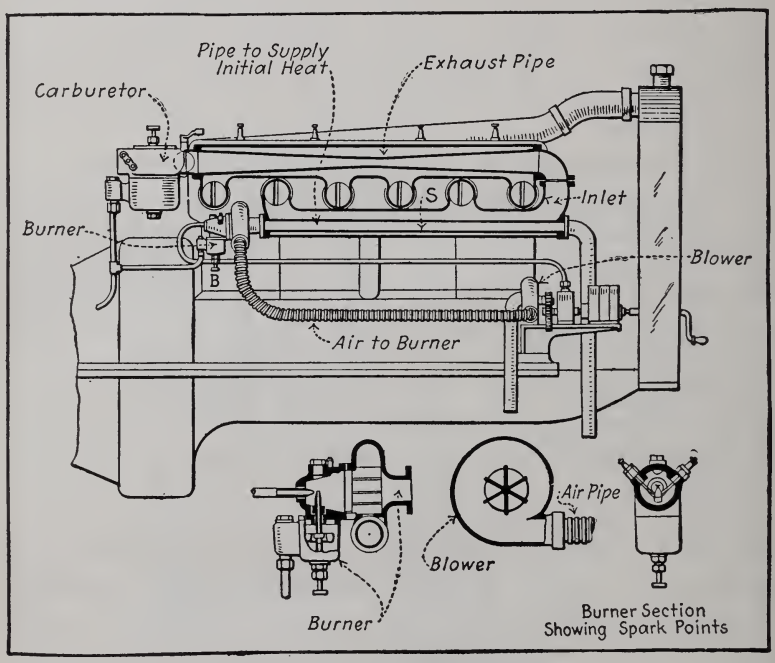


Fig. 330.—The Good Kerosene Vaporizer Outfit.

velocity in the front, while it does not cause the great drop of pressure and therefore limit the possibility of cylinder filling.

The most interesting feature of the Good system is that it permits an engine to be started up exactly as though it were operating on gasoline. Passing through the intake manifold from end to end is a small tube of thin steel. At the end of this is a burner fed with kerosene sprayed by a small electric blower and ignited by a series of sparks which can be provided either by a magneto or by a battery fitting. Dr. Lucke says that this vaporizing tube will attain a red heat in fifteen seconds, and when in this condition it will vaporize

any mixture reaching the intake manifold to a sufficient extent to enable the engine to be started and to permit it to fire regularly until the main Venturi heats up. The burner operates so quickly that the whole engine and the burner can be started simultaneously. If the engine is cranked with the ordinary self-starter and the blower is in operation simultaneously the time taken to start is, according to Dr. Lucke, the same as that required for starting with heavy gasoline in cold weather. It is best, however, to arrange to control the blower independently so that it can be started by pressing a button a few seconds before the main engine is cranked. By this means the deposition of kerosene in the intake manifold or in the cylinders is prevented. Dr. Lucke says that with this device there is no smoke and little carbon accumulation and that the operator would never know that he was using kerosene except that in cold weather he would have less starting trouble than he now experiences with gasoline.

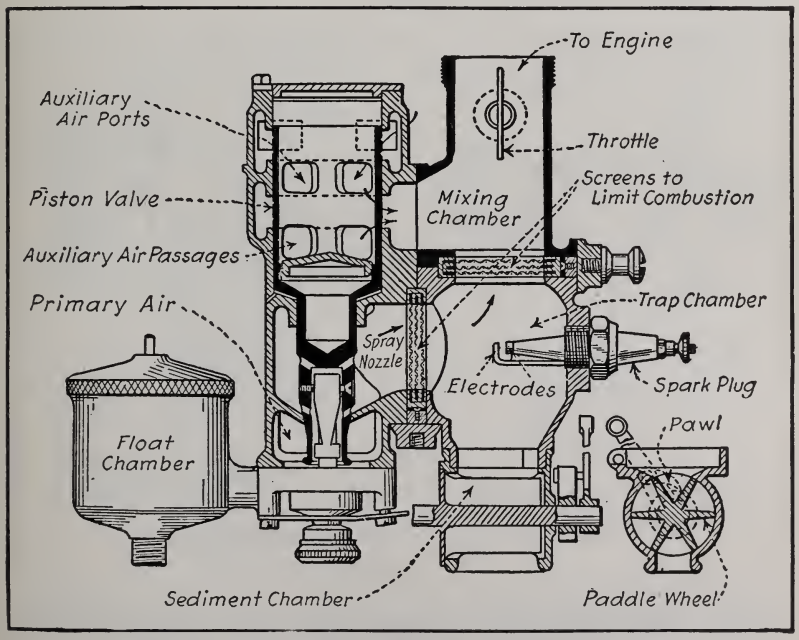


Fig. 331.—Partial Combustion Type Kerosene Carburetor.

Partial Combustion Type Carburetor.—Another method of starting an engine directly on kerosene is by using a partial combustion type carburetor, such as shown at Fig. 331, which produces what is known as a " fog " mixture. The type shown forms the subject of an English patent. The kerosene spray is drawn through a screen interposed

between the spray nozzle and the trap chamber, and when starting the engine cold a series of sparks from the ignition apparatus fires the vapor in the trap chamber. Combustion is very slow, however, and flaming gas is always present in the trap chamber as long as the engine runs. This converts the most of the kerosene vapor into a "fog," which is diluted with air through the auxiliary air valve ports to form a gas which will burn easily in the engine cylinders. The screens in the intake and outlet ports of the trap chamber limit combustion and only a very small part of the vaporized kerosene is used to furnish heat to convert the remainder into fog. A self-cleaning sediment chamber, composed of a paddle wheel, pawl actuated, discharges the tarry residue which collects from the imperfect combustion in the trap chamber. The carburetor cannot back-fire into the primary mixing chamber in which the spray nozzle is carried because of the combustion limiting screens. These are so arranged that they may be easily removed for cleaning.

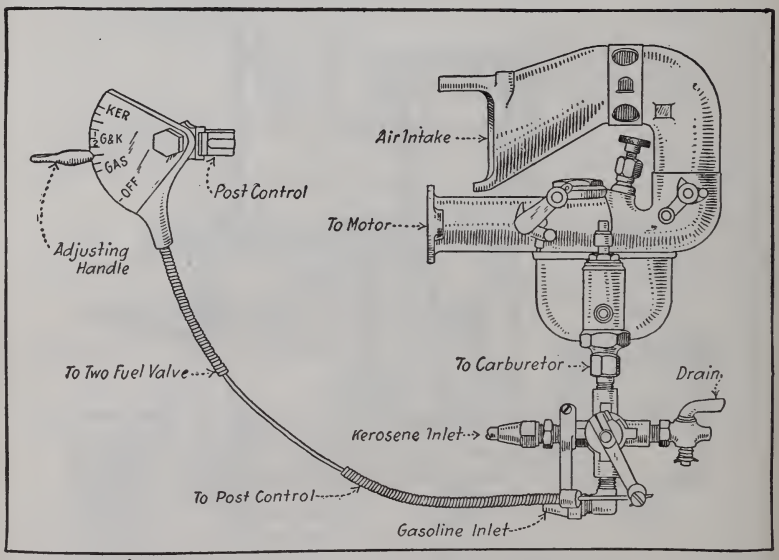


Fig. 332.—Simple Control Valve to Permit Mixing High- and Low-Grade Fuels or to Use Either Gasoline or Kerosene Alone.

Fuel Mixing Valve.—The fact that almost any of the present designs of gasoline engines can run satisfactorily on mixtures of gasoline and kerosene after the engine heats up is taken advantage of by the designer of the simple valve and steering post control, which can be attached to any standard carburetor and shown at Fig. 332. Two

tanks are needed, one for gasoline, the other for kerosene. Each tank is connected to the proper point on the mixing valve attached beneath the float chamber. The kerosene inlet can be entirely closed off and the engine started on the volatile fuel. After it has become heated up some kerosene may be mixed with the gasoline, and it is said that half-and-half mixtures work very well in a hot motor, but as the proportions are so easily regulated the mixed fuel best adapted for the individual power plant can be secured without difficulty.

A Camphor Vaporizer.—Repeated attempts have been made in France to use camphor or naphthaline in the form of ordinary moth balls as a fuel for internal combustion engines. The first trials of this fuel date back over a decade, but it seems that the recent increase in the price of gasoline has revived interest in it, and new tests have recently been made. A form of vaporizer which has been submitted to tests at the laboratory of the Automobile Club of France is shown

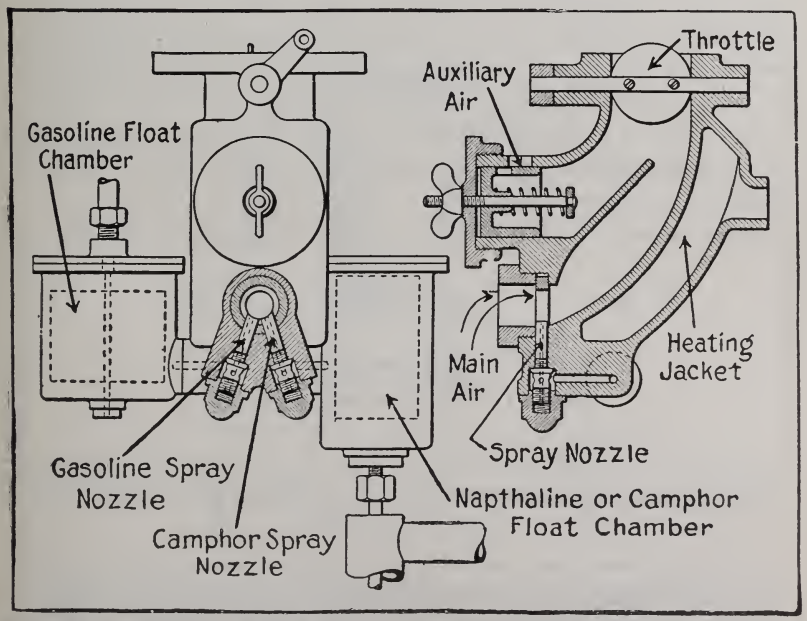


Fig. 333.—Vaporizer of French Design Adapted for Use with Either Gasoline or Camphor Fuel.

at Fig. 333. There are two spray nozzles, one for the gasoline used for starting and the other for the liquefied camphor. The camphor is vaporized by heat derived from the exhaust gases which pass through a heating jacket or chamber adjacent to the camphor-mixing chamber. In all respects the vaporizer resembles an ordinary carbu-

retor, as it has both primary and secondary air inlets. The camphor is melted by contact with a separate coil heated by the exhaust gases, and after being thus melted it flows to the spray nozzle through a gauze strainer. After being sprayed from the spray nozzle the liquid comes in contact with the hot wall of the mixing chamber and is thereby gasified. It is claimed that in France camphor costs about 50 cents per hundred pounds when bought in large quantities. The test of the vaporizer was made with a two-cylinder taxicab. The vehicle was first run over a macadam road with slight gradients and good surface for a distance of 32.5 miles out and the same distance back again. This trip was made at an average speed of 22.5 miles per hour, the highest speed attained being 25 miles per hour. The entire distance was covered on camphor, the consumption being at the rate of substantially two miles per pound of camphor. At that rate the cost per hundred miles would be about 56 cents, as compared with $1.60 for gasoline at present French prices. The second test was made to determine the time required to heat up the engine sufficiently so it would run on the camphor vapor. It was ascertained that 13½ minutes sufficed to heat up the engine and that when hot the power plant could be restarted directly on camphor after a stop not exceeding fifteen minutes. Stops of longer duration made it necessary to restart on gasoline.

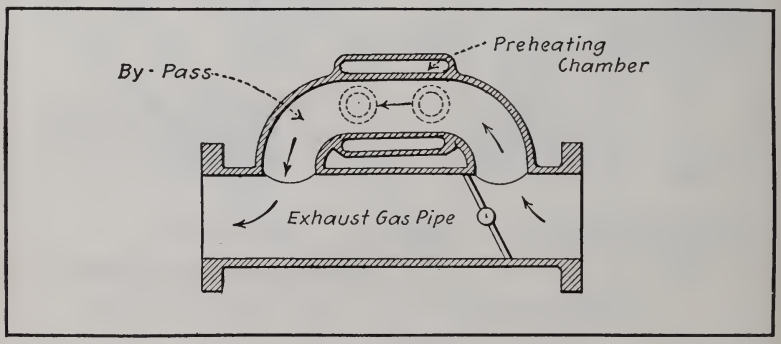


Fig. 334.—Simple Device for Preheating Fuel by Heat of Exhaust Gases.

Preheating Fuel—Owing to the gradual reduction in the volatility of the gasoline at present used as engine fuel some authorities believe that much better carburetion would result if the gasoline was heated before it reached the carburetor spray nozzle. This may be done by jacketing the float bowl, but in the gasoline carburetors there is the danger of heating it too much, which is not present to the same degree when kerosene is used. The illustration at Fig. 334 shows an

invention that forms the subject of an English patent. This is an exhaust by-pass intended to provide controllable preheating for gasoline or kerosene. In the cut the large pipe shown is the main exhaust line, and the annular chamber surrounding the branch, or alternative passage, is interposed in the fuel line between the tank and the carburetor. When the throttle shown is closed, as in the cut, all the exhaust gas passes through the branch and so heats the fuel in the annular jacket. When the throttle is opened the bulk of the exhaust will pass straight out, thus reducing the temperature in the branch. In the abstract of the patent published in the official journal no mention is made as to how the inventor proposes to link up the throttle. Presumably it could be interconnected with the main carburetor throttle with fairly good results.

Air Cleaner.—Considerable trouble is caused by road and field dust getting into the engine through the air intake, especially on

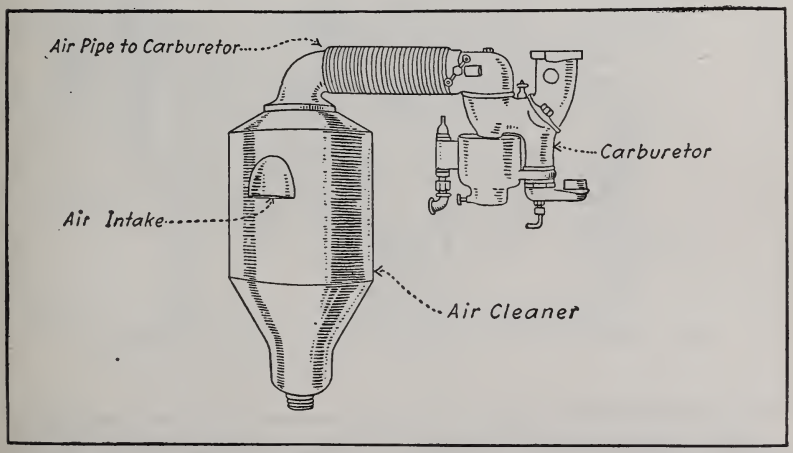


Fig. 335.—The Bennett Air Cleaner, which Removes Dust and Other Solid Matter from Incoming Air.

tractors. The object of the Bennett air cleaner, shown at Fig. 335, is to filter all air and remove dust and other foreign matter it holds in suspension. Much of this matter is of an abrasive nature and has a deteriorating effect on the bearing surfaces, and all of it is thickening and reducing the efficiency of the lubricating oil. It is said that there are no moving parts and no cloths to clean, no screens to clog or adjustments needed. A cap is removed to empty out dust, otherwise the cleaner requires no attention. It is made in various sizes to fit all standard carburetors and will function properly with any power plant.

Primers to Make Starting Easy.—The Imperial primer, shown at Fig. 336, is an easily installed plunger-pump outfit which throws a rich spray of vaporized gasoline into the manifold near the entrance to the cylinders. It consists of a small plunger, along with which are furnished the necessary bolts, connections and tubing for mounting on the dash of any car. To operate the lever is given an up-stroke and the pump draws in a small charge from the main gasoline line, and a down-stroke shoots the charge, vaporized, into the manifold. All connections are made by compression couplings which require no soldering or threading.

Difficulty is sometimes experienced in starting automobiles in cold weather because the fuel does not vaporize quickly enough and will

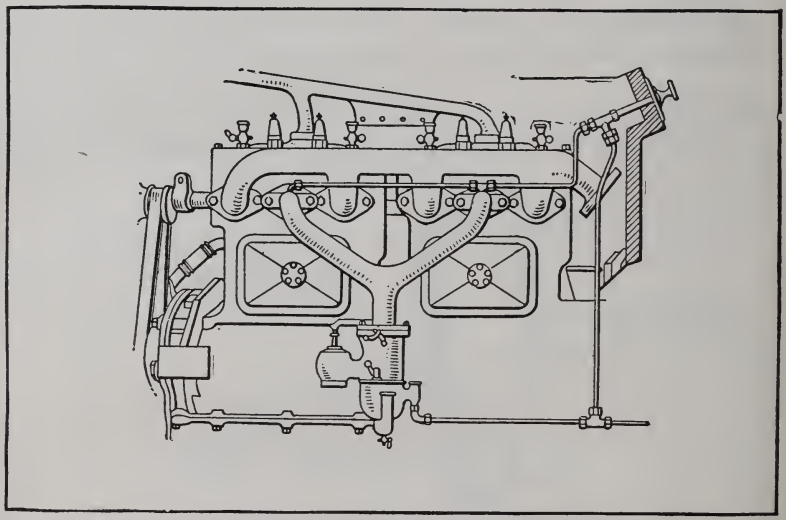


Fig. 336.—Diagram Showing Installation of Imperial Primer Outfit to Facilitate Starting in Cold Weather.

not explode. A simple accessory that combines three distinct devices in one, as it is a primer, an electric vaporizer and sprayer, and an economizer is being marketed, and is shown at Fig. 337. A simple priming cup on the dashboard is connected to the electric vaporizer on the inlet manifold by a short piece of copper tubing. The resistance coil in the plug may be heated by either storage battery or dry cells. Gasoline is put into the priming cup and passes through the heated plug, with the result that as the engine is cranked over a hot vapor that is easily ignited is supplied the cylinders and the engine will start as easily in cold weather as in warm. The priming cock

may be opened to act as an auxiliary air valve and gasoline saver after the engine has warmed up if desired.

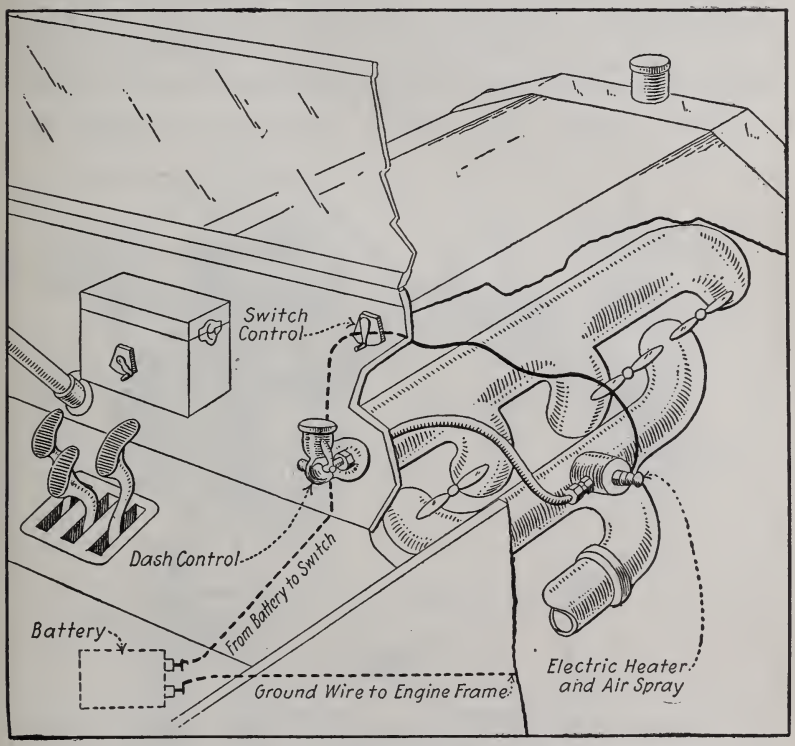


Fig. 337.—Electrically Heated Vaporizer Makes Starting Easy.

Vapor Humidifiers.—A number of accessory makers are exploiting devices to admit steam or water vapor in with the mixture which are said to reduce carbon deposits, etc. The device, shown at Fig. 338-A, supplies warm, moist vapor to the manifold, the exact amount being controlled from the dash. It consists of a valve at the manifold from which runs a pipe to the filler spout of the radiator, from which point the vapor is procured. It is said to provide a better mixture and, consequently, to improve the power and smoothness of operation of the engine. The Gemco steam vaporizer, shown at B, is fastened to the top of the exhaust manifold and delivers steam to the intake manifold. The water is held within a sealed container and begins to give off vapor as soon as the exhaust pipe is heated. The regular water system is the source of supply and the vaporizer needs no attention after it is once installed.

The Marsh device, shown at C, consists in connecting the overflow pipe of the radiator through a combination and three-way spring check or compensating valve to the manifold intake above the carburetor. It is operated by a rod leading to the dash. By turning the plug of the valve air can be drawn from the radiator interior, or from the outside, or from both sources at the same time, or cut out entirely as conditions require. The radiator connection is to obtain water

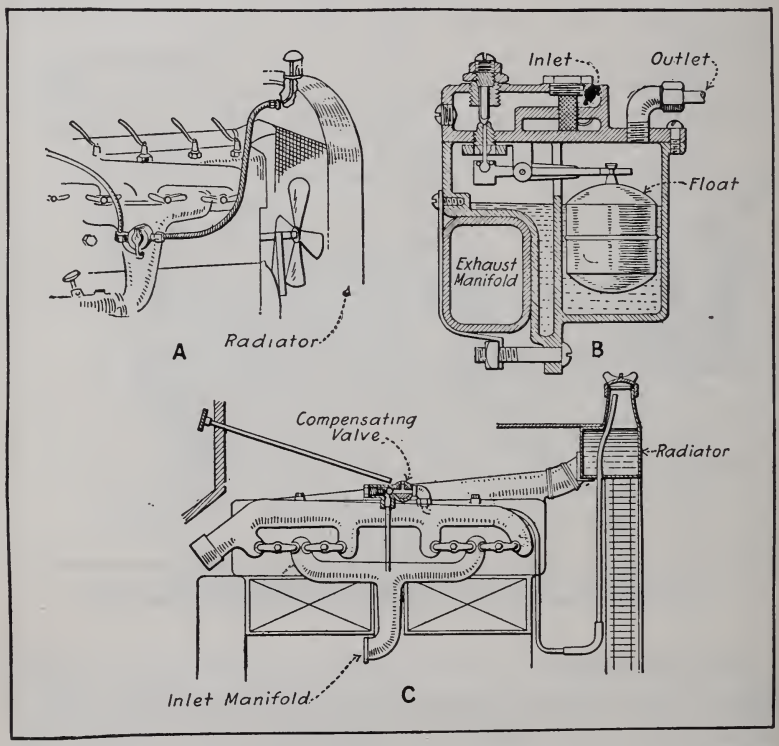


Fig. 338.—A Group of Vapor Humidifiers, a Recently Developed Accessory Said to Reduce Carbon Deposit.

vapor to stimulate combustion in the motor. When alcohol is used for winter driving it is claimed that the vapor from this liquid will still further assist combustion. The spring check is to prevent water from entering the motor when the motor is not running.

Fuel Economizing Devices.—The increasing cost of fuel has resulted in the development of many devices, some automatic, others manually controlled to admit extra air into the intake manifold and thin out the gas mixture at medium and high engine speeds, thereby

securing greater economy. Great claims are made for the efficiency of these devices, but they do not always live up to the expectations of their makers. Some have worked out very well in practice and savings in fuel consumption have been secured ranging from five to twenty per cent, by their use. The compensating vapor plug, a cross-section of which is shown at Fig. 339-A, is intended to screw into the

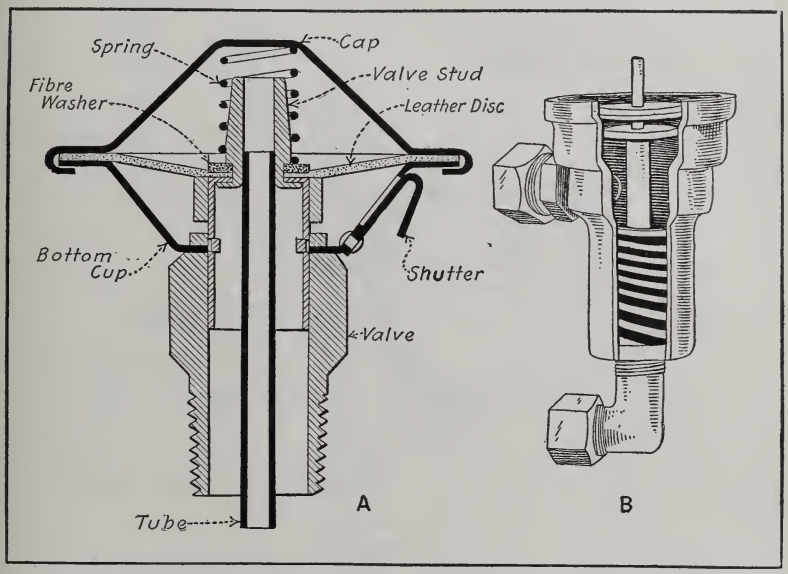


Fig. 339.—Sectional Views of Auxiliary Air Valves for Attachment to Inlet Manifold.

manifold, and its purpose is to feed fresh air to the gas charge coming from the carburetor in such proportions as to conduct a charge to the motor which will be most efficient as regards gasoline consumption and power developed. The action is automatic, air being sucked in by the action of the piston in quantities depending on the speed of the motor. The Duplex air valve at Fig. 339-B is a similar device, intended to be screwed into the intake manifold. The casting houses the valve opening into the manifold, the valve being operated by a piston working in a cylinder, which is also connected to the manifold. At low speeds the valve is held closed by vacuum, but at higher speeds the reduced vacuum allows the valve to open under the action of a spring and admit additional air.

An automatic gasoline economizer for Ford cars, which is installed between the inlet pipe and carburetor without drilling, tapping or

machine work, is shown at Fig. 340-A. It consists of a hollow chamber with a passage communicating between the inlet pipe and a peculiar valve which is connected by means of a simple linkage to the throttle rod, and operates with every movement of the throttle, its

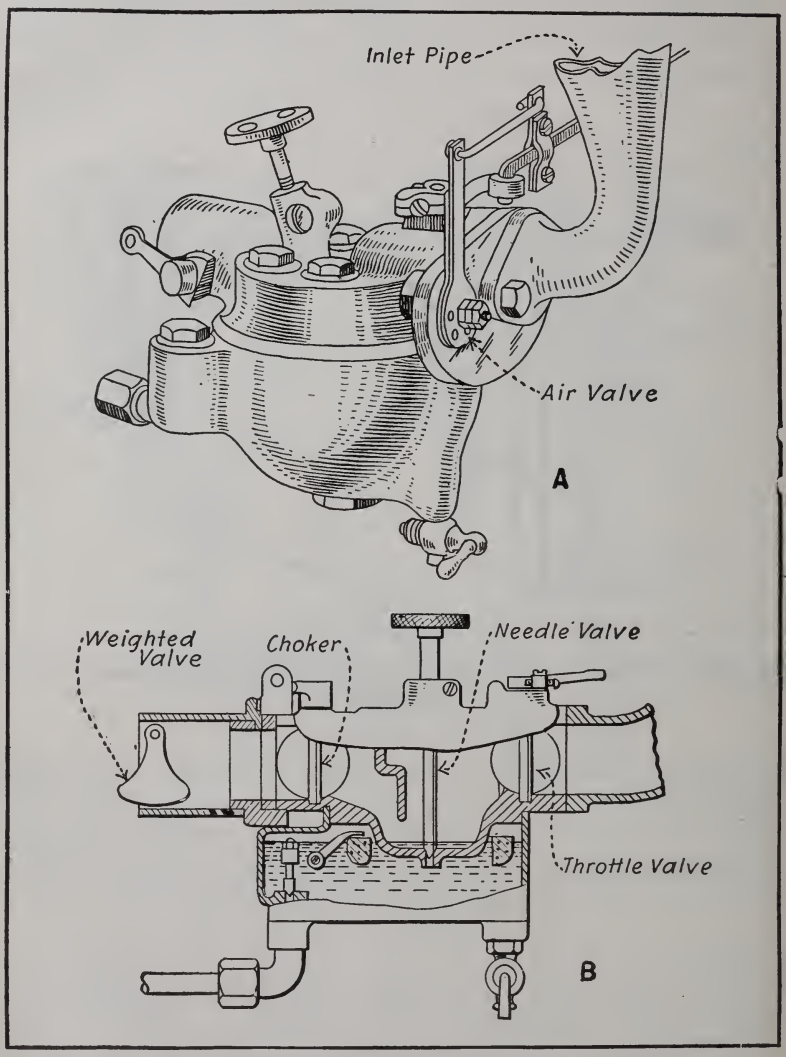


Fig. 340.—Fuel Economizing Devices for Use with Ford Carburetors.

purpose being to admit pure air, which dilutes the overrich mixture and effectively vaporizes the heavy ends. It is not dependent upon foot or hand control, and as it is claimed the proportion of air ad-

mitted is absolutely correct for each opening of the throttle, installation may be accomplished in ten minutes.

The Myle-Maker, shown at Fig. 340-B, is an attachment to go onto the standard Ford carburetor and for which the claim is made that the gasoline mileage will be increased from three to ten miles per gallon. The device is a gravity-operated flutter valve controlling the richness of the gas mixture in inverse ratio to the speed of the engine. There is only one moving part; a composition metal hinge or gate valve, suspended at the top and filling a square space through which air passes. At low engine speeds the hinge remains suspended vertically, allowing enough air to pass underneath it to afford a suitably rich mixture. This is said to facilitate cranking and idling. As the motor is speeded the suction of the engine pulls the valve in, allowing more air to enter the carburetor and consequently diluting the mixture. When much gas is needed to start a cold engine the flutter valve remains partially closed, automatically richening the mixture. When the engine is running freely the valve is lifted by engine suction and the mixture is automatically thinned.

How High Altitude Affects Power.—Any internal combustion engine will show less power in mountainous country of high altitude than it will deliver at sea level, and this has caused a great deal of questioning. In fact, many car owners in mountainous districts have complained from time to time that their cars do not perform as well as they should, lacking their rated power and speed.

"There is a good reason for this," says a writer in "Motor Age," "and it is a physical impossibility for the engine to do otherwise. The difference is due to the lower atmospheric pressure the higher up we get. That is, at sea level the atmosphere has a pressure of 14.7 pounds per square inch; at 5,000 feet above sea level the pressure is approximately 12.13 pounds per square inch, and at 10,000 feet it is 10 pounds per square inch. From this it will be seen that the final pressure attained after the piston has driven the gas into compressed condition ready for firing is lower as the atmospheric pressure drops. This means that there is not so much power in the compressed charge of gas the higher up you get above sea level.

"For example, suppose the compression ratio to be 4½ to 1; in other words, suppose the air space above the piston to have 4½ times the volume when the piston is at the bottom of its stroke that it has when the piston is at the top of the stroke. That is a common compression ratio for an average motor, and is chosen because it is considered to be the best for maximum horsepower and in order that the compression pressure will not be so high as to cause pre-ignition.

Knowing the compression ratio, we can determine the final pressure immediately before ignition by substituting in the standard formula:

$$P^1 = P \left(\frac{V}{V^1}\right)^{1.3}$$

in which P is the atmospheric pressure; P^1 is the final pressure, and $\frac{V}{V^1}$ is the compression ratio, therefore $P^1 = 14.7 \ (4.5)^{1.3} = 104$ pounds per square inch, absolute.

"That is, 104 pounds per square inch is the most efficient final compression pressure to have for this engine at sea level, since it comes directly from the compression ratio.

"Now supposing we consider that the altitude is 7,000 feet above sea level. At this height the atmospheric pressure is 11.25 pounds per square inch, approximately. In this case we can again substitute in the formula, using the new atmospheric pressure figure. The equation becomes:

$P^1 = 11.25 \ (4.5)^{1.3} = 79.4$ pounds per square inch, absolute.

"Therefore we now have a final compression pressure of only 79.4 pounds per square inch, which is considerably below the pressure we have just found to be the most efficient for the motor. The resulting power drop is evident.

"It should be borne in mind that these final compression pressures are absolute pressures—that is, they include the atmospheric pressure. In the first case, to get the pressure above atmospheric you would subtract 14.7 and in the latter 11.25 would have to be deducted. In other words, where the sea level compression is 89.3 pounds per square inch above the atmosphere, the same motor will have only a compression pressure of 68.15 pounds per square inch above the atmosphere at 7,000 feet elevation.

"From the above it is evident that in order to bring the final compression pressure up to the efficient figure we have determined, a different compression ratio would have to be used. That is, the final volume would have to be less, and as it is impossible to vary this to meet the conditions of altitude, the loss of power cannot be helped except by the replacing of the standard pistons with some that are longer above the wrist-pin so as to reduce the space above the pistons when on top center. Then if the ratio is thereby raised to some such figures as 5 to 1, the engine will again have its proper final pressure, but it will still not have as much power as it would have at sea level, since the horsepower varies directly with the atmospheric pressure,

final compression being kept constant. That is, at 7,000 feet the horsepower of an engine that had 40 horsepower at sea level would be equal to

$$\frac{11.25}{14.7} = 30.6 \text{ horsepower.}$$

"If the original compression ratio of 4.5 were retained, the drop in horsepower would be even greater than this. These computations and remarks will make it clear that the man who contemplates buying a car for high altitude use should see to it that it is of sufficient power

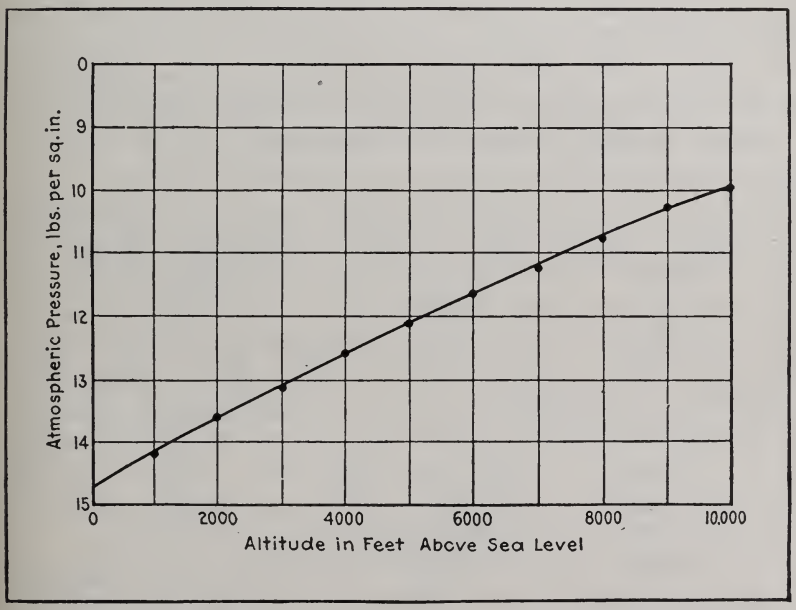


Fig. 341.—Chart Showing Variation in Air Pressure According to Altitude.

to compensate for the drop that is inevitable when it is up in the mountains. This is often illustrated in stationary gas engine installations. An engine that had a sea level rating amply sufficient for the work required, might not be powerful enough when brought up several thousand feet."

The Diesel System.—A system of fuel supply developed by the late Dr. Diesel, a German chemist and engineer, is attracting considerable attention at the present time on account of the ability of the Diesel engine to burn low-grade fuels, such as crude petroleum. In this system the engines are built so that very high compressions

are used, and only pure air is taken into the cylinder on the induction stroke. This is compressed to a pressure of about 500 pounds per square inch, and sufficient heat is produced by this compression to explode a hydrocarbon mixture. As the air which is compressed to this high point cannot burn, the fuel is introduced into the cylinder combustion chamber under still higher compression than that of the compressed air, and as it is injected in a fine stream, it is immediately vaporized because of the heat. Just as soon as the compressed air becomes thoroughly saturated with the liquid fuel, it will explode on account of the degree of heat present in the combustion chamber. Such motors have been used in marine and stationary applications, but have not yet been adapted to automobiles because of lack of flexibility and great weight in proportion to power developed. The Diesel engine is the standard power plant used in submarine boats and motorships, as its efficiency renders it particularly well adapted for large units.

Intake Manifold Design and Construction.—On four- and six-cylinder engines and in fact on all multiple-cylinder forms, it is important that the piping leading from the carburetor to the cylinders be made in such a way that the various cylinders will receive their full quota of gas and that each cylinder will receive its charge at about the same point in the cycle of operations. In order to make the passage direct the bends should be as few as possible, and when curves are necessary they should be of large radius because an abrupt corner will not only impede gas flow but will tend to promote condensation of the fuel. Every precaution should be taken with four- and six-cylinder engines to insure equitable gas distribution to the valve chambers if regular action of the power plant is desired. If the gas pipe has many turns and angles it will be difficult to charge all cylinders properly.

The problem of intake piping is simplified to some extent on block motors where the intake passage is cored in the cylinder casting and where but one short pipe is needed to join this passage to the carburetor. If the cylinders are cast in pairs a simple pipe of T or Y form can be used with success. When the engine is of a type using individual cylinder castings, especially in the six-cylinder power plants, the proper application and installation of suitable piping is a difficult problem.

Intake piping is constructed in two ways, the most common method being to cast the manifold of brass or aluminum. The other method, which is more costly, is to use a built-up construction of copper or brass tubing with cast metal elbows and Y pieces. One of the disadvantages advanced against the cast manifold is that blowholes may exist which produce imperfect castings and which will cause mix-

ture troubles because the entering gas from the carburetor, which may be of proper proportions, is diluted by the excess air which leaks in through the porous casting. Another factor of some moment is that the roughness of the walls has a certain amount of friction which tends to reduce the velocity of the gases, and when projecting pieces are present, such as core wire or other points of metal, these tend to collect the drops of liquid fuel and thus promote condensation.

The advantage of the built-up construction is that the walls of the tubing are very smooth, and as the castings are small it is not difficult to clean them out thoroughly before they are incorporated in the manifold. The tubing and castings are joined together by hard soldering or brazing, and extreme care is needed to insure tight joints at all points.

Some typical manifolds formerly used on four-cylinder engines of various types before the present system of casting the cylinders

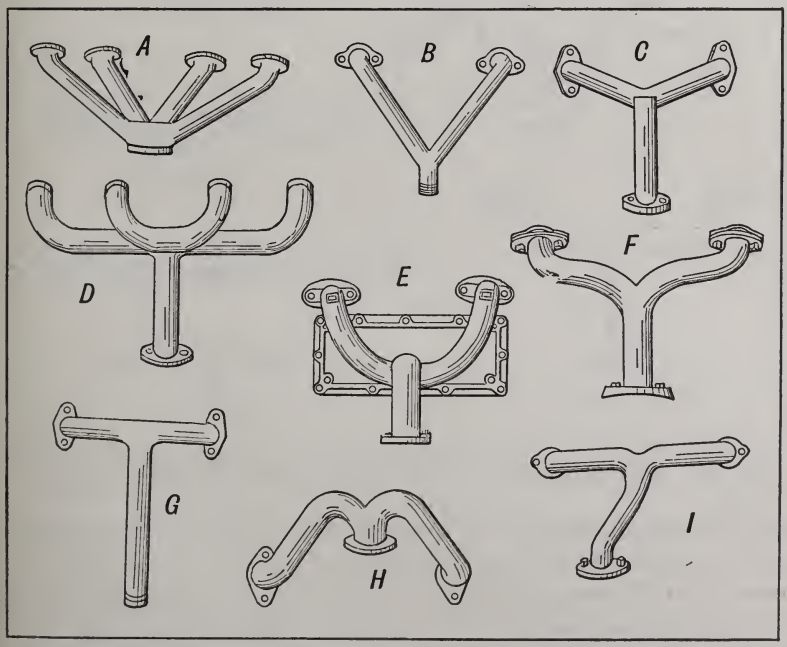


Fig. 342.—Typical Induction Pipes Used on Early Four-Cylinder Motors.

en bloc was the vogue are depicted at Fig. 342. That at A is composed of four pipes leading from a central member, each one communicating with an individual cylinder. The pipes are so nearly the same length that gas distribution is fairly uniform. The manifolds shown at B

and C are substantially the same, except that one is a more pronounced Y than the other. Both are cast forms, that at B being of round section, while that at C is a square section casting. The manifold depicted at D is another type which has been evolved for use with a four-cylinder motor having individual cylinder castings.

At E a cast manifold which is combined with a water-jacket cover plate used on the early Chalmers block motor is illustrated, it being plain that the heating effect of the jacket-water tends to raise the temperature of the entire manifold and promote more rapid vaporization if low-grade fuels are used. The manifold at F is a type applied to a four-cylinder motor having cylinders cast in pairs, and this cast form has been made with graceful curves rather than straight lines. The

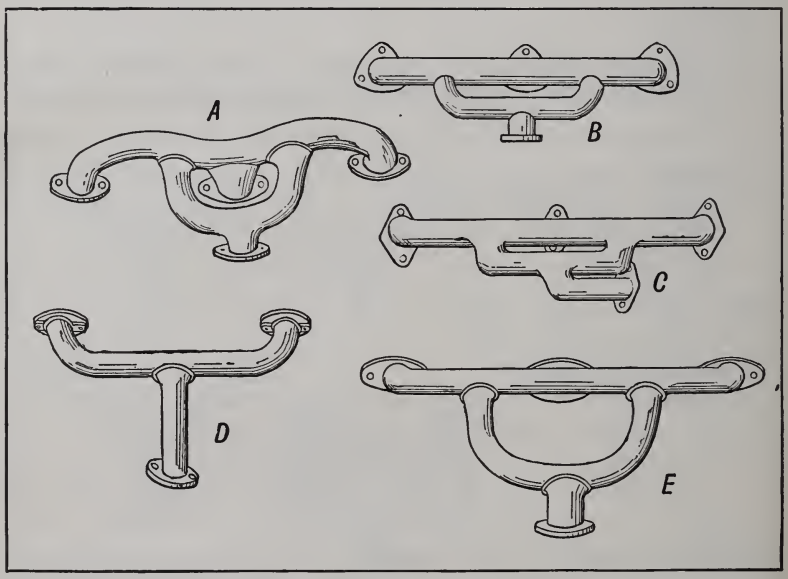


Fig. 343.—Conventional Inlet Manifold Designed for Six-Cylinder Motor.

induction pipe depicted at G is also utilized to supply a four-cylinder motor having twin cylinder castings and is made in the form of a letter T. At H a ramshorn type is outlined, the curves being reversed to the usual construction. The form at I is still another variation of the simple two-branch or T form of induction pipe.

When six-cylinder motors are used the problem is one that is not so easily solved, and designers show considerable ingenuity in devising manifolds to secure even charge distribution. A number of conventional forms that have received successful application are depicted at Fig. 343. All types shown except that outlined at D are used with six-

cylinder engines having three pairs of cylinders, while that at D is employed when the motor is composed of two three-cylinder block castings. All the manifolds illustrated are built-up forms composed of tubing and cast fittings with the exception of that outlined at C, which is a cast aluminum member.

Another group of six-cylinder manifolds is given at Fig. 344. The forms at A, B, C, and E are designed for use with six-cylinder motors

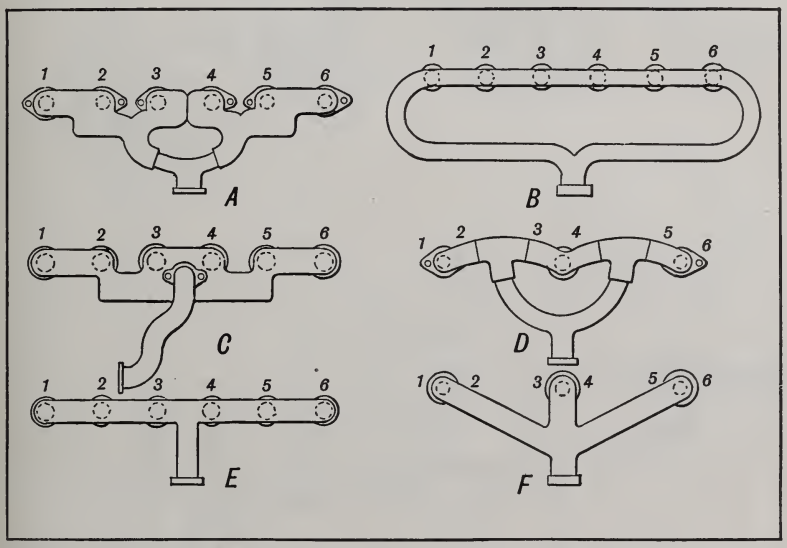


Fig. 344.—Some Unconventional Forms of Gas Supply Pipes Used on Six-Cylinder Engines.

having individual cylinder castings. The form at A, while of peculiar shape, provides gas passages of about the same length leading to all cylinders. This is not true of those shown at B, C, and E, which are faulty in design, inasmuch as the gas will reach cylinders three and four much quicker than it will get to two and five, and to these two cylinders quicker than it will reach those on the extreme ends of the manifold, or one and six. It is claimed that the loop shown at B has given very satisfactory results, and that the peculiar construction compensates to a certain degree for the varying lengths of piping leading from the carburetor to the various valve chambers. The manifold at D is a built-up form utilized when cylinders are cast in pairs, and is much superior to that outlined at F, which is a cast aluminum member designed for the same type of motor.

Compensating for Varying Atmospheric Conditions.—The low-grade gasoline used at the present time makes it necessary to use

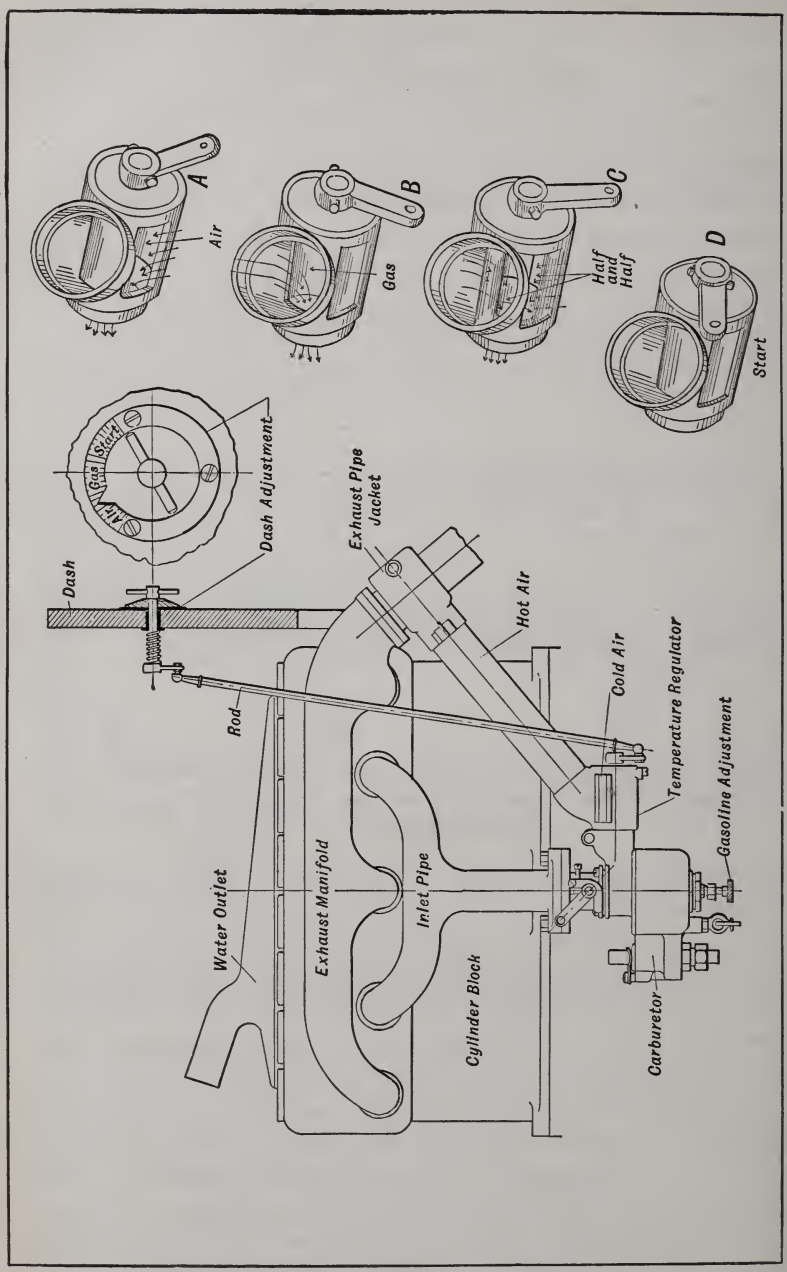


Fig. 345.—Holley Method of Compensating for Temperature Variations and Securing Easy Starting from Dash Adjusted Regulator. Positions of Regulator Valve Sleeve for Different Conditions Outlined.

vaporizers that are more susceptible to atmospheric variations than when higher grade and more volatile liquids are vaporized. Sudden temperature changes, sometimes being as much as forty degrees rise or fall in twelve hours, affect the mixture proportions to some extent, and not only changes in temperature but variations in altitude also have a bearing on mixture proportions by affecting both gasoline and air. As the temperature falls the specific gravity of the gasoline increases and it becomes heavier, this producing difficulty in vaporizing. The tendency of very cold air is to condense gasoline instead of vaporizing it and therefore it is necessary to supply heated air to some carburetors to obtain proper mixtures during cold weather. In order that the gas mixtures will ignite properly the fuel must be vaporized and thoroughly mixed with the entering air either by heat or high velocity of the gases.

As it would be somewhat inconvenient to constantly regulate the average carburetor from day to day by the regular adjustments incorporated in the device, forms of dash-controlled regulators have been devised. One of these is shown at Fig. 345 as applied to the Holley carburetor. It consists of a special form of valve interposed between the hot air connection around the exhaust manifold and the primary air entrance at the side of the carburetor. It is worked by a simple key and leverage connection. An indicator plate on the dash shows the different positions of the regulator. When the shutter is in the position shown at A only cold air is supplied the carburetor, this being the proper position for summer running. When in the position shown at B the cold air slot is closed and only warm air which is taken from the jacket surrounding the exhaust pipe is supplied the carburetor. This would be the proper position for cold or damp weather. If the shutter is placed as shown at C the air supplied the carburetor will be composed of both warm and cold currents in any desired proportion. When it is desired to exert a strong suction on the gasoline in the carburetor, as is often necessary in starting, the shutter may be turned as depicted at D, in which case both air openings are shut off with the exception of but a very small slot. The equipment illustrated has been designed especially for use with the Holley carburetor and is supplied by the manufacturers of that device. Air shutter regulation has been used on many cars, however, and has proved to be a very satisfactory way of compensating for extremes of temperature or altitude and variations in fuel quality.

Disposition of Exhaust Gases.—While the problem of getting the fresh gases into the cylinders is an important one the means of disposing of them after they have been burned is also important. The

form of the exhaust manifold, which is usually a large malleable iron casting, is not so important as that of the induction pipe and the chief precaution to be observed is to make the passages in this member as large as possible and to proportion it in such a way that all parts of the casting will expand with the same ratio. An important condition to be observed, however, is the method of discharging the gases to the air and for this purpose various forms of mufflers, or silencers, are used so that the gases will be discharged in an unobjectionable manner.

It has been demonstrated that the average motor vehicle engine cannot utilize the full expansive force of the burned charge because the exhaust valve is opened a certain number of degrees before the bottom center or before the piston reaches the end of its power stroke. This is done to give a lead or start to the gases and obtain higher engine speeds than would otherwise be possible. As a result of the early opening of the exhaust valve the gases will issue through the valve port at sufficient pressure to produce a report like a gun shot which would be apt to disturb persons and animals of nervous temperament and at the same time not be exactly music to the normal ear.

It is not difficult to muffle the gases so there will be but little noise to the exhaust, but it is quite a problem to do it without producing back pressure in the muffling device that will cause serious loss of power. A muffler should offer minimum resistance to the passage of the gas and means should be provided for not only breaking the entering gas stream into smaller streams, but the capacity of the muffler should be sufficiently large so that the gases will expand to nearly atmospheric pressure before they are discharged into the air.

Various forms of mufflers are shown in section at Fig. 346. The simplest, outlined at A, consists of a sheet metal shell having its ends closed by cast metal pieces. This has several times the volume of the cylinder and the gases expand to about atmospheric pressure before they are discharged through the series of small holes at the bottom. The gas enters and leaves the muffler in streams indicated by the arrows. The objection to the use of small holes for breaking up the gas stream is that these are liable to clog with carbonaceous matter from the interior of the engine, such as would result when excessive amounts of oil were used or from mud or clay from the road surface.

The form shown at B consists of a number of concentric chambers which afford an excellent opportunity for the gas to expand to atmospheric pressure and to break it up thoroughly before it is discharged to the air. The exhaust gas enters the central pipe, passes

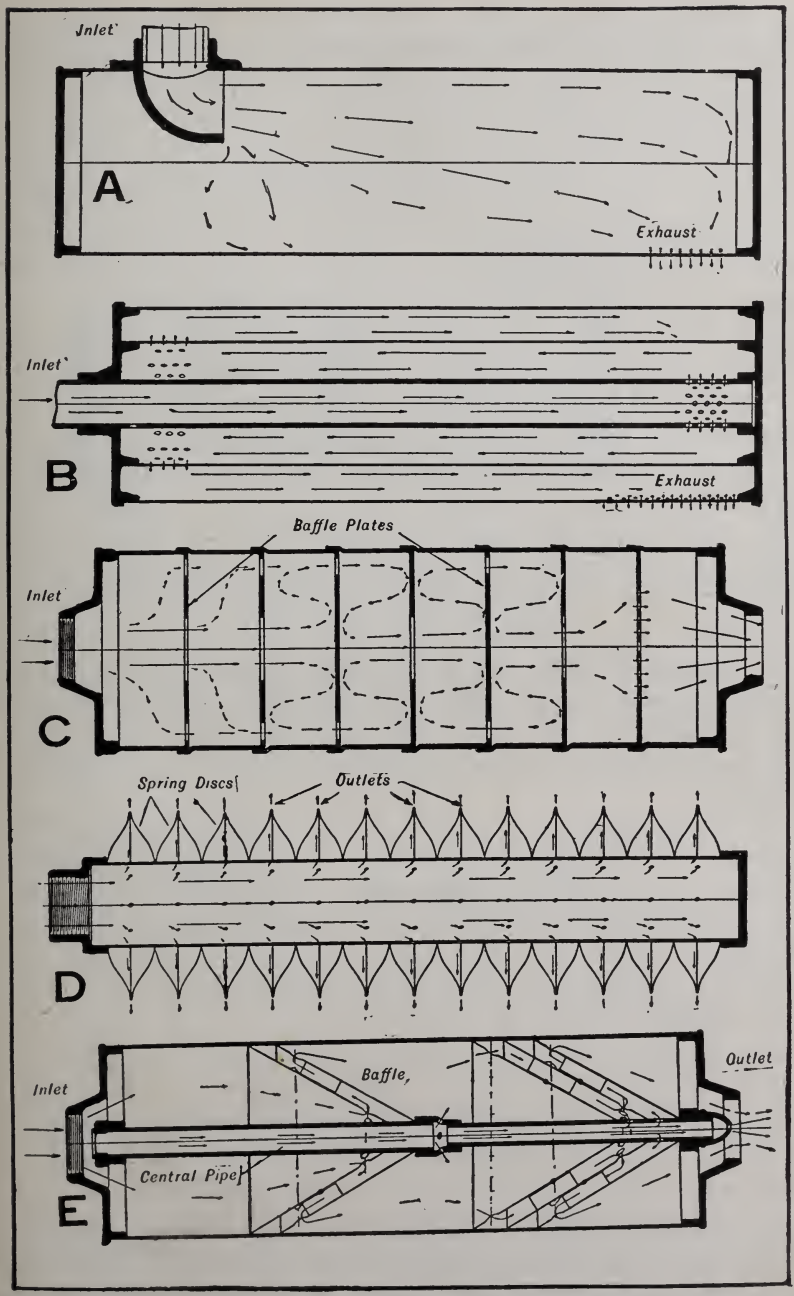


Fig. 346.—Muffler Forms Adapted to Reduce Pressure of Exhaust Gases Before Discharging Them.

out through a series of fairly large holes at its extremity into the middle compartment where it expands and passes out through another series of holes into the outer chamber. Here it again expands and finally leaves the muffler through a series of openings punched in the outer shell. The course of the gas may be easily followed by referring to the illustration, as it is indicated by arrows. A form employing a series of perforated baffle plates which divide the muffler body into eight compartments is shown at C. The function of the baffles is to break up the gas by making the gas streams follow a devious path through the first six chambers and expand into the seventh compartment, from which it passes to the eighth compartment through a series of fine holes in the last baffle plate of the series.

The form at D consists of a central pipe member around which are placed thirteen pairs of stamped disks which form the same number of expansion chambers. The gas issues from the center pipe, where opportunity is given it to expand into the chambers provided by the disks which are merely placed in contact with each other at their edges and held together by moderate pressure. The force of the gas causes the disks to spring slightly at their edges and thus produce an annular discharge passage in each set of disks which insures thorough breaking up of the issuing gas stream. It is claimed that this method of construction provides a large amount of cooling surface and that the pressure of the gas is reduced just as much by the cooling effect as it is by the increase in volume permitted by the expansion chambers.

The form shown at E is built on the ejector principle and is claimed to be particularly efficient, not only as relates to silencing qualities but also because back pressure is practically eliminated. The efficiency is due to its design, which allows that part of the gases which pass through the central pipe to do so with considerable force. This tends to produce a partial vacuum, which in turn promotes a ready expulsion of gas by drawing the main portion through the muffler rather than depend upon the upward stroke of the piston to clear both cylinder and muffler. This device is of the baffle plate type and the partitions are in the form of cones instead of the usual vertical or horizontal dividing walls, because the conical form lends itself to the ejector principle better than the other types.

A very good muffler for marine purposes is shown at Fig. 347. This consists of a double-expansion chamber and a water jacket. If the exhaust gases are cooled they will be considerably reduced in volume and pressure and for this reason water cooled forms are very quiet. As the gases are considerably reduced in pressure by the cool-

ing effect one may use large holes for the passage of gas from one chamber to the other and the back pressure is correspondingly reduced. While a water cooled form of muffler can be readily adapted to marine service, it is not possible to use such on a motor car because of the large volumes of water which would have to be supplied to insure adequate cooling of the muffling device.

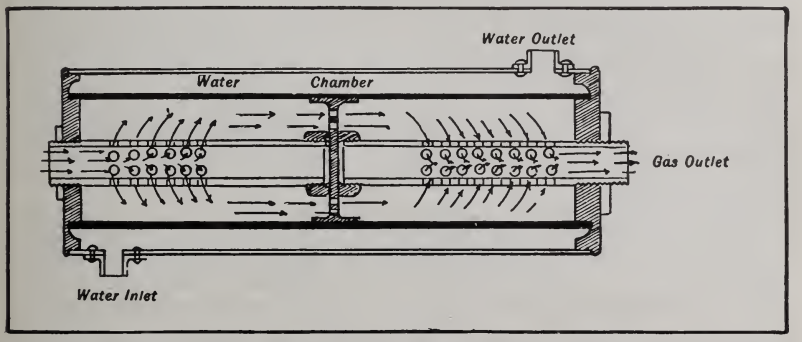


Fig. 347.—Water-Cooled Muffler Used when Exceptional Silence is Desired. Often Applied in Marine Service.

Ejector Type Exhaust Manifold.—It is sometimes possible to secure a more prompt discharge of the exhaust gases from the cylinder if a little attention is paid to the design of the exhaust manifold. The form shown at Fig. 348 is a composite member consisting of four sep-

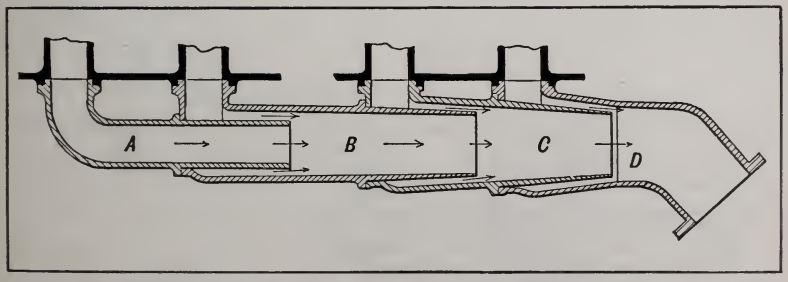


Fig. 348.—Suggested Exhaust Manifold Design in which Ejector Action of Exhaust Gases Under High Velocity is Said to Reduce Back Pressure on Piston.

arate castings, the object of the arrangement being to secure an ejector effect by which the discharge from any one cylinder would tend to keep a condition of partial vacuum in the manifold and thus draw out the gases. The discharge from cylinder 1 goes through pipe A; that from cylinder 2, through member B, while the gases from cylinders 3 and 4

pass out through pipes C and D respectively. If the exhausts occur in the order 1, 2, 4, 3, it will be seen that the gases flowing through pipe A will produce a certain suction effect in pipe B, which will tend to draw out the gases discharged from that cylinder when the exhaust valve opens. A manifold so constructed is but little more complicated than the ordinary construction, as it consists of the four bent tubes A, B, C and D, which are assembled together in such a manner that a portion of one projects into the other. The faster the engine works the more rapid the ejection of the gases and consequently the ejector action has a higher value at a time that it is needed the most. Such a manifold would be more expensive than the conventional pattern, however, and there might be some difficulty in keeping it tight at the multiplicity of joints.

Utility of Cut-out Valve Explained.—In order to take advantage of the gain in power which results when the gases are discharged directly

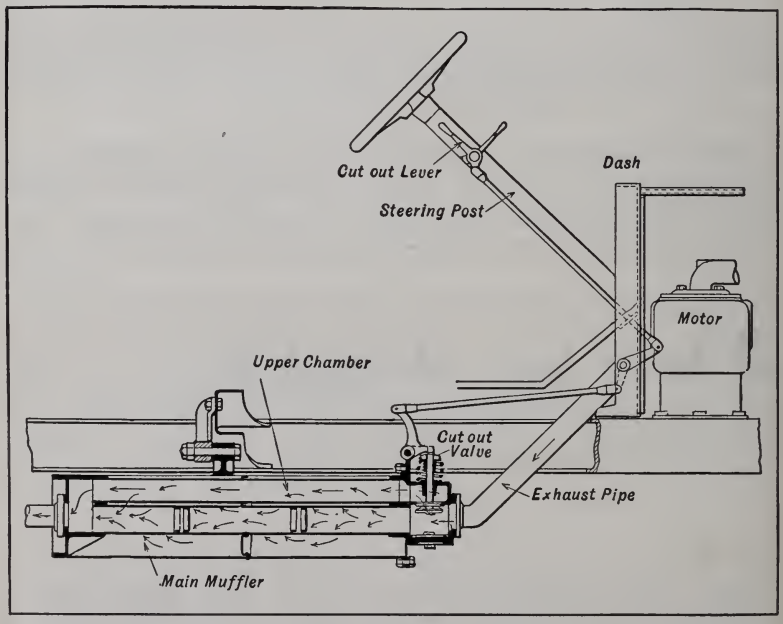


Fig. 349.—How Muffler Cut-out Valve is Arranged on Wolseley (English) Cars to Reduce Noise of Direct Exhaust.

into the air instead of being passed through the muffling device, many automobile makers provide a simple valve, which is called a "cut-out," between the exhaust manifold and the muffler. This is arranged in such a manner that when opened, the gases are free to issue directly

to the air instead of passing through the muffling device, and as the back pressure incidental to the silencer is eliminated more power is obtained from the motor. A cut-out is also useful because it permits one familiar with gasoline motors to detect irregularity in engine operation by sound of the exhaust.

A typical cut-out installation is shown at Fig. 349, this being more efficient than that commonly used because even with the cut-out valve opened the gases are silenced to a certain extent by being passed through the chamber P before they issue to the air. When the cut-out valve is closed the gases must follow a circuitous route through the muffler and by being broken up and allowed to expand, issue to the air without appreciable noise. Whenever a cut-out valve is provided it is usually planned to open out so that any explosion of gas in the muffler which might result if the motor missed several explosions and then fired the gas in the silencer will tend to open the valve and relieve the excessive pressure in the muffling device. If some means were not provided to relieve the pressure, it might burst the muffler asunder. The average cut-out valve, therefore, performs three useful functions: First, it permits the exhaust gases to be discharged directly to the air at such times that maximum motor power is desired; second, it provides audible indication of irregular engine action; third, it is a safety or relief valve to prevent excessive pressures from damaging the muffler.

Multiple Exhaust System Advantages.—In order to completely exhaust a single cylinder the exhaust valve must be open through 235 degrees of crank shaft travel. In the six-cylinder engine all six cylinders must go through a suction, compression, explosion, and exhaust cycle in two crankshaft revolutions. (See Fig. 350.) Therefore suction, compression, explosion, and exhaust actions must overlap. The overlapping of explosions, or power strokes, is one of the big advantages of multi-cylinder engines—but the overlapping of exhausts into a single system is known to result in trapped gases, reduced power and waste of fuel.

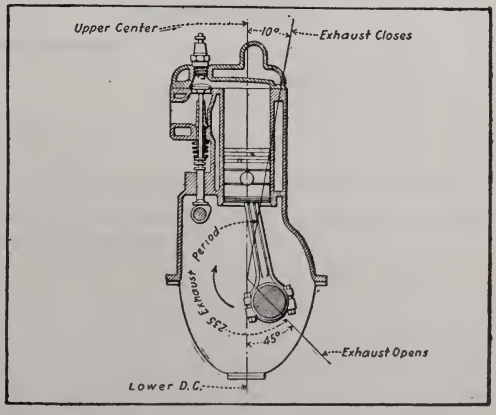


Fig. 350.—Diagram Showing Period of Exhaust Valve Opening.

The cut at Fig. 351 shows what happens. Cylinder No. 1 has little more than half completed its exhaust when cylinder No. 5 starts to exhaust. The gases coming from No. 5 are at a higher pressure

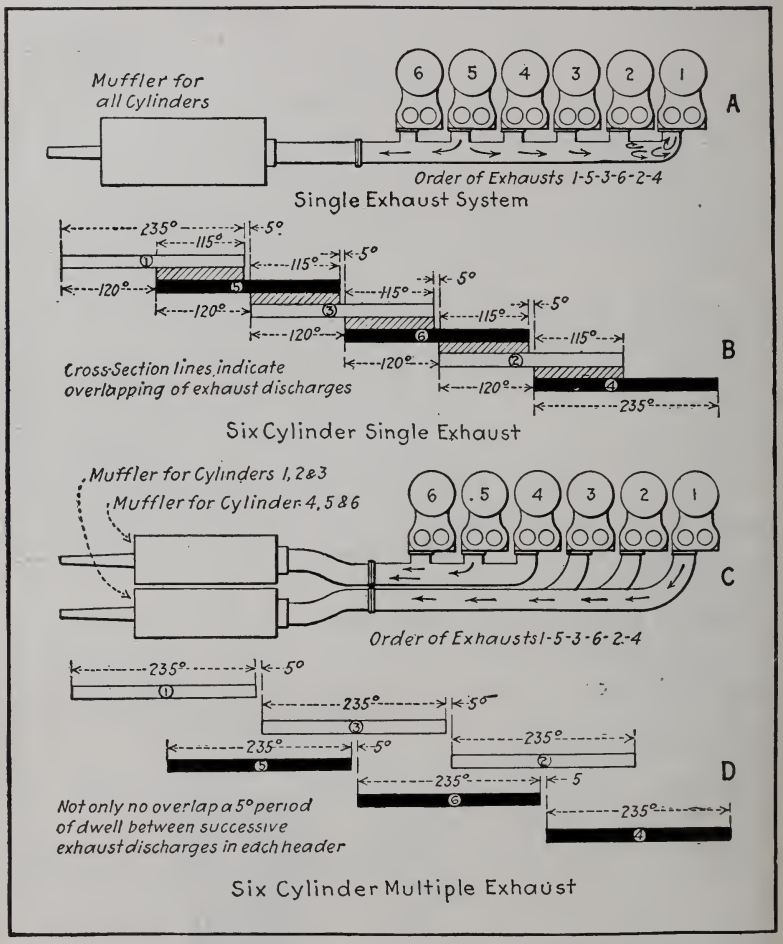


Fig. 351.—Diagrams Defining Advantages of Multiple Exhaust System on Six-Cylinder Engines.

than those still coming from No. 1. Therefore the gases from No. 5 prevent the further egress of the No. 1 exhaust and by the time the No. 5 gases are sufficiently reduced in pressure to allow No. 1 gases to resume their travel through the manifold, the exhaust valve of cylinder No. 1 has closed and burnt gases still remain in it.

What is needed is induced draft in the exhaust system, so that all dead gases will leave the cylinder and allow it to take in a full charge of fresh mixture and develop full power. The multiple exhaust system supplies this need.

A careful study of the graphical diagrams at Fig. 351 will show how the interference between exhaust gas discharges is prevented by having alternate discharges carried away by separate inert gas manifolds.

First note that an exhaust period of 235 degrees is necessary in all engines. With the four-cylinder engine there is an overlap of 55 degrees in the exhaust periods. This means that after the exhaust valve of any one cylinder has been open 180 degrees, the exhaust valve of another cylinder opens at a higher pressure and during the remaining 55 degrees of the first cylinder's exhaust period there is interference in the manifold. This is bad enough. But when two more cylinders are added the period of overlap is more than doubled. In the four-cylinder engine each cylinder has a clear track in the manifold for not quite three-fourths of the period required for the complete exhaust. But in the six-cylinder engine the clear track lasts for only half of the period. Instead of a clear track for 180 degrees and 55 degrees of conflict as in the four-cylinder engine, there is a clear track for only 120 degrees, and there are 115 degrees of conflict in the six-cylinder engine. These same conditions exist both in the eights and twelves, because the eight is a double four as is the twelve a double six.

Now compare the cuts at C and D. The exhausts shown in white overlap those immediately below in black in time only. Actually each series, those in white and those in black, exhaust into separate manifolds, and there is not only no overlapping effect, but there is a clear interval of 5 degrees between each exhaust, during which no cylinder is exhausting at all. In other words, cylinder No. 1 exhausting into manifold No. 1 finishes its exhaust period completely and there is a short interval before cylinder No. 3 begins to exhaust into the same manifold. No. 3 finishes completely and there is another short interval before cylinder No. 2 begins its exhaust period. A similar cycle takes place in cylinders Nos. 5, 6 and 4, which exhaust into manifold No. 11. Each series, 1, 3, 2, and 5, 6, 4 is distinct. Every cylinder is completely cleaned of burnt gases and can therefore take in a full fresh charge of carbureted mixture at every stroke.

The following tests were made to demonstrate the advantages of the multiple exhaust system. The engine used was a six-cylinder Lexington-Continental of 224 cubic inches piston displacement having cylinders of 3¼-inch bore and 4¼-inch stroke. The greatest gains

are made at high speeds, though a substantial increase in power is noted even at medium speeds:

MOORE MULTIPLE EXHAUST SYSTEM
(Patented Aug. 29, 1916)
VS. SINGLE EXHAUST SYSTEM

REVOLUTIONS PER MINUTE

	400	600	800	1000	1200	1400	1600	1800	2000	2200	2300	2400	2500	HORSE POWER
Moore Multiple Exhaust System — Cut-outs closed	7.9	12.6	16.8	21.2	25.5	29.7	33.9	36.5	38.0	39.5	38.5	37.8	36.9	
Single Exhaust System — Cut-outs closed	7.2	12.5	16.6	20.7	24.3	26.6	30.0	32.2	33.5	34.6	31.6	31.1	30.2	
Single Exhaust — Manifold only	7.9	12.7	16.8	21.2	24.8	28.6	31.8	34.7	36.7	37.1	35.9	34.3	33.1	
Engine Exhausting Direct Into Air — No manifold	7.5	12.2	16.6	20.7	24.1	26.5	30.7	34.0	37.5	37.6	37.6	36.3	34.0	

Carburetor set to idle at 200 r. p. m.
Carburetor unchanged throughout all tests.
Ignition advanced same degrees for r. p. m. each test.
Barometer average, 29.30.
Water outlet average, 148 degrees Fahrenheit.
Room, 78 degrees Fahrenheit.

CHAPTER VII

Automobile Power Plant Ignition Systems Outlined—Chemical Current Producers—Mechanical Generators of Electricity—Essentials of Battery Ignition Systems—Functions of Timers and Distributors—Operating Principles of Induction Coil—Spark Plug Construction and Action Defined—Advantages of Two-Spark Ignition—Typical Battery Ignition Groups—Low-tension Ignition Systems—High-tension Magneto Forms—Typical Double Ignition Systems.

One of the most important auxiliary groups of the gasoline engine comprising the automobile power plant and one absolutely necessary to insure engine action is the ignition system or the method employed of kindling the compressed gas in the cylinder to produce an explosion and useful power. The ignition system has been fully as well developed as other parts of the automobile, and at the present time practically all ignition systems follow principles which have become standard through wide acceptance.

During the early stages of development of the automobile various methods of exploding the charge of combustible gas in the cylinder were employed. On some of the earliest engines a flame burned close to the cylinder head and at the proper time for ignition, a slide or valve moved to provide an opening which permitted the flame to ignite the gas back of the piston. This system was practical only on the primitive form of gas engines in which the charge was not compressed before ignition. Later, when it was found desirable to compress the gas a certain degree before exploding it, an incandescent platinum tube in the combustion chamber, which was kept in a heated condition by a flame burning in it, exploded the gas. The naked flame was not suitable in this application because when the slide was opened to provide communication between the flame and the gas the compressed charge escaped from the cylinder with enough pressure to blow out the flame at times and thus cause irregular ignition. When the flame was housed in a platinum tube it was protected from the direct action of the gas, and as long as the tube was maintained at the proper point of incandescence regular ignition was obtained.

Some engineers utilized the property of gases firing themselves if compressed to a sufficient degree, while others depended upon the

heat stored in the cylinder head to fire the highly compressed gas. None of these methods were practical in their application to motor car engines because they did not permit flexible engine action which is so desirable. At the present time, electrical ignition systems in which the compressed gas is exploded by the heating value of the minute electric arc or spark in the cylinder are standard, and the general practice seems to be toward the use of mechanical producers of electricity rather than chemical batteries.

Two general forms of electrical ignition systems may be used, the most popular being that in which a current of electricity under high tension is made to leap a gap or air space between the points of the sparking plug screwed into the cylinder. The other form, which has been almost entirely abandoned in automobile practice, but which is still used to some extent on marine engines, is called the low-tension system because current of low voltage is used and the spark is produced by moving electrodes in the combustion chamber.

The essential elements of any electrical ignition system, either high or low tension, are: First, a simple and practical method of current production; second, suitable timing apparatus to cause the spark to occur at the right point in the cycle of engine action; third, suitable wiring and other apparatus to convey the current produced by the generator to the sparking member in the cylinder.

The various appliances necessary to secure prompt ignition of the compressed gases should be described in some detail because of the importance of the ignition system. It is patent that the scope of a work of this character does not permit one to go fully into the theory and principles of operation of all appliances which may be used in connection with gasoline motor ignition, but at the same time it is important that the elementary principles be considered to some extent in order that the reader should have a proper understanding of the very essential ignition apparatus. The first point considered will be the common methods of generating the electricity, then the appliances to utilize it and produce the required spark in the cylinder.

Current Production by Chemical Action.—The simplest method of current generation is by various forms of chemical current producers which may be either primary or secondary in character. A simple form of cell is shown in section at Fig. 352-A, and as the action of all devices of this character is based on the same principles it will be well to consider the method of producing electricity by the chemical action of a fluid upon a metal. The simple cell shown consists of a container which is filled with an electrolyte which may be either an alkali or acid solution. Immersed in the liquid are two plates of

metal, one being of copper, the other zinc. A wire is attached to each plate by means of suitable screw terminals.

If the ends of the plates which are not immersed in the solution are joined together a chemical action will take place between the electrolyte and the zinc plate; in fact, any form of cell consists of dissimilar elements which are capable of conducting electricity immersed in a liquid which will act on one of them more than the other. The chemical action of electrolyte on the zinc liberates gas bubbles which are charged with electricity and which deposit them-

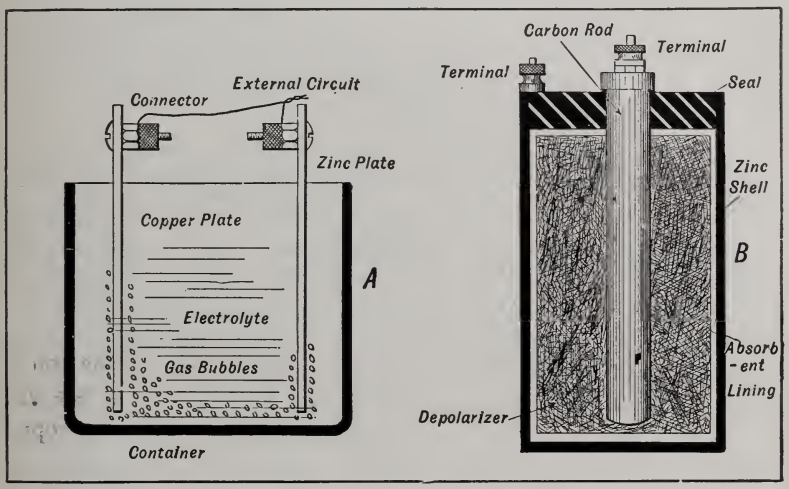


Fig. 352.—Simple Primary Cells Used to Produce Electric Current. A—Form to Show Principle of Current Production by Chemical Action. B—Dry Cell, the Type Suitable for Automobile Service.

selves on the copper plate. The copper element serves merely as a collecting member and is termed the "positive" plate, while the zinc which is acted upon by the solution is termed the "negative" member. The flow of current is from the zinc to the copper plate through the electrolyte and it is returned from the copper plate to the zinc element by the wiring which comprises the external circuit.

While in the cell shown zinc and copper are used, any other combination of metals between which there exists a difference in electrical condition when one of them is acted upon by a salt or acid may be employed. Any salt or acid solution will act as an electrolyte if it will combine chemically with one of the elements and if it does not at the same time offer too great a resistance to the passage of the electric current. The current strength will vary with the nature of

the elements used, and will have a higher value when the chemical action is more pronounced between the negative member and the electrolyte.

As the vibrations which obtain when the automobile is driven over highways makes it difficult to use cells in which there is a surplus of liquid, a form of cell has been devised in which the liquid electrolyte is replaced by a solid substance which cannot splash out of the container even if the cell is not carefully sealed. A current producer of this nature is depicted in section at Fig. 352-B. This is known as a dry cell and consists of a zinc can in the center of which a carbon rod is placed. The electrolyte is held close to the zinc or negative member by an absorbent lining of blotting paper, and the carbon rod is surrounded by some depolarizing material. The top of the cell is sealed with pitch to prevent loss of depolarizer.

The depolarizer is needed that the cell may continue to generate current. When the circuit of a simple cell is completed the current generation is brisker than after the cell has been producing electricity for a time. While the cell has been in action the positive element becomes covered with bubbles of hydrogen gas, which is a poor conductor of electricity and tends to decrease the current output of the cell. To prevent these bubbles from interfering with current generation some means must be provided for disposing of the gas. In dry cells the hydrogen gas that causes polarization is combined with oxygen gas evolved by the depolarizing medium and the combination of these two gases produces water which does not interfere with the action of the cell. Carbon is used in a dry cell instead of copper because it is a cheaper material and the electrolyte is a mixture of sal-ammoniac and chloride of zinc which is held in intimate contact with the zinc shell which forms the negative element by the blotting-paper lining.

A single dry cell will not produce sufficient current to ignite the charge of gas in the engine cylinder, therefore it is common practice to combine two or more cells in such a manner that batteries are formed which will give more current than a single cell. If it is desired to increase the voltage the cells are connected in series, as shown at Fig. 353. If one dry cell will produce one and one-half volts and six volts are needed to produce the spark in the engine cylinder, the current value of one dry cell is augmented by coupling three others to it in a series connection. When cells are connected in series it is the unlike elements which are joined together. For example, the zinc of one cell should be joined with the carbon of the adjacent member by a flexible conductor. This will leave the carbon of one end

cell and the zinc of the other end cell free so that they can be joined to the apparatus in the outer circuit.

When it is desired to obtain more amperage or current quantity than could be obtained from a single cell they are joined in series-multiple connection. With this method of wiring two or more sets of four cells which have been joined in series are used. The zinc of one set is joined with the zinc element of the other and the two carbons are similarly connected. Any number of sets of cells may be connected in series multiple and the amperage of the combination is increased proportionately to the number of sets joined together in this manner.

When dry cells are connected in series the voltage of one cell is multiplied by the number of cells and the amperage obtained from the set is equal to that of one cell. When connected in series multiple,

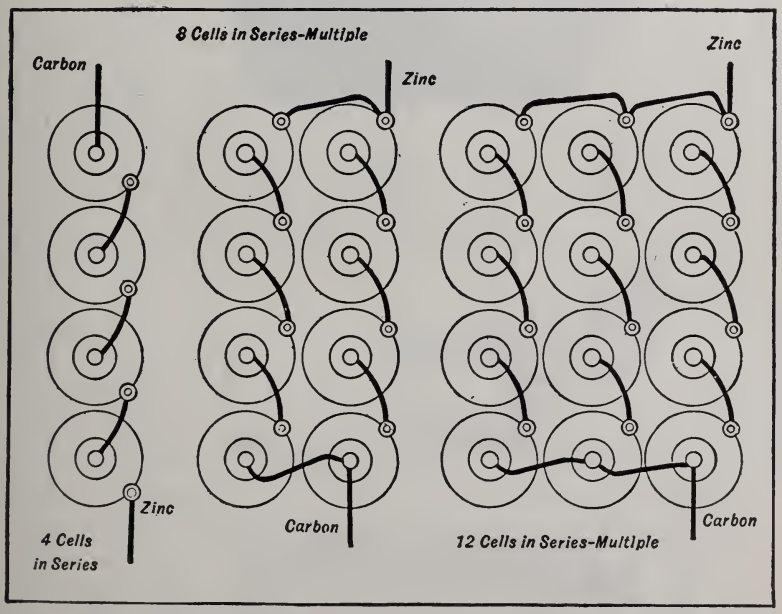


Fig. 353.—Methods of Joining Dry Cells to Form Batteries of Varying Voltage and Current Strength.

as shown at Fig. 353, the amperage is equal to two cells and the voltage produced is equivalent to that obtained from four cells. When twelve cells are joined in series multiple the amperage is equal to that of one cell multiplied by three while the voltage or current pressure is equal to that produced by one cell multiplied by the num-

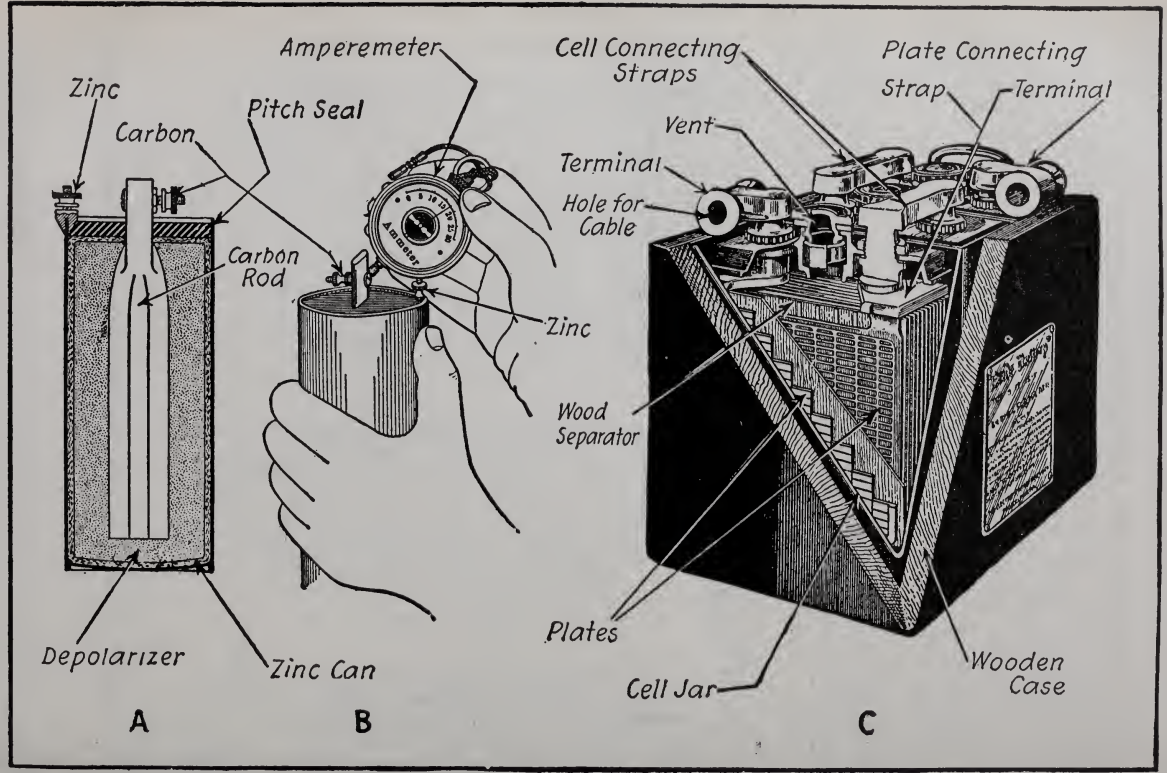


Fig. 354.—Comparing Chemical Current Producers. A—Sectional View of Dry Cell. B—How to Test Dry Cell Amperage. C—Part Sectional View of Storage Battery for Automobile Ignition, Starting and Lighting.

ber of cells which are in series in any one set. By properly combining dry cells in this manner batteries of any desired current strength may be obtained.

The terms "volt" and "ampere" are merely units by which current strength is gauged. The volt is the unit of pressure or potential which exists between the terminals of a circuit. The ampere measures current quantity or flow and is independent of the pressure. One may have a current of high amperage at low potential or one having great pressure and but little amperage or current strength. Voltage is necessary to overcome resistance while the amperage available determines the heating value of the current. As the resistance to current flow increases the voltage must be augmented proportionately to overcome it. A current having the strength of one ampere with a pressure of one volt is said to have a value of one watt, which is the unit by which the capacity of generators and the amount of current consumption is gauged.

One of the disadvantages of primary cells, as those types which utilize zinc as a negative element are called, is that the chemical action produces deterioration and waste of material by oxidization. Dry cells are usually proportioned so that the electrolyte and depolarizing materials become weaker as the zinc is used and when a dry cell is exhausted it is not profitable to attempt to recharge it because new ones can be obtained at a lower cost than the expense of renewing the worn elements would be.

The number of dry cells necessary will vary with the system of ignition employed and the size of the motor. While two or three cells will ignite small engines such as used in motorcycles, five or six will be needed on automobile engines employing high-tension ignition. When the make-and-break system, or low-tension method, is used eight or ten cells are necessary. If the engine is a multiple cylinder one, it will draw more current than a single cylinder type because of the greater frequency of sparks. On four-cylinder cars dry cells should be joined in multiple series, which is the most economical arrangement. Cells used in multiple connection are more enduring than if the same number were used independently in single-series connection. A disadvantage of a dry cell battery is that it is suited only for intermittent service and it will soon become exhausted if used where the current demands are severe. For this reason most automobiles in which batteries are used for ignition employ storage or secondary batteries to furnish the current regularly used and a set of dry cells is provided for use only in cases of emergency when the storage battery becomes exhausted. A modern form of dry cell is

shown in section at Fig. 354-A and the method of testing the current strength is depicted at Fig. 354-B.

Principles of Storage Battery Construction.—Some voltaic couples are reversible, i. e., they may be recharged when they have become exhausted by passing a current of electricity through them in a direction opposite to that in which the current flows on discharge. Such batteries are known as "accumulators" or "storage batteries." A storage battery belies its name as it does not store current and its action is somewhat similar to that of the simpler chemical cell previously described. In its simplest form a storage cell would consist of two

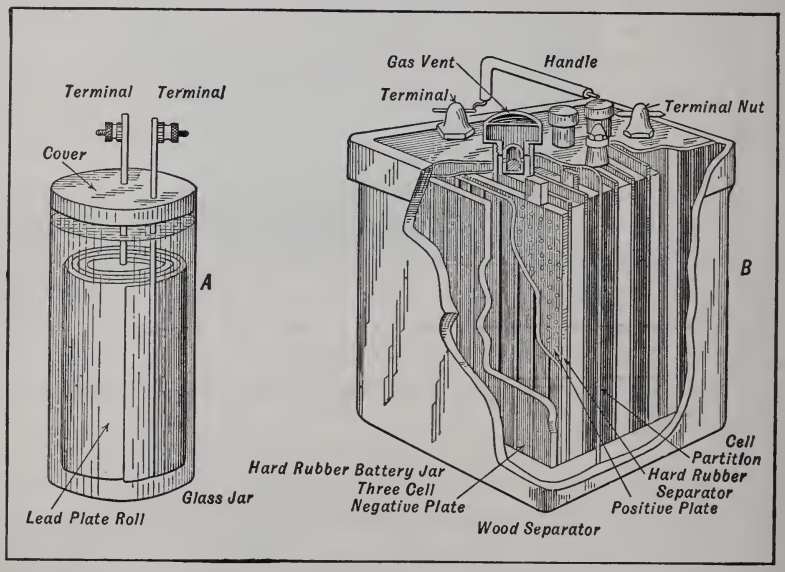


Fig. 355.—Types of Accumulators or Storage Batteries. A—Simple Form of Cell. B—Battery Composed of Three Cells Used Only for Ignition Because of Low Capacity, Small Plates.

elements and an electrolyte, as outlined at Fig. 355-A. The storage battery differs from the primary cell in that the elements are composed of the same metal before charging takes place, usually lead instead of being zinc or carbon. One of the plates is termed the "positive" and may be distinguished from the other because it is brown or chocolate in color after charging, while the negative plate is usually a light gray or leaden color. The active material of a charged storage battery is not metallic lead but oxides of that material.

The simple form shown at A consists of two plates of lead which are rolled together separated by insulating bands of rubber at the top

and bottom to keep them from touching. This roll is immersed in an electrolyte composed of a weak solution of sulphuric acid in water. Before such a cell can be used it must be charged, which consists of passing a current of electricity through it until the lead plates have changed their nature. After the charging process is complete the lead plates have become so changed in nature that they may be considered as different substances and a chemical action results between the negative plate and the electrolyte and produces current just as in the simple cell shown at Fig. 352-A. When the cell is exhausted the plates return to their metallic condition and are practically the same, and as there is but little difference in electrical condition existing between them, they do not deliver any current until electricity has been passed through the cell so as to change the lead plates to oxides of lead instead of metallic lead.

When storage cells are to be used in automobile work they are combined in a single containing member, as shown at Fig. 355-B, which is a part sectional view of a storage battery used for ignition purposes. The main containing member, a jar of hard rubber, is divided into three parts. Each of these compartments serves to hold the elements comprising one cell. The positive and negative plates are spaced apart by wood and hard rubber separators which prevent short circuiting between the plates. After the elements have been put in place in the compartments forming the individual cells of the battery, the top of the jar is sealed by pouring a compound of pitch and rosin, or asphaltum, over plates of hard rubber, which keeps the sealing material from running into the cells and on the plates. Vents are provided over each cell through which gases produced by charging or discharging are allowed to escape. These are so formed that while free passage of gas is provided for, it is not possible for the electrolyte to splash out when the vehicle is in motion.

It will be evident that this method of sealing would not be practical on a cell where the members attacked by the acid had to be replaced from time to time, but in a storage battery only the electrolyte need be renewed. When the plates are discharged they are regenerated by passing a current of electricity through them. New electrolyte can be easily inserted through caps in which the vents are screwed. The cells of which a storage battery is composed are joined together at the factory with bars of lead which are burned in place and only two free terminals are provided by which the battery is coupled to the outer circuit. A typical heavy duty battery, such as used for automobile starting and lighting, is shown at Fig. 354-C.

The capacity of a storage battery depends upon the size and the

number of plates per cell, while the potential or voltage is determined by the number of cells joined in series to form the battery. Each cell has a difference of potential of two and two-tenths volts when fully charged, therefore a two-cell battery will deliver a current of four and four-tenths volts and a three-cell type, as shown at Fig. 354, will give about six and six-tenths volts between the terminals. In the form shown each cell is composed of four plates and their separators. Two of the plates are positive, the remaining two negative members. The size of storage battery to be used depends upon the number of cylinders of the engine. Four-cylinder motors usually take a six-volt, sixty-ampere-hour battery, but it is desirable to supply a six-volt battery having eighty-ampere-hour capacity for six-cylinder motors.

When chemical current producers are depended upon to supply the electricity used for ignition, two distinct sets are provided, one for regular service and the other for emergency use in event of failure of that which is depended upon regularly. The common practice is to provide an accumulator or storage battery for normal use and a set of dry cells, which are cheaper in first cost and which do not deteriorate if not used for some time, for emergency service. When two sources of current are thus provided, a switch is included in the circuit so that either set may be used at will. The zinc terminal of the dry battery and the negative terminal of the storage battery are joined together by a suitable conductor and are grounded by running the wire attached to them to some metal part of the chassis such as the crank case or frame side member. The remaining terminals, which are the positive of the storage battery and the carbon of the dry cell, are coupled to distinct terminals on the switch block.

The fact that any battery cannot maintain a constant supply of electricity has militated against their use to a certain extent and the modern motorist demands some form of mechanical generator driven from the power plant, which will deliver an unfailing supply of electricity. The strength of batteries is reduced according to the amount of service they give. The more they are used the weaker they become. The modern multiple cylinder engines are especially severe in their requirements upon the current producer and the rapid sequence of explosions in the average four- or six-cylinder motor produce practically a steady drain upon the battery. When dry cells are used their discharge rate is very low and as they are designed only for intermittent work, when the conditions are such that a constant flow of current is required, they are unsuitable and will soon deteriorate.

The same objection applies to a certain extent to the storage bat-

tery, though this form of current producer is more practical for use where a steady flow of current is desired. The same objection advanced against the dry cell that the current becomes weaker as the cell is used applies equally well to the storage battery. This has made it imperative that one of the various forms of mechanical generators be employed as a source of electricity for regular ignition service. Such devices are driven directly from the engine and the amount of energy they deliver is proportionate to the speed of rotation up to a certain point, where an automatic regulator cuts down the current output to prevent damage to the windings. When the engine is accelerated and more electricity is needed, the mechanical generator speed increases directly as that of the driving source, and more current is delivered as the demands upon the generator augment if it is a magnetic type.

Dynamo Electric Machines.—Two distinct types of mechanical generators are in common use and while their principles of action are practically the same, they differ somewhat in construction and application. The forms first used to succeed the battery were modifications of the larger dynamo electric machines used for delivering current for power and lighting. Later developments resulted in the simplification of the dynamo, by which it was made lighter and more efficient, and the modern magneto igniter is the form furnished on some power plants. A dynamo uses electro-magnets to produce a magnetic field for the armature to revolve in and is necessarily somewhat heavier and larger than a magneto of equal capacity because the field in the latter instrument is produced by permanent magnets. An important advantage in using the magneto form of construction is that the weight of the windings is saved because the permanent magnets retain their magnetism and do not require the continual energizing that an electro-magnet demands.

The dynamo construction is superior where a continual drain is made upon the apparatus, because if a magneto is used continuously the magnets are liable to lose some of their strength and as the magnetic field existing between the pole pieces decreases in value the amount of current delivered by the apparatus diminishes in direct proportion. When electro-magnets are used the constant flow of electrical energy through the windings keeps them energized to the proper point, and as current is continuously supplied, the strength of the magnetic field remains constant. The dynamo form of generator is utilized where currents of considerable value are needed, such as in electric lighting and starting systems now universally used on automobiles.

Where the device is depended upon only to furnish ignition current the magneto is preferred by most engineers because it is simpler

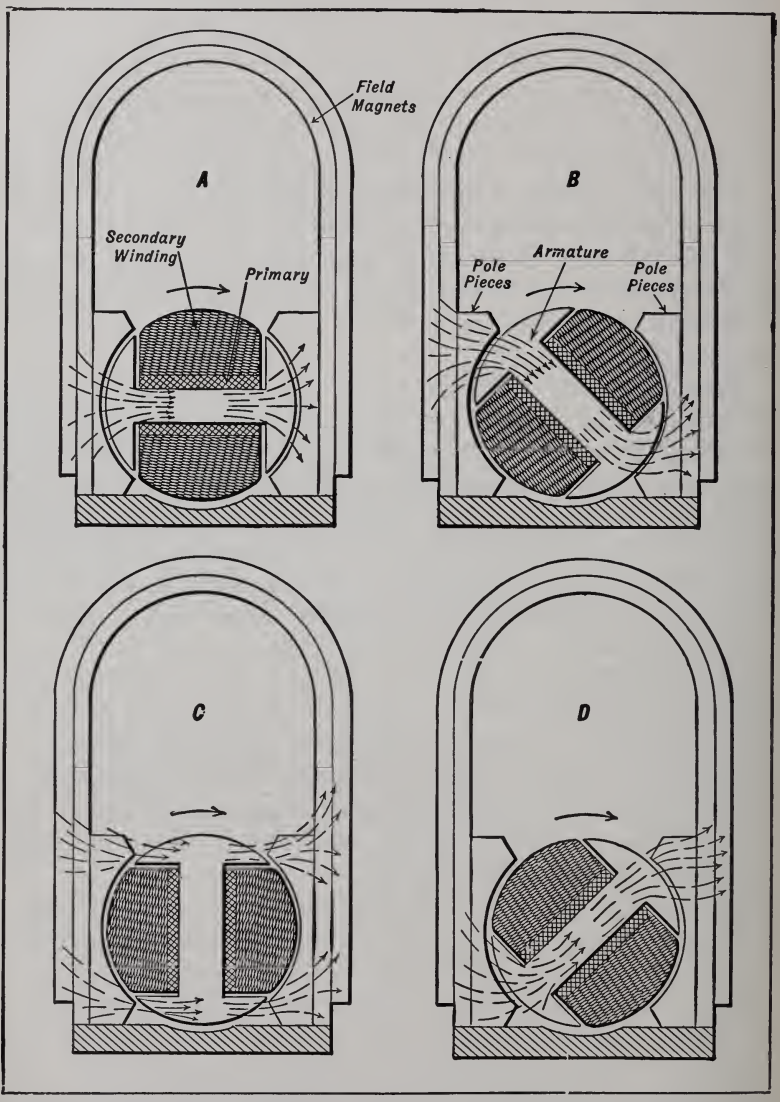


Fig. 356.—Showing How Strength of Magnetic Influence and of the Current Induced in the Windings of Magneto Armature Vary with the Rapidity of Changes of Direction in Flow.

and lighter than the dynamo, and also because it may be made in such form that it will comprise a complete ignition system in itself. When

a dynamo is utilized the conditions are just the same, as far as necessary auxiliary apparatus is concerned, as though batteries were used and one merely substitutes a mechanical generator in place of the chemical cells. The same auxiliary apparatus necessary in one case is employed in the other as well, and in most modern ignition systems the dynamo is used to keep a storage battery charged and the ignition current is really taken from this battery.

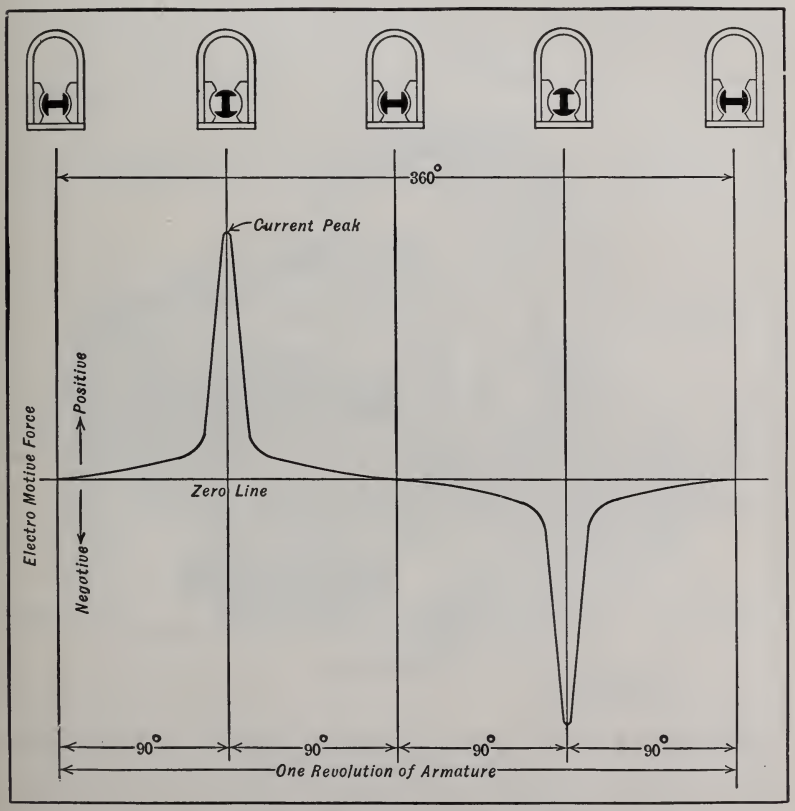


Fig. 357.—Diagram Showing How Magneto Current Strength Fluctuates with Varying Armature Positions.

A dynamo or magneto produces electricity by an inductive action, which is a reversal of the phenomena by which a current of electricity flowing around a bar of iron or steel makes a magnet of it. If a wire through which a current of electricity is flowing will magnetize a bar of iron, a bar of steel which is already magnetized will generate a current of electricity by induction in a conductor surrounding it if

either the magnet or the coil of wire is moved in such a manner that the magnetic influence is traversed or traverses the wire. In a dynamo or magneto a coil of wire mounted on a suitable armature is revolved between the pole pieces of the field magnet and as the conductor cuts across the zone of magnetic influence a current of electricity is induced in the coil. The various views at Fig. 356 show how the magnetism passes through the wiring on the armature core. The greatest current generation is when the armature is just leaving the position shown at C for that outlined at D. The diagram at Fig. 357 shows how the current value fluctuates in a magneto for each armature position. The faster the coil is rotated the more rapidly the winding passes through the magnetic field. As an electrical impulse is produced every time the magnetic field is traversed, it is patent that the greater number of electrical impulses will produce a current of higher value.

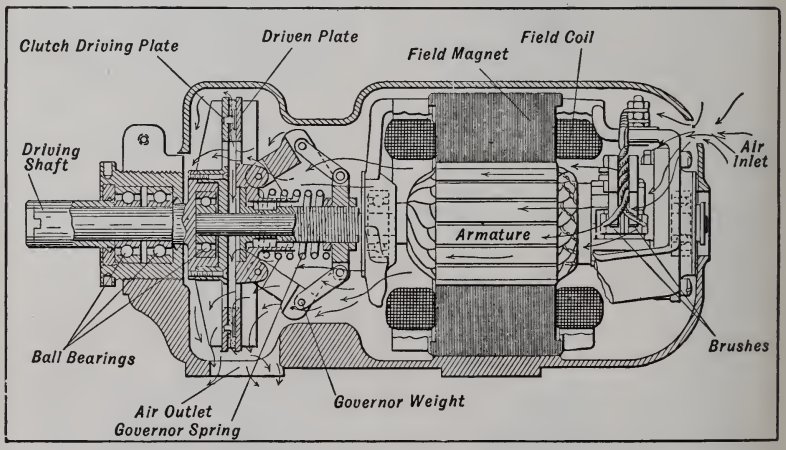


Fig. 358.—Gray & Davis Governed Dynamo and Appliance for Producing Electricity by Mechanical Means.

A sectional view of a typical dynamo electric machine of conventional design is shown at Fig. 358. All parts are clearly indicated and there should be no difficulty in understanding the principles of operation. The three main portions of the dynamo are the field magnets, which produce the magnetic field, the armature, which carries the coils of wire and which is mounted between the extremities or pole pieces of the magnet, and the brushes, which bear against segments of a collecting device known as a commutator serving to convey the current to terminals which are joined to the outer circuit. In the

form shown the field magnets are composed of a number of iron stampings which are surrounded by a coil of wire, and two such magnets are provided, one above, the other below the armature. The armature is supported on a shaft mounted in ball bearings so that it will turn with minimum friction. The whole mechanism is protected by an outer casing.

The device shown is a constant speed dynamo, i. e., it should be operated at a certain speed to obtain the best results. If run faster

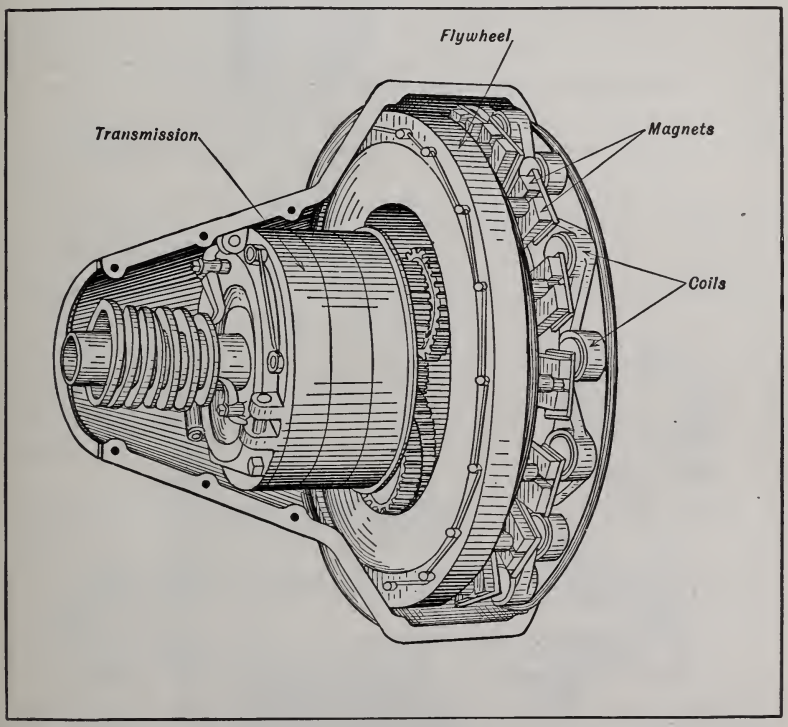


Fig. 359.—Distinctive Form of Current Producer Used in Ford Cars is Incorporated in the Power Plant Fly Wheel.

than the speed for which it is designed the excess current generated is liable to burn out the windings of the field magnet. For this reason a governor of the fly ball type is interposed between the dynamo armature and the driving shaft coupled to the source of power. At all normal speeds the tension of the governor spring keeps the two plates of the clutch in contact and the armature is turned at the same speed as the driving shaft.

Should the driving shaft speed exceed a certain predetermined limit the governor weights will fly out by centrifugal force and the governor spring will be compressed so the driving and driven plates of the clutch are separated and the driving shaft revolves independently of the armature. As soon as the armature speed becomes re-

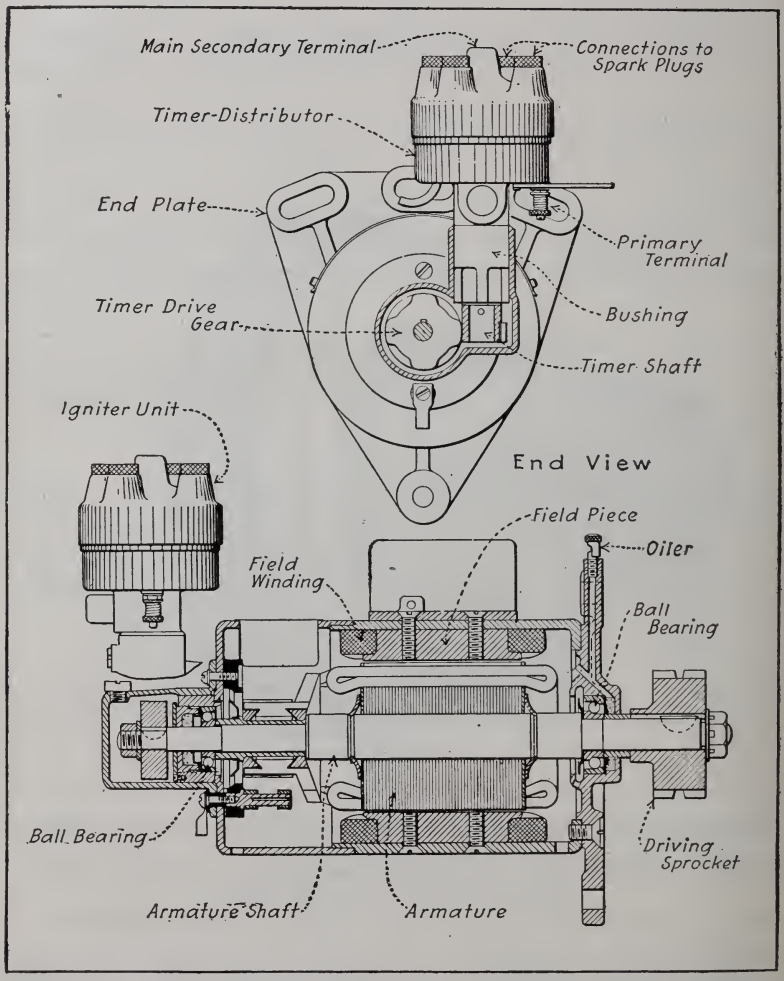


Fig. 360.—Sectional View of Small Dynamo with Integral Ignition Timing Device.

duced sufficiently to allow the governor spring to overcome the centrifugal force and draw back the governor weights, the clutch plates are again brought into contact and the armature is again joined to the driving shaft. All dynamos are not governed by centrifugal

governors, the current output of most of the late patterns, such as shown at Fig. 360, is governed by external resistance coils brought into action automatically or by inherent governing by a system of bucking currents to reduce the field magnet strength. The device shown includes a timer-distributor unit driven from the armature shaft by spiral gears.

A current of air is kept circulating through the casing by means of the fan action of the reënforcing webs of the clutch plate, the object being to absorb any heat which may be produced while the dynamo is in action. An appliance of this nature may be driven from the engine by belt, chain, or gear connection. It will deliver low voltage current which must be transformed by means of an induction coil to current of higher value in order that it may be successfully utilized to produce the spark in the combustion chambers of the engine.

A very ingenious application of the dynamo is shown at Fig. 359. The electric generator is built in such a manner that it forms an integral part of the power plant. The magneto field is produced by a series of revolving magnets which are joined to and turn with the fly wheel of the motor. The armature coils are carried by a fixed plate which is attached to the engine base. This apparatus is really a magneto having a revolving field and a fixed armature, and as the magnets are driven from the fly wheel there is no driving connection to get out of order and cause trouble. As the coils in which the current is generated are stationary, no commutator or brushes are needed to collect the current because the electricity may be easily taken from the fixed coils by direct connection. It has been advanced that this form of magneto is not as efficient as the conventional patterns because more metal and wire are needed to produce the current required. As the magnets which form the heavier portion of the apparatus are joined to the fly wheel, which can be correspondingly lighter, this disadvantage is not one that can be considered seriously because the magnet weight is added to that of the motor fly wheel, the combined weight of the two being that of an ordinary balance member used on any other engine of equal power.

Timer and Distributor Forms.—Anyone familiar with the basic principles of internal combustion engine action will recognize the need of incorporating some device in the ignition system, which will insure that the igniting spark will occur only in the cylinder that is ready to be fired and at the right time in the cycle of operations. There is a certain definite point at which the spark must take place, this having been determined to be at the end of the compres-

sion upstroke, at which time the gas has been properly compacted and the piston is about to start returning to the bottom of the cylinder again. Timers or distributors are a form of switch designed so that hundreds of positive contacts which are necessary to close and open the circuit may be made per minute without failure.

When the device is employed to open and close a low-tension circuit, it is known as a commutator or timer, and when used in connection with current of high voltage they are called secondary distributors. Certain constructional details make one form different from the other, and while they perform the same functions they vary in design. Such distributing devices are always driven by positive gear-

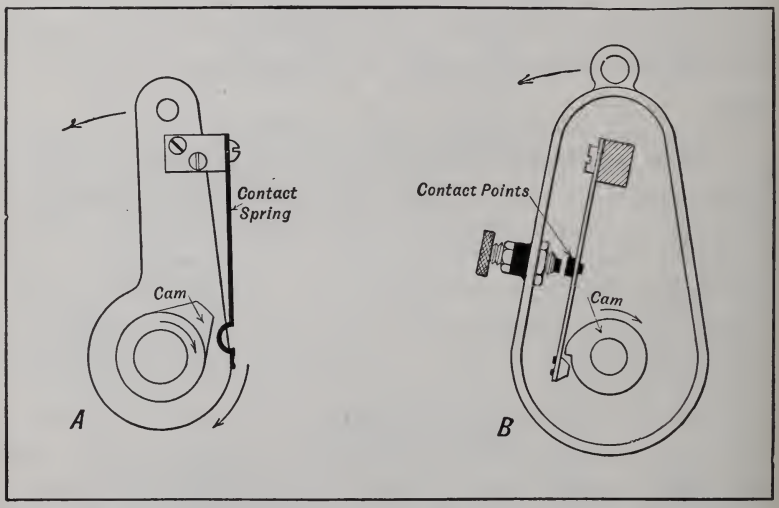


Fig. 361.—Early Simple Forms of Contact Breakers Used on One-Cylinder Engines. A—Wipe Contact. B—Touch Contact.

ing from the engine and are timed so the sparks will occur in the cylinders at just the proper ignition time. The usual construction is to use a fixed case which carries one or more contact members suitably disposed around its periphery and a central revolving member or cam which contacts with the points on the body of the device to close any desired circuit. On a four-cylinder four-cycle engine the cam is revolved at one-half the engine speed and the timer is usually driven from the cam shaft. In two-cycle engines the revolving member of the timer turns at engine speed, and should be driven directly from and at the same speed as the crankshaft.

Simple timer forms suitable for one-cylinder motors which are seldom used except in simple marine and stationary installations are

shown at Fig. 361. The simplest one, depicted at A, consists of a rocking member of fiber or other insulating material which carries a steel spring that is normally out of engagement with the surface of the cam. When the point of the cam brushes by the contact spring, any circuit in which the device is incorporated will be closed and current will flow from the battery or dynamo to the transformer coils and spark plugs which are depended on to furnish a spark of sufficient intensity to insure ignition of the gas. It is desirable that the member which carries the contact spring be capable of a certain degree of movement, in order that the spark time may be advanced or retarded to suit various running conditions. In the form shown if the top of the casing is pushed in the direction of the arrow, the contact spring will come in contact with the point of the cam which is turning in the direction indicated sooner than it will if the base member is rocked in a reverse direction and the contact spring pulled away from the point of the cam instead of being moved forward to meet it. The wipe contact form is the simplest, but the spring is liable to wear at the point of contact and may break off and cause trouble. Such a device is more suitable for low-speed engines than it is for those which have high crank-shaft velocity.

The single-cylinder timer depicted at B is a form that is widely used on high-speed engines and contact is made between a pair of platinum contact points which just touch each other instead of wiping. Platinum is a material that is not affected by the arcing or heat of the spark as much as steel or brass would be and provides a more positive contact. In the wipe contact form the continual brushing action of the cam against the spring tends to keep the contact surfaces clean, but this condition does not obtain in the simple touch contact of the form shown at B. The casing is rocked in the direction of the arrow to advance a spark in either case. The form shown at B is more economical of current because the contact is shorter and is more suitable for high-speed engines. While the forms considered prove practical in their application to simple one- and two-cylinder engine forms, they are very heavy or clumsy appliances when used for four-cylinder engines, as it is very hard to assemble the spring element so that the contact will take place at the proper point in all cylinders. Modified forms having a special contact arrangement such as used in magneto contact breakers and using a multi-point cam are now widely used on all types of engines.

When a timer is to be used in connection with a four- or six-cylinder engine the compact form shown at Fig. 362, A, is adopted. This has many desirable features and permits of timing the spark with

reasonable accuracy. The contact segments are spaced on quarters or sixths and are imbedded in a ring of fiber which is retained in a casing of aluminum. The central revolving element carries a lever which has a roll at one end and a tension spring designed to keep the roller in contact with the inner periphery of the fiber ring at the other. The segments are of steel and are accurately machined and hardened, and as the surface of the roller is also hardened, this form of timer is used with vibrator coil ignition because it provides a positive contact and works smoothly at all engine speeds.

An old style secondary distributor which was employed to distribute both high- and low-tension current is shown at Fig. 362, B.

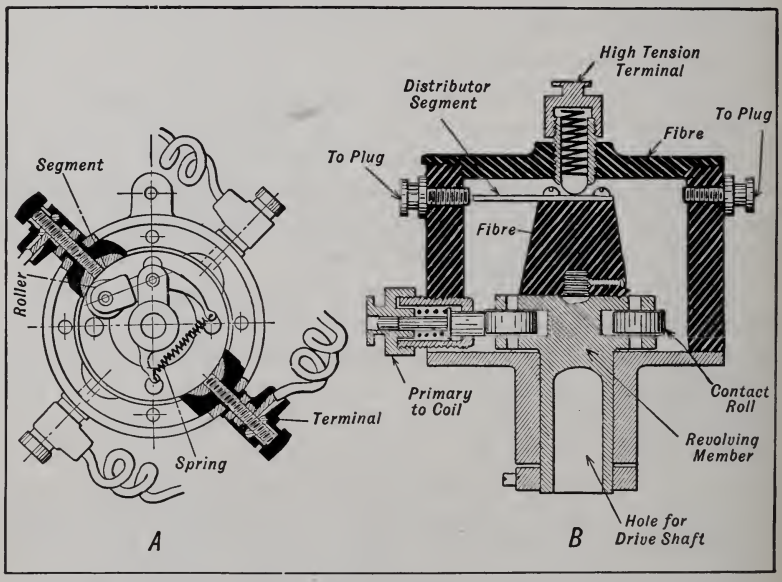


Fig. 362.—Timers of Early Design Employed on Four-Cylinder Engines.

This consists of a primary timing arrangement in the lower portion, and a secondary current-distributing segment at the upper portion. The central revolving member carries as many rolls as there are cylinders to be fired, these being spaced at the proper points in the circle to insure correct timing. One primary contact member is screwed into the casing, this contacting with the rolls as they revolve. At the upper portion of the case a number of terminals are inserted from which wires lead to plugs in the cylinders. When a timer of the form shown at Fig. 362, A, is used a separate vibrator type induction coil is needed for each cylinder and the number of units in the coil box and

contact points on the timer will be the same as the number of cylinders to be fired. When a secondary distributor is employed but one induction coil is needed for all cylinders, because the secondary or high-tension current from one unit is distributed to the spark plugs at the

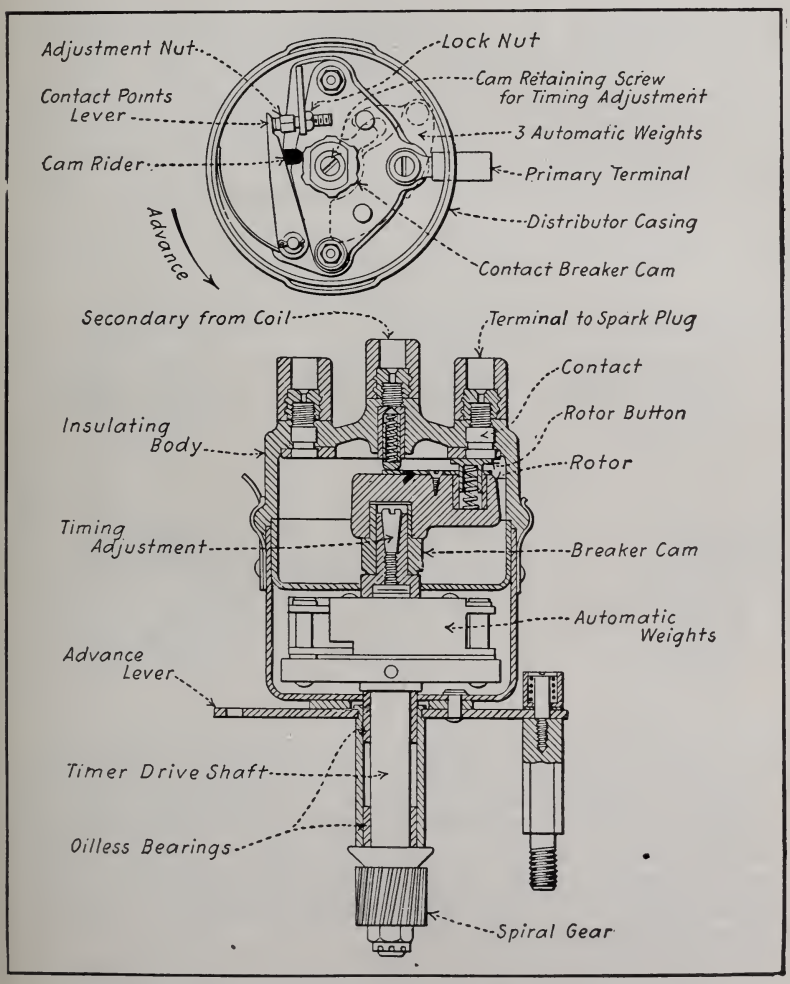


Fig. 363.—The Delco Timer-Distributor with Simple Automatic Spark Advance.

proper time. Various wiring diagrams will be presented to show the methods of using timers and distributors, both in the vibrator and non-vibrator coil forms. The latter is much more popular now and the timing device used follows the general form of that shown at Fig. 363. This has an automatic spark advance arrangement in the base. It will

be noticed that the high-tension portion of the distributor is well insulated from the primary circuit closing member at the lower end. This is necessary because current of high voltage is much more difficult to handle than that of lower pressure, and it is more liable to short circuit.

The arrangement of the contact points for various numbers of cylinders in roller contact timers is shown at Fig. 363. At A but one segment is provided, this obviously serving only one cylinder. The form depicted at B is utilized with a double-cylinder opposed motor or a twin-cylinder vertical type in which both connecting rods act on a common crank pin or crank pins in the same plane. As the

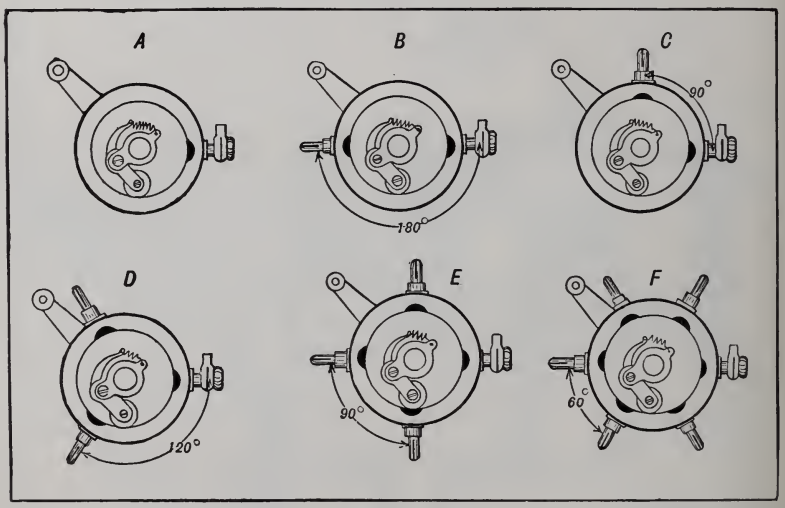


Fig. 364.—Diagrams Showing Disposition of Contact Points on Roller Contact Timers for Various Numbers of Cylinders. A—One-Cylinder Type. B—Arrangement for Two-Cylinder Opposed Motor. C—Contacts Separated by 90 Degrees in One Direction and 270 Degrees in the Other when Used on Two-Cylinder Vertical Engine with Opposed Crankpins. D—Three-Cylinder Type. E—Suitable for Four-Cylinder Engines. F—Type Employed on Six-Cylinder Power Plants.

explosions are evenly spaced and the intervals separating the sparks are equal, the contact segments are placed diametrically opposite and are separated by a space of 180 degrees. If the two-cylinder engine is a vertical form having opposed cranks, the explosions will not be separated by equal intervals, so the segments must be placed to compensate for the difference which exists in the time interval separating the power impulses. Two contact segments are imbedded in the in-

sulating ring, the contacts being separated by a space of 90 degrees on one side and 270 degrees on the other. This form of timer is seldom used at the present time because the two-cylinder engine of the pattern for which it is adapted has been practically discarded.

When three cylinders are used the contact points are separated by a space of 120 degrees, as shown at D. In a four-cylinder timer the contact segments are spaced on quarters of the circle and are separated by a space equal to 90 degrees. With a six-cylinder motor six segments are necessary, these being separated by a space of 60 degrees, as shown at F. In the newly designed timer-distributors it is the secondary terminals that are spaced as indicated above, and as but one ignition coil is used on engines up to six cylinders the cam has as many projections as there are cylinders to be fired. Before considering the other components of a battery ignition system it would be well to outline the essential elements of a simple ignition group so that the circuit and flow of current may be easily followed.

Essential Elements of Simple Ignition System.—The current obtained from the dry or storage battery or low-tension dynamo or magneto is not sufficiently powerful to leap the gap which exists between the points of the spark plug in the cylinder unless it is transformed to a current having a higher potential. The air gap between the points of the spark plug has a resistance which requires several thousand volts pressure to overcome, and as a battery will only deliver six to eight volts, it will be evident that, unless the current value is increased, it could not produce a spark between the plug electrodes.

The low voltage current is transformed to one of higher potential by means of a device known as the induction coil. The current from the battery is passed through the primary coil, which is composed of several layers of coarse wire wound around a core of soft iron wire to form an electro-magnet as shown at Fig. 365. Surrounding this primary coil is one composed of a large number of turns of finer conductor. When a current of electricity of low voltage passes through the primary coil, a current of very high electro-motive force is produced in the secondary winding. One end of each coil is grounded. The free end of the primary coil is coupled to the battery while that of the secondary coil is attached to the insulated terminal of the spark plug.

The arrangement of wiring at Fig. 365 is that employed in a typical transformer coil of the vibrator type, which is used to increase the voltage of the current sufficiently to cause it to overcome the resistance of the air gap at the spark plug and produce a spark which

will ignite the gas. In the primary circuit are included a suitable timer for closing the circuit, a battery of chemical cells to supply the energizing current, and a vibrator or make-and-break mechanism on the coil. The secondary circuit includes the spark plug and the secondary

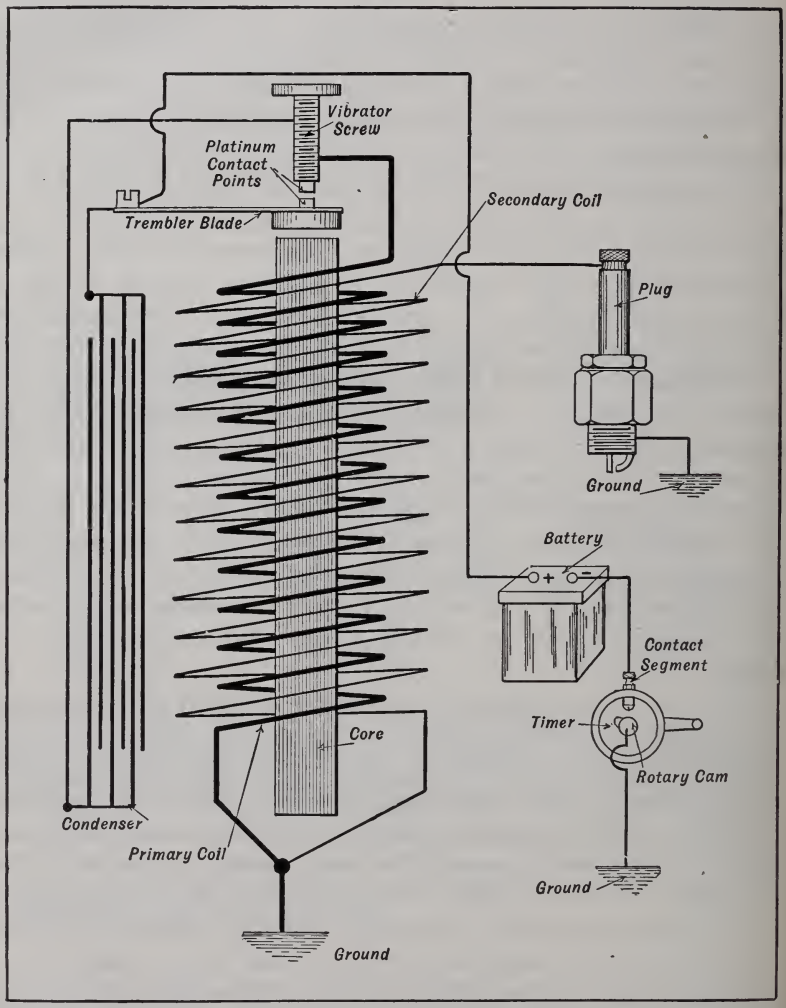


Fig. 365.—Simple Ignition System for One-Cylinder Motor, Showing Important Components and Their Relation to Each Other.

winding of the coil. Most modern ignition coils are of the non-vibrator type, but operate on the same principle, except that only one spark occurs for each contact of the platinum points.

When the primary circuit is closed by the cam of the timer making contact with the segment, the current from the battery flows through the primary coil of the transformer. This magnetizes the core which draws down the trembler blade, this in turn separating the platinum contact point of the vibrator and interrupting the current. As soon as the current is interrupted at the vibrator the core ceases to be a magnet and the trembler blade flies back and once again closes the circuit between the platinum points. Every time the circuit is made and broken at the vibrator an electrical impulse is induced in the secondary winding of the coil.

The vibrator may be adjusted so that it will make and break the circuit many times a second, and as a current of high potential is produced in the secondary winding with each impulse, an intense but short spark will be produced between the points of the spark plug. The condenser is a device composed of layers of tin foil separated from each other by waxed or varnished paper insulation. It is utilized to absorb some of the excess current produced between the vibrator points, which causes sparking. This extra current is induced by the action of the primary coils of wire upon each other and by a reversed induction influence from the secondary coil.

If this current is not taken care of, it will impede the passage of the primary current and the sparks are apt to burn or pit the platinum contact points of the vibrator. When a condenser is provided the extra primary current is absorbed by the sheets of tin foil which become charged with electricity. When contact is made again the condenser discharges the current in the same direction as that flowing through the primary coil from the battery and the value of the latter is increased proportionately. There is less sparking between the vibrator points and a stronger current is induced in the secondary coil which in turn produces a more intense spark between the points of the spark plug.

A typical induction coil such as would be used for firing a one-cylinder engine if used with a simple timer, or a multiple-cylinder engine if used in connection with a combined timer and distributor, is depicted in part section at Fig. 366. It will be observed that three terminal screws are provided on the box, one designed to be attached to the battery, the other two to the spark plug and ground, respectively. The terminal to which the battery wire is attached is coupled to the bridge member which carries the contact screw while the vibrator blade is connected with one of the ends of the primary coil. The other end of the primary coil goes to the terminal which is joined to the ground. The condenser is shunted in between the vibrator

points, i. e., one of the leads is attached to terminal No. 1 while the other is soldered to the end of the primary coil which goes on the vibrator spring member. One end of the secondary coil is attached to terminal No. 2, which is grounded on some metal part of the chassis frame, while the other end is secured to terminal No. 3, which is joined to the spark plug electrode. After the various components of the induction coil are assembled in the box and the connections made as indicated, the spaces between the sides of the box and the coil member are filled with an insulating compound composed of beeswax, pitch and rosin. This holds everything rigidly in place and prevents the wire joints loosening through vibration.

The method of connecting the members of an induction coil, shown at Fig. 366, is a conventional one, though the connections will differ

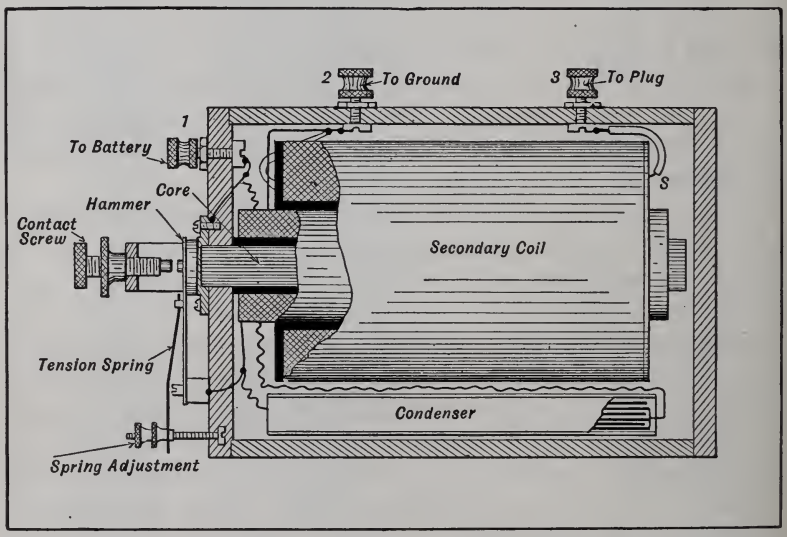


Fig. 366.—Part Sectional View of Simple Induction Coil of the Vibrator Type.

with the nature of the circuit of which the coil forms a part and the number of units comprising the coil assembly. When such devices are employed for igniting multiple-cylinder motors, the internal wiring is very much the same as though the same number of box coils for single-cylinder ignition were combined together by outside conductors. The number of terminals provided will vary with the number of units.

Various forms of induction coils are depicted at Fig. 367. That at A is a simple unit form in which the coil is attached directly to

the spark plug, which in turn is screwed into the cylinder. On this coil but two primary terminals are attached, one being connected to the insulated contact point on the timer, the other being grounded,

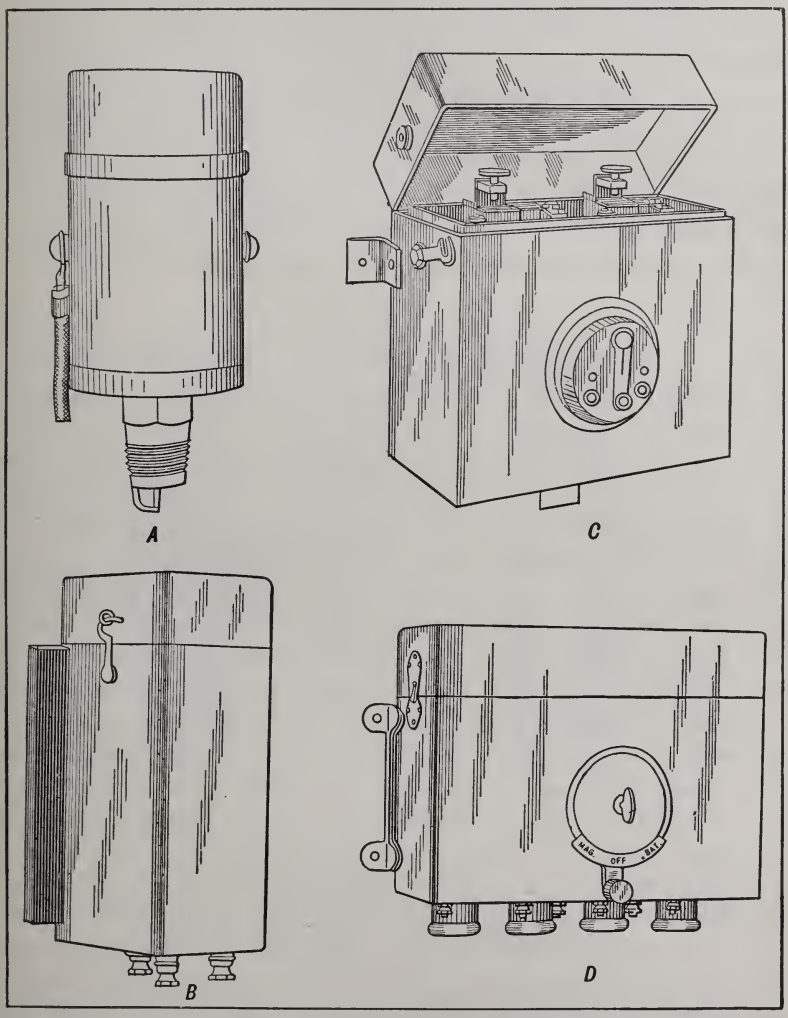


Fig. 367.—Conventional Vibrator Induction Coil Forms. A—Coil Unit and Spark Plug Combined. B—Simple Box Coil for One-Cylinder Ignition. C—Two-Unit Coil for Two-Cylinder Motors. D—Four-Unit Coil for Four-Cylinder Service.

or attached to the battery. Coils of this type have been very popular in marine application because of the simple and direct wiring possible, but they have not been used in connection with automobile engine

ignition to any extent. The form shown at B is a simple dash coil for one-cylinder use which has three terminals, one being used for a secondary lead to the spark plug, the other two being joined to the battery and ground respectively, as shown at Fig. 366.

The form of coil shown at C is a two-unit member designed for double-cylinder ignition. As the switch is mounted on the coil box to use two sets of batteries, six terminals are provided on the bottom of the coil case. Two of these are attached directly to the insulated contact point of the timer; two others which are enclosed in hard rubber insulating caps are attached to the spark plugs. The two immediately under the switch are attached to the free terminals of the battery, two sets being provided, one being coupled to each side of the switch.

With a four-unit coil, as shown at D, ten terminals are provided because of the attached switch. Four go to the spark plugs, four to the insulated segments of the timer and two to the battery, or battery and magneto or dynamo, as the case may be. In modern coils the units may be removed from the box without disturbing any internal connection, and a new one slipped in its place if it does not function properly. Special care is taken in insulating the high-tension terminal by means of rubber caps which surround the wire, and care is taken to have the vibrator contact points readily accessible for inspection, cleaning, or adjustment. Coils of the types illustrated are seldom used at the present time in automobile ignition systems, but are still popular in motor boat and stationary power-plant practice.

Spark Plug Design and Application.—With the high-tension system of ignition the spark is produced by a current of high voltage jumping between two points which break the complete circuit, which would exist otherwise in the secondary coil and its external connections. The spark plug is a simple device which consists of two terminal electrodes carried in a suitable shell member, which is screwed into the cylinder. Typical spark plugs are shown in section at Fig. 368 and the construction can be easily understood. The secondary wire from the coil is attached to a terminal at the top of a central electrode member, which is supported in a bushing of some form of insulating material. The type shown at A employs a molded porcelain as an insulator, while that depicted at B uses a bushing of mica. The insulating bushing and electrode are housed in a steel body, which is provided with a screw thread at the bottom, by which it is screwed into the combustion chamber.

When porcelain is used as an insulating material it is kept from direct contact with the metal portion by some form of yielding pack-

ing, usually asbestos. This is necessary because the steel and porcelain have different coefficients of expansion and some flexibility must be provided at the joints to permit the materials to expand differently when heated. The steel body of the plug which is screwed into the cylinder is in metallic contact with it and carries sparking points which form one of the terminals of the air gap over which the spark occurs. The current entering at the top of the plug cannot reach the ground, which is represented by the metal portion of the engine, until it has traversed the full length of the central electrode and overcome the resistance of the gap between it and the terminal point on the shell. The porcelain bushing is firmly seated against the

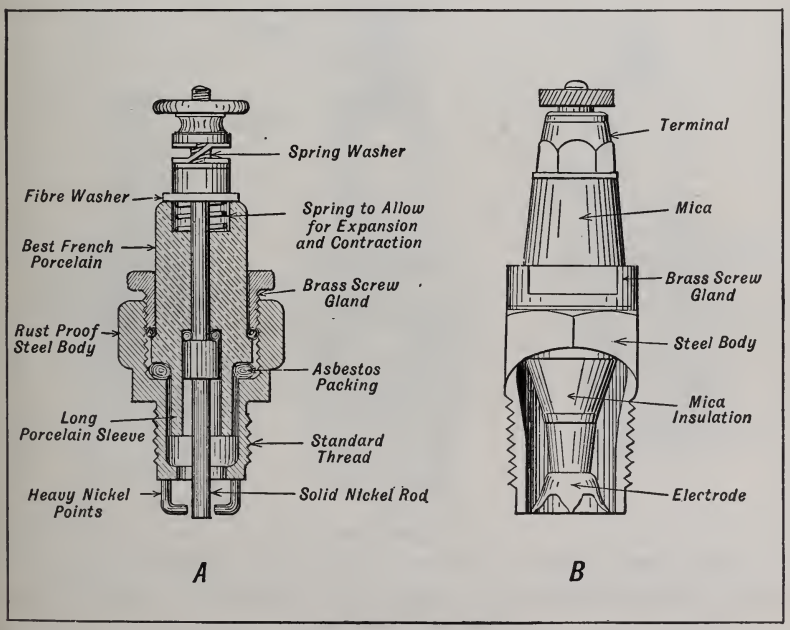


Fig. 368.—Spark Plug Construction Outlined. A—Sectional View of Porcelain Plug. B—Part Sectional View of Mica Plug.

asbestos packing by means of a brass screw gland which sets against a flange formed on the porcelain, and which screws into a thread at the upper portion of the plug body.

The mica plug shown at B is somewhat simpler in construction than that shown at A. The mica core which keeps the central electrode separated from the steel body is composed of several layers of pure sheet mica wound around the steel rod longitudinally, and hundreds of stamped steel washers which are forced over this member

and compacted under high pressure with some form of a binding material between them. Porcelain insulators are usually molded from high grade clay and are approximately of the shapes desired by the designers of the plug. The central electrode may be held in place by mechanical means such as nuts, packings, and a shoulder on the rod, as shown at A. Another method sometimes used is to cement the electrode in place by means of some form of fire-clay cement. Whatever method of fastening is used, it is imperative that the joints be absolutely tight so that no gas can escape at the time

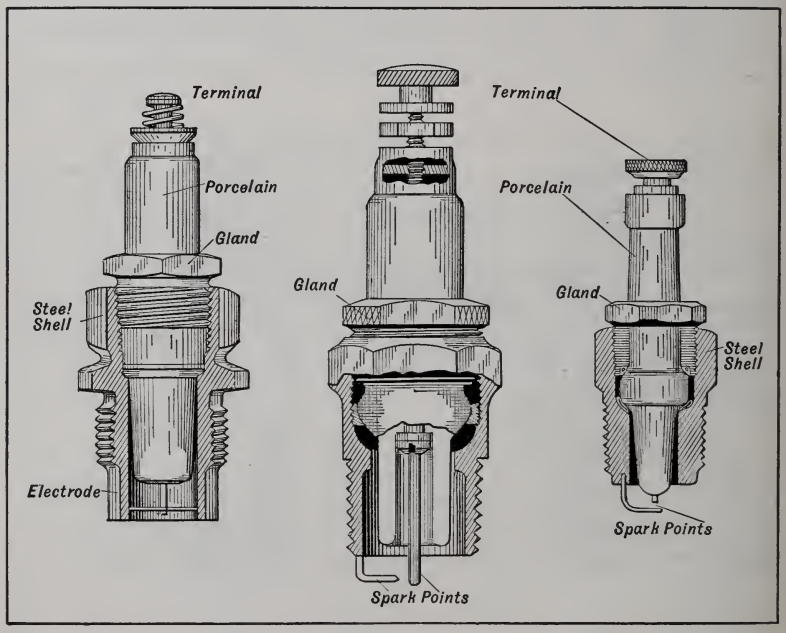


Fig. 369.—Three Forms of Spark Plugs, in which Electrodes are Separated by Porcelain Insulation.

of explosion. With a mica plug the electrode and the insulating bushing are really a unit construction and are assembled in permanent assembly at the time the plug is made.

Other insulating materials sometimes used are glass, steatite (which is a form of soapstone), and lava. Mica and porcelain are the two common materials used because they give the best results. Glass is liable to crack while lava or the soapstone insulating bushings absorb oil. The spark gap of the average plug is equal to about $\frac{1}{32}$ of an inch for coil ignition and from $\frac{1}{40}$ to $\frac{1}{64}$ of an inch when used in magneto circuits. A simple gauge for determining the gap

setting is the thickness of an ordinary visiting card for magneto plugs, or a space equal to the thickness of a worn dime for a coil plug. The insulating bushings are made in a number of different ways, and while details of construction vary, spark plugs do not differ essentially in design. Three different forms of plugs using porcelain insulation are shown in part section at Fig. 369. Porcelain is the material most widely used because it can be glazed so that it will not absorb oil, and it is subjected to such high temperature in baking that it is not liable to crack when heated.

The spark plugs may be screwed into any convenient part of the combustion chamber, the general practice being to install them in the caps over the inlet valves, or in the side of the combustion chamber, so the points will be directly in the path of the entering fresh gases from the carburetor. The methods of spark plug installation commonly used are shown at Fig. 370. At A the plug is screwed into

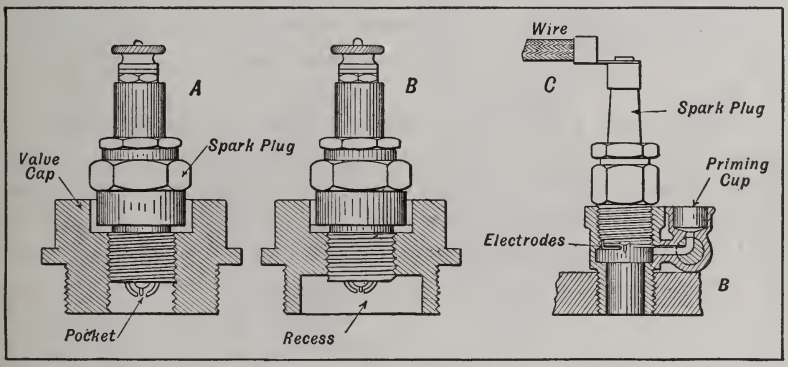


Fig. 370.—Methods of Installing Spark Plugs of Conventional Form. A—Incorrect Method. B—Correct Installation in Valve Chamber Cap. C—Combined with Cylinder Priming Device or Compression Relief Cock.

a threaded hole which passes through the valve cap in such a manner that the points are in a pocket. This is not considered to be as good as the method depicted at B, where the interior of the valve cap is recessed out so there is considerable space around the spark point. When the electrodes are carried in a pocket they are more liable to become short circuited by oil or carbon accumulations, because it is difficult for the fresh gases to reach them and the pocket tends to retain heat. Ignition is not so certain because some of the burned gases may be retained in the pocket and prevent the fresh gas from getting in around the spark gap. With a recess, as shown at B, conditions are more favorable because the fresh gases can sweep the points

of the spark plug and keep them clear, and also because of the larger space any burned products retained in the cylinder are not so apt to collect around the plug point.

On some types of engines which are not provided with compression relief, or priming cocks, plugs are sometimes installed, as shown at C. A special fitting, which carries a priming cup at one side, is screwed into the cylinder and the spark plug is fitted to its upper portion. When it is desired to relieve the compression, the valve portion is turned in such a way that a passage is provided from the interior of the fitting to the outer air. At the same time when the valve is in the position shown in illustration, gasoline may be introduced into the cylinder for priming purposes. It is advanced that this method of construction also provides a simple means of freeing the plug points from oil or particles of carbon if the cock is opened while the engine is running. The high pressure gas which brushes by the points on its way out of the cylinder tends to dislodge any particle of foreign matter which may be present near the spark gap. The same objections apply to this method of mounting as to that illustrated at A.

Spark plugs are made in many different forms and some have been designed with a view of permitting one to see if the charge is being exploded regularly in the cylinder by some form of transparent material for insulation, so that the light produced by the explosion could be seen from the outside of the cylinder. The simplest method of determining if a spark is occurring regularly between the points is to use some form of spark gap which is interposed between the source of current and the plug terminal. A device of this nature is shown at Fig. 371-A. It consists of a body of insulating material which carries in a glass tube two points, which are separated by a slight air space. The eye or hook end is attached to the plug terminal, while the other end is attached to the secondary wire. If the current is passing between the points of the plug, a spark will take place between the points of the auxiliary spark gap every time one occurs between the points of the plug in the cylinder.

It is claimed that there are certain advantages obtained when a spark gap is used in the circuit, in that the spark in the cylinder is more effective and less liable to be short circuited by particles of foreign matter. At the other hand, others contend that the current must be stronger to jump two gaps than would be required if only the resistance of one was to be overcome. While very popular at one time, the spark gap is of rather doubtful utility and is seldom used at the present time, except as a means of indicating if spark has

taken place between the points of the spark plug. It is apt to be somewhat misleading, however, because even if the points of the plug are short circuited and no spark is taking place between the plug points, and yet current is passing to the ground, a spark will continue to take place at the auxiliary spark gap. The device is useful in showing when there is a break or derangement of the wiring or coils.

A form of spark plug having glass bull eyes set into the plug shell or body is shown at Fig. 371, B. These simple lenses are made of

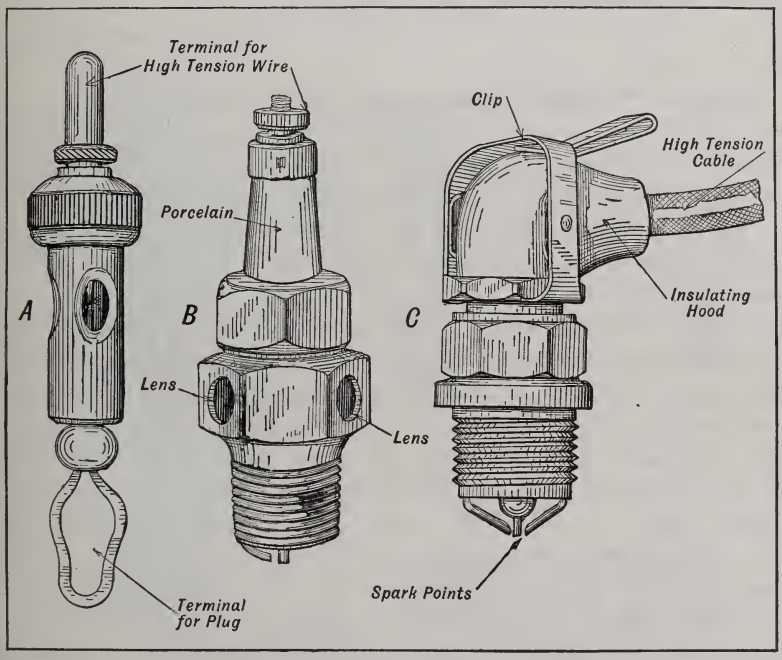


Fig. 371.—Novel Spark Plugs and Accessory Parts. A—Spark Gap Designed to Be Placed in Series with Plug Electrode and Current Source. B—Plug Shell with Glass Insets to Show Spark. C—Spark Plug with Waterproof Terminal Cover.

specially compounded glass, which has a high resistance to heat and every time an explosion takes place in the cylinder the light resulting causes a flash which is readily seen through the lens. If the flashing is regular it is safe to assume that the cylinder is functioning properly, but should the flashes be intermittent or separated by unequal intervals of time the cylinder is missing explosions.

It is often desirable to have a water-tight joint between the high-tension cable and the terminal screw on top of the insulating bush-

ing of the spark plug, especially in marine applications. The plug shown at C is provided with an insulating member or hood of porcelain, which is secured by a clip in such a manner that it makes a water-tight connection. Should the porcelain of a conventional form of plug become covered with water or dirty oil, the high-tension current is apt to run down this conducting material on the porcelain and reach the ground without having to complete its circuit by jumping the air gap and producing a spark. It will be evident that wherever a plug is exposed to the elements, which is often the case in motorcycle or motor-boat service, that it should be protected by an insulating hood which will keep the insulator dry and prevent short circuiting of the spark.

Plugs for Two-Spark Ignition.—On some forms of engines, especially those having large cylinders, it is sometimes difficult to secure complete combustion by using a single-spark plug. If the combustion is not rapid the efficiency of the engine will be reduced proportionately. The compressed charge in the cylinder does not ignite all at once or instantaneously, as many assume, but it is the strata of gas nearest the plug which is ignited first. This in turn sets fire to consecutive layers of the charge until the entire mass is aflame. One may compare the combustion of gas in the gas-engine cylinder to the phenomena which obtains when a heavy object is thrown into a pool of still water. First a small circle is seen at the point where the object has passed into the water, this circle in turn inducing other and larger circles until the whole surface of the pool has been agitated from the one central point. The method of igniting the gas is very similar as the spark ignites the circle of gas immediately adjacent to the sparking point, and this circle in turn ignites a little larger one concentric with it. The second circle of flame sets fire to more of the gas, and finally the entire contents of the combustion chamber are burning.

While ordinarily combustion is sufficiently rapid with a single plug so that the proper explosion is obtained at moderate engine speeds, if the engine is working fast and the cylinders are of large capacity, more power may be obtained by setting fire to the mixture at two different points instead of but one. This may be accomplished by using two sparking plugs in the cylinder instead of one, and experiments have shown that it is possible to gain from twenty-five to thirty per cent in motor power at high speed with two-spark plugs, because the combustion of the gas is accelerated by igniting the gas simultaneously in two places. To fit a double-spark system successfully, one of the plugs must be a double-pole member to which the high-

tension current is first delivered, while the other may be one of ordinary construction.

A typical double-pole plug is shown in section at Fig. 372, A. In this member two concentric electrodes are used, these being well insulated from each other. One of these is composed of the usual form passing through the center of the insulating bushing, while the other is a metal tube surrounding the tube of insulating material which is wound around the center wire. The current enters the plug through the terminal at the top in the usual manner, but it does not go to

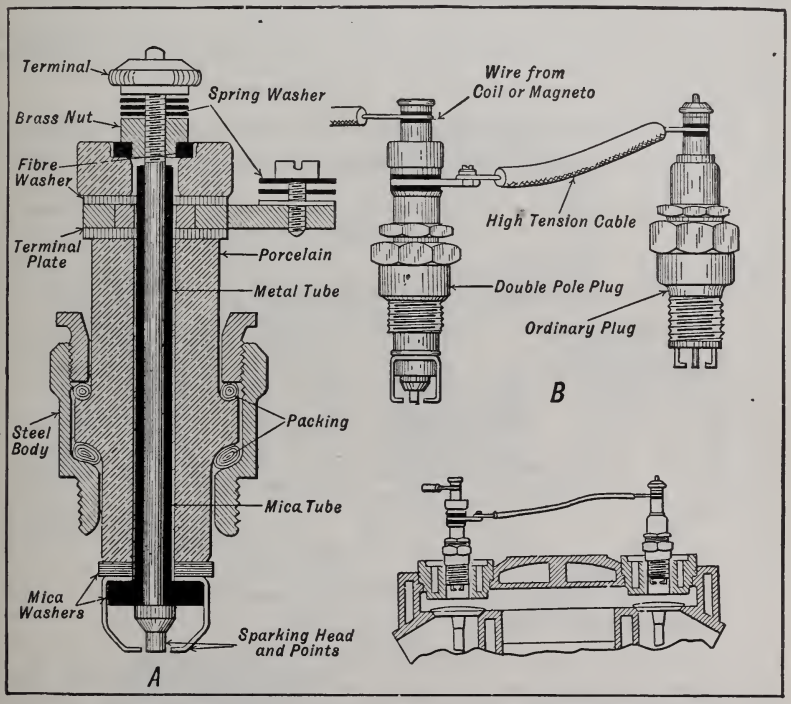


Fig. 372.—Double Pole Spark Plug and Method of Installing It to Obtain Two Sparks in Cylinder.

the ground because the sparking points are insulated from the steel body of the plug which screws into the cylinder. After the current has jumped the gap between the sparking head and the point, it flows back to the terminal plate at the top, from which it is conducted to the insulated terminal of the usual type plug.

The method of wiring these plugs is shown at Fig. 372, B. The secondary wire from the coil or magneto is attached to the central terminal of the double-pole plug, and another cable is attached to

the insulated terminal plate below it and to the terminal of the regular type plug. One is installed over the inlet valve, the other over the exhaust valve, if the system is fitted to a T head cylinder. Before the current can return to the source it must jump the gap between the points of the double-pole plug as well as those of the ordinary plug, which is grounded because it is screwed into the cylinder. When a magneto of the high-tension type furnishes the current a double distributor is sometimes fitted, which will permit one to use two ordinary single-pole plugs instead of the unconventional double-pole member. Each of the plugs is joined to an individual distributor, and as but one primary contact breaker or timer is used to determine the time of sparking at both plugs, the ignition is properly synchronized and the sparks occur simultaneously.

Typical Battery Ignition Systems.—The components of typical battery ignition systems of several years ago now found only on old

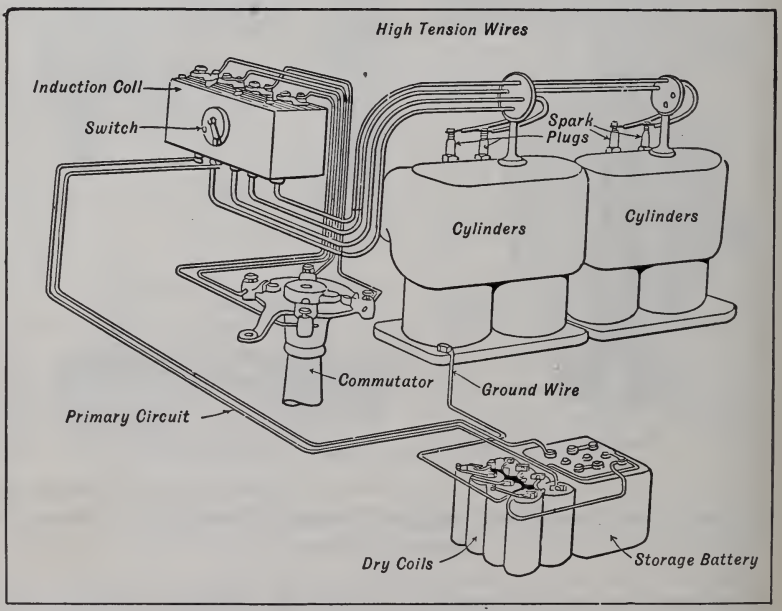


Fig. 373.—Assembly View of Four-Cylinder Ignition Group, Showing All Devices and Methods of Wiring.

models of cars may be easily determined by studying the illustrations given at Figs. 373, 374 and 375. The four-cylinder ignition group shown at Fig. 373 depicts the old method of wiring two sets of batteries, a four-point timer or commutator, and a four-

unit induction coil together. It will be seen that eight dry cells are wired together in series and are used as an auxiliary to a six-volt or three-cell storage battery. The negative terminals of the storage battery and dry cell set are coupled together by a short length of wire and are grounded by being attached to the engine base by a suitable conductor. The positive terminals are coupled to the two binding posts under the switch or the coil. The four points of the commutator are attached to the different units of the coil while the secondary wires run from the high-tension terminals on the bottom of the coil to the spark plugs in the cylinders. If the switch

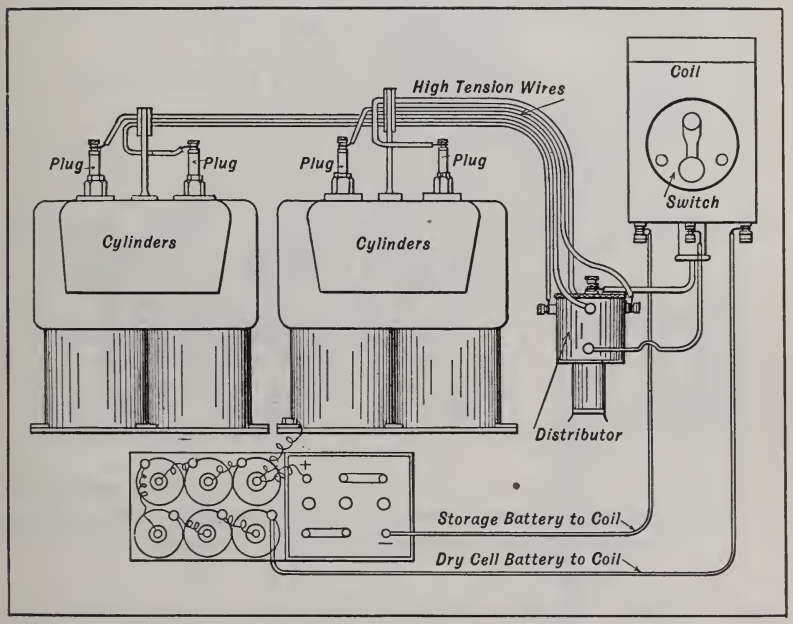


Fig. 374.—Methods of Employing Single Coil to Fire Four Cylinders when Secondary Current is Distributed Instead of Battery Energy.

lever is placed on one contact button, the current is obtained from the dry cells. If it is swung over to the other side, electricity from the storage battery is utilized.

A typical high-tension vibrator coil distributor system is shown at Fig. 374. Two sources of primary current are provided, one being a six-cell, dry battery, the other a three-cell, or six-volt storage battery. The battery connections are similar to those previously shown and but a single unit coil is needed to fire all cylinders. A single primary wire is attached to the commutator section of the distributor. The second-

ary wire from the induction coil is joined to the distributing terminal on the top of the distributor, from which it is delivered to the collecting terminals spaced on quarters around the outer periphery of the distributor casing by means of a central distributing segment. Suitable conductors connect the distributor with the spark plugs in the cylinders.

The illustration at Fig. 375 is practically the same as that at Fig. 374, except that a distributor capable of firing a six-cylinder

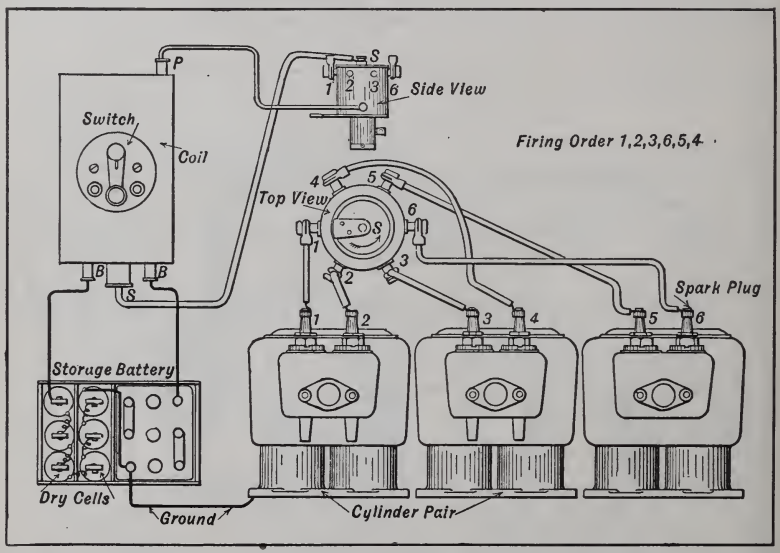


Fig. 375.—Distributor and Coil Ignition Group for Six-Cylinder Motor, Showing Order of Firing and Method of Wiring Connections.

engine is used. If individual unit coils were to be employed, as is the case at Fig. 373, the coil box would contain six units and the primary timer would have six contact points. The wiring would be considerably more complicated than the system outlined.

Non-Vibrator Distributor Systems.—Because of the almost universal employment of electricity for lighting and starting systems, the battery ignition system has been improved materially inasmuch as the storage battery supplying the current is now constantly charged by a generator. A number of systems has been devised, these operating on two different principles, the open and the closed circuit. A typical complete electrical system, including ignition, starting and lighting circuits, is shown at Fig. 376. The storage battery is kept properly charged by the motor-generator unit.

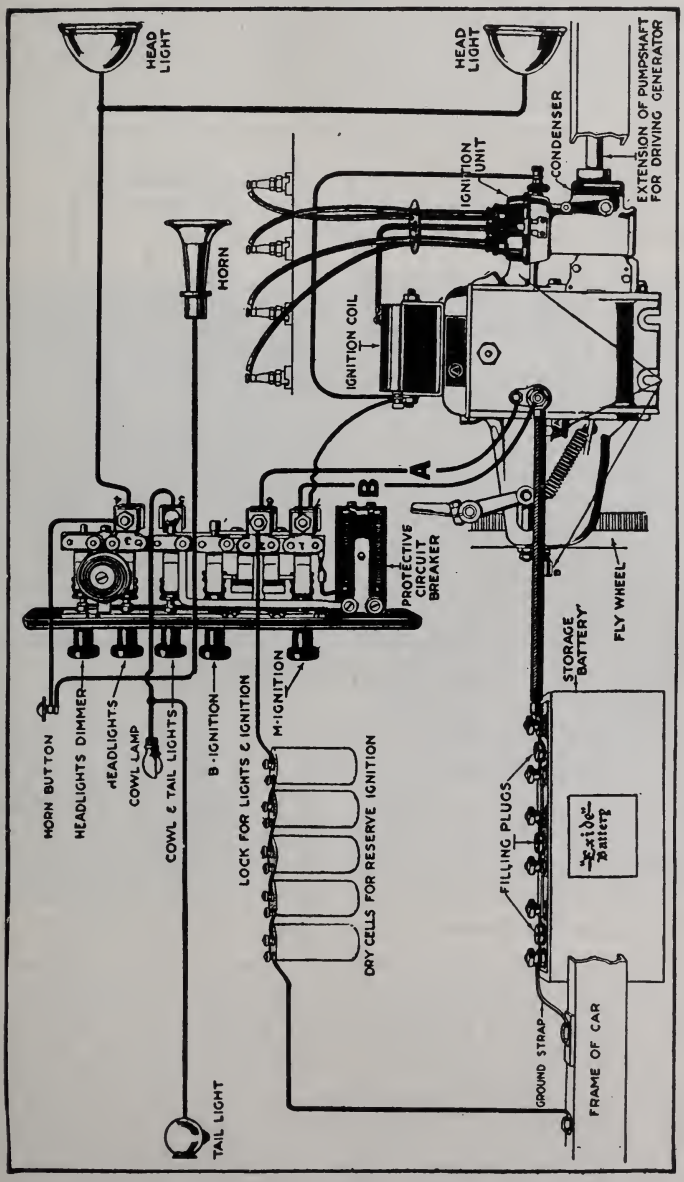


Fig. 376.—The Delco Ignition, Engine Starting and Car Lighting System.

One of the best known of the short contact forms of timer is the Atwater-Kent, which is usually combined with a secondary distributor, as shown at Fig. 378. The method of placing this timing and distributing member in circuit is clearly shown in wiring diagram Fig. 377. The advantage of a timer of the form shown, as contrasted to

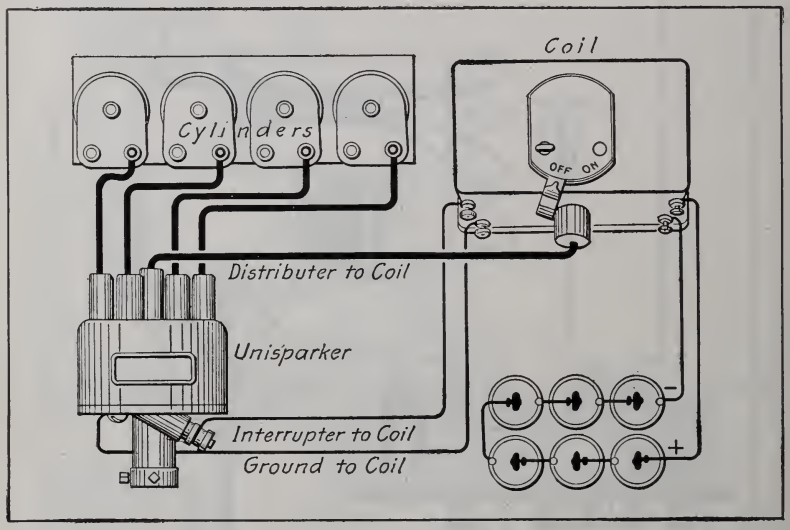


Fig. 377.—Atwater-Kent Uni-Sparker System.

the simple type previously considered, is that a one unit induction coil will serve any number of cylinders from 2 to 8, whereas with the roller type a separate induction coil is needed for each cylinder to be fired. It will be observed that the coil used with the Atwater-Kent system has five terminals, four of these being primary terminals, one at the center of the coil box a secondary or high tension terminal. A set of six dry cells connected in series (or a storage battery) is wired to one side of the coil box as indicated. One of the two remaining primary terminals runs to the primary contact at the bottom of the interrupter, the other to a grounding screw attached to the interrupter casing. The secondary terminal is connected to the central terminal of the distributor, while the remaining four terminals are joined to the plugs in the engine cylinders in such order as to insure proper sequence of explosions. The external view of the Atwater-Kent unisparker is shown at Fig. 378, A. In this a centrifugal mechanism is contained in the lower part of the casing by which the spark is automatically advanced as the speed of the engine increases.

The only points that will wear on a device of this character are

the contact points which are clearly shown in the view of the contact breaker mechanism at B. The revolving shaft in the center has a number of notches, two, three, four, six, or eight, according to the number of cylinders to be fired, cut into it. A light hardened steel trigger, B, is held against the shaft at this point by a small spring. On turning the shaft this trigger is carried forward by the notches in the shaft, and is suddenly released as the hook end leaves the notch. In so doing the back of the trigger strikes a small pivoted hammer, D, situated between the trigger and the spring carrying the contact points. This causes the contact points, K, to open and close

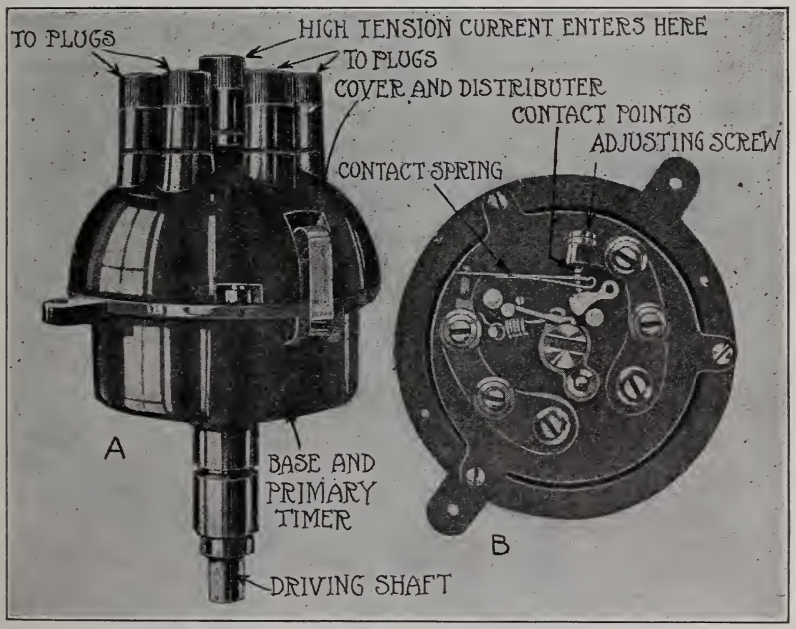


Fig. 378.—Showing Construction of Atwater-Kent Uni-Sparker.

with remarkable rapidity, but one contact being made for each spark. When it is desired to adjust the platinum contact points, as when they show signs of wear, it is only necessary to remove one or more of a number of extremely thin washers under the head of the adjustment screw and to replace the screw. The contact points should be absolutely clean and bright and have smooth contacting surfaces. The distributor portion of the device consists of a hard rubber block fitted to the top of the primary shaft, this carrying a brass quadrant that passes the high-tension current to the spark plugs by means of the terminal points imbedded in the hemispherical cover. There is

no actual contact between the rotating quadrant and the distributor points, as the high-tension current is capable of jumping the very slight gap that exists between them. Owing to there being no actual contact, there will be no depreciation in the distributor or upper portion. The center terminal, which is in connection with the induction coil, is a combination of carbon and brass, and a light, flat spring on the quadrant bears against it to maintain positive electrical connection. The distributor cover is easily removed without the use of tools, as it is held by spring clips. Location of dowel pins in its lower edge insures that it will be replaced in the correct position.

Delco Ignition System.—The arrangement of the parts of the complete Delco starting, lighting and ignition system are shown at Fig.

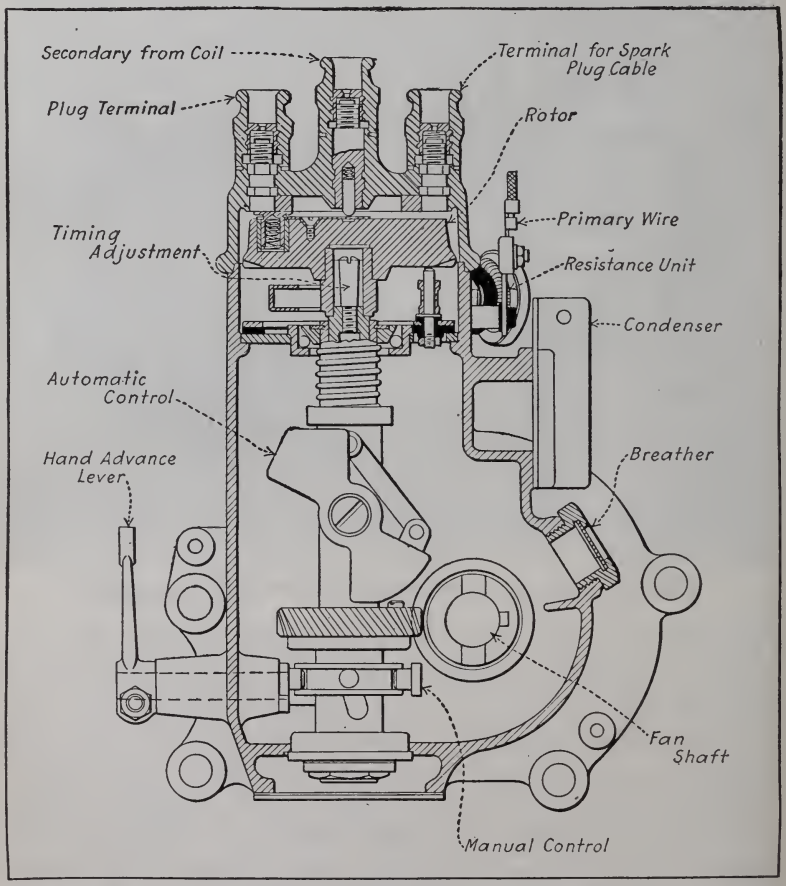


Fig. 379.—Part Sectional View of Delco Timer, Showing Automatic Spark Advance Mechanism in Base.

376. The ignition parts are special timer-distributor, an induction coil and two current sources, a storage battery for regular use and a dry-cell battery for emergencies. The general arrangement of a Delco timer unit used on Cadillac cars is shown at Fig. 379. This is used in connection with an eight-cylinder ignition system. Both automatic spark advance and manual control of the spark time are provided. The Delco ignition timers used on the Packard "Twin Six" twelve-cylinder engine are shown at Fig. 380. Two separate

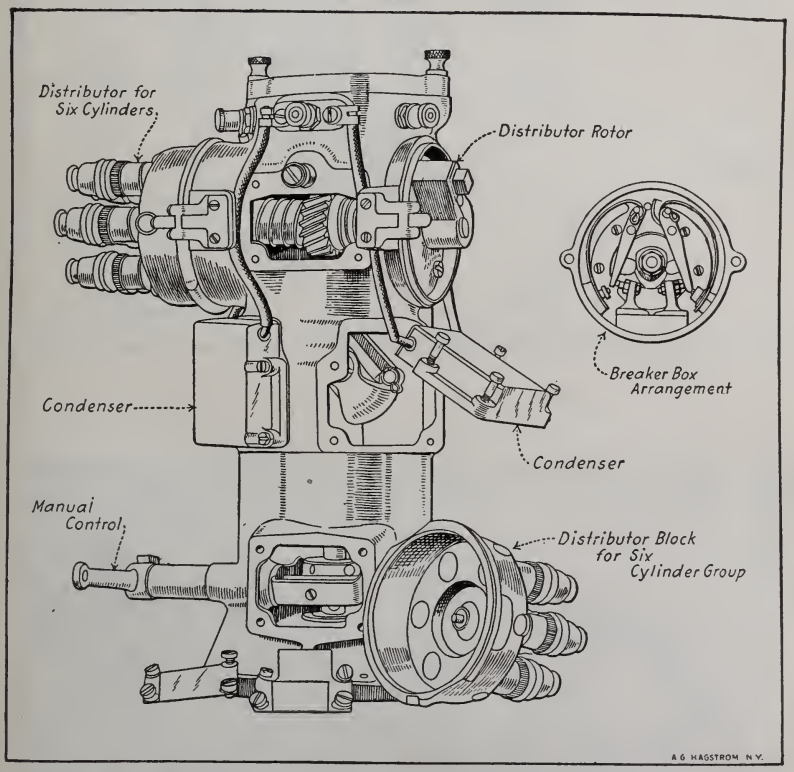


Fig. 380.—How the Delco-Packard Twin-Six Timer is Constructed.

timers are used, each having its own condenser and distributor. One takes care of the right-hand block of six cylinders, the other ignites the left-hand block. The spark advance mechanism is very much the same as shown in the sectional view at Fig. 379. Two induction coils are used, one for each half of the timer.

The action of the Delco system is very much the same as that of any battery-non-vibrator coil outfit. The simplified diagram at Fig.

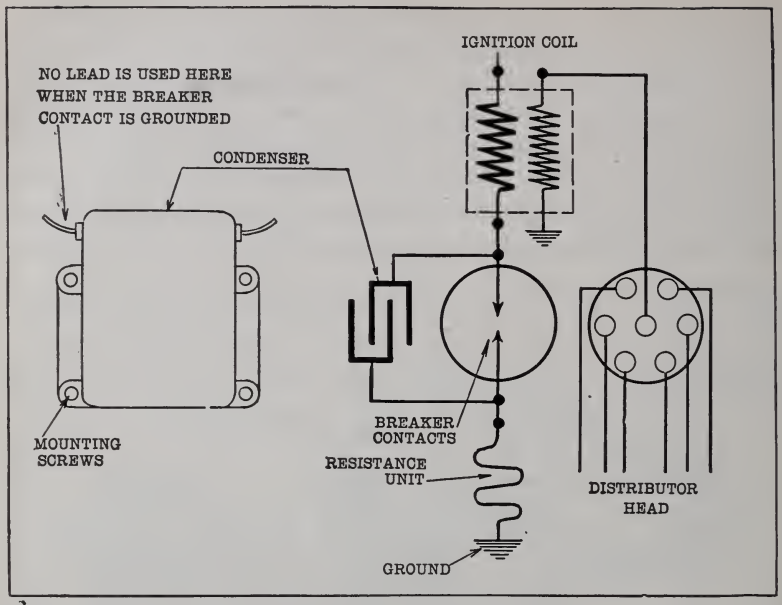


Fig. 381.—Simplified Wiring Diagram, Showing Action of Delco Ignition System.

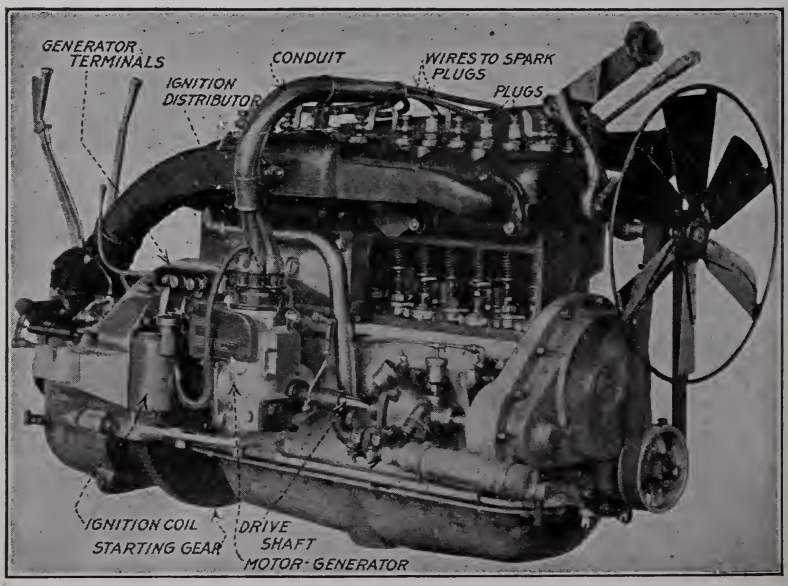


Fig. 382.—Application of Delco Motor-Generator to Hudson Engine.

381 shows the relation of the coil, condenser, primary timer and secondary distributor head. The battery is not shown connected, but

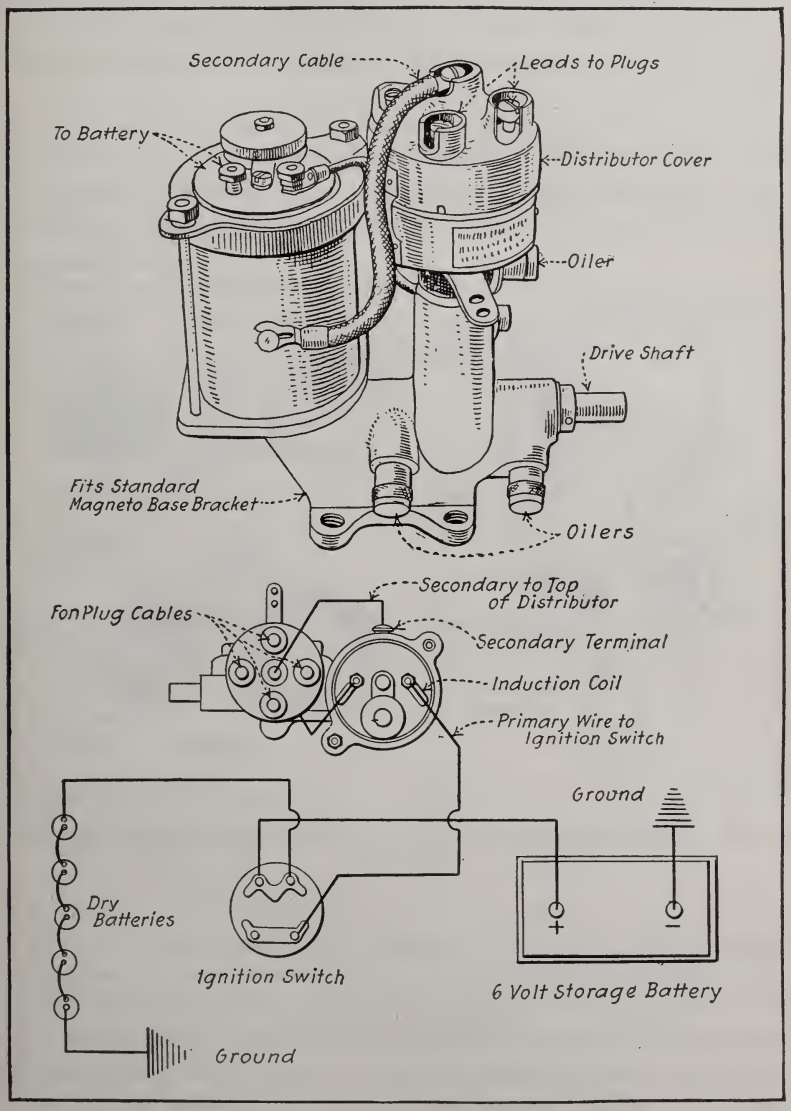


Fig. 383.—Remy Ignition Outfit for Attachment to Magneto Base on Engine Crankcase.

one terminal is grounded, the wire from the other passes through a switch and to the primary lead of the ignition coil. One end of the

secondary coil is grounded, the other secondary lead conducts the high-tension current to the central distributor terminal. The other distributor terminals are connected to the spark plugs. The primary circuit includes the coarse wire winding of the ignition coil, the battery and the timer contacts. The condenser is in shunt and no primary current can pass through it.

The ignition system is composed of a combined timer and distributor, a set of dry cells for reserve ignition and a coil for delivering a high-tension spark to the distributor. The distributor consists of a cap or head of insulating material carrying a high-tension distributing

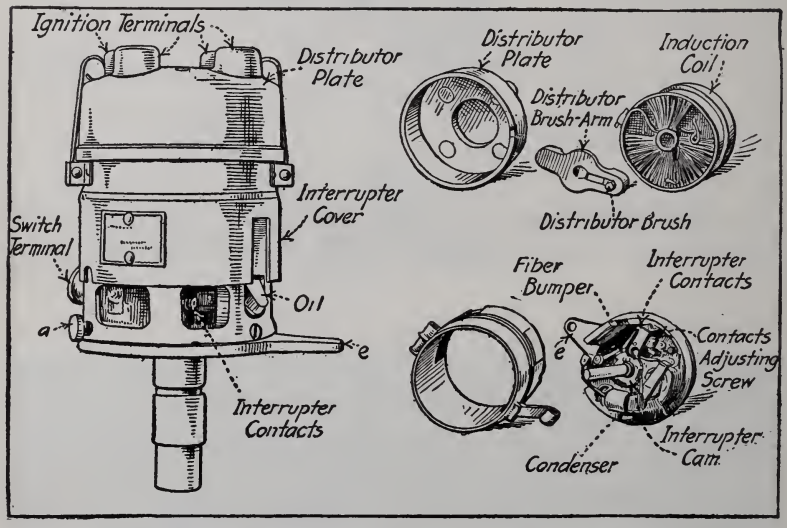


Fig. 384.—Parts of Westinghouse Timer-Distributor, which Includes the Induction Coil.

contact in the center, while six similar collecting contacts are spaced equi-distant about the center one, when device is used on a six-cylinder motor. A rotor member directs the current from the center contact to that leading to the plug in the cylinder about to fire. The timer portion of the ignition unit is a short contact platinum point form and it sends a current of electricity through the primary winding of the induction coil each time that a spark is needed in the engine. In place of the fuses which are used on some systems a protective circuit breaker is attached to the switch panel which gives warning of a short circuit by rapidly vibrating an armature. The various parts of the system and all of the circuits are clearly shown in the

diagram, and in view of what has been previously said no difficulty should be experienced in tracing the various wires. An actual installation of the Delco ignition system is shown at Fig. 382, which depicts the method of grouping the parts on a typical six-cylinder engine.

Battery ignition systems are becoming so popular that some of these are arranged on a special base that will fit the standard size platforms used for holding magnetos. The wiring diagram of a Remy conversion set of this type and the appearance of the ignition unit which includes coil, timer and driving gears, is shown at Fig. 383. All parts are clearly designated, and the reader should have no difficulty in identifying them.

Westinghouse Vertical Ignition Unit.—The Westinghouse vertical ignition unit, shown at Fig. 384, can be used for ignition from storage batteries or plain lighting generators. This set contains interrupter, spark coil and condenser, and distributor, all in one unit. One wire from the battery or generator to the ignition unit and one wire to each spark plug are all that are required—the simplest possible connections. The interrupter, located at the lower end of the set, has the same type of circuit-breaker as that on the Westinghuose ignition and lighting generators, but no automatic spark advance feature. It can be used equally efficiently for either direction of rotation without change. The interrupter is enclosed by a spring collar which can be readily removed for inspection or adjustment of the contacts. The collar makes a tight joint and is clamped by a screw which prevents it from slipping. The spark coil is embedded in heat-proof insulating material, and the condenser is well insulated. Both are contained in a tube of Bakelized Micarta, which forms the body of the unit. The distributor is of very simple construction with a wiping brush contact of the same type as that used on the ignition generators. It clamps to the upper end of the set. The wiring diagram of this system is shown at Fig. 385. The device is sometimes mounted in connection with a generator when that member is driven by direct gear connection from cam shaft which provides a properly timed drive for the ignition unit.

An example of the closed circuit system is shown at C, Fig. 386, and is of Connecticut design, the complete ignition system consisting of a combined timer and high-tension distributor, a separate induction coil and a switch. The system is distinctive in that the timer is so constructed that the primary circuit of the coil is permitted to become throughly saturated with electricity before the points separate, with a result that a spark of maximum intensity is produced. The action is very much the same as that of a magneto on account of the

saturation of the winding. Another feature is the incorporation with the switch of a thermostatically operated electro-magnetic device which automatically breaks the connection between the battery and coil should the switch be left on with the motor idle.

The contact breaker mechanism consists of an arm A carrying one contact, a stationary block B carrying the other contact, a fiber roller R which is carried by the arm A and operated by points on the cam C, which is mounted on the driving shaft. Normally the contacts are held together under the action of a light spring. As the four cams, which in touching the roller R raise the arm and separate the contacts, are 90 degrees for a four-cylinder motor, the period of saturation of the coil or the length of time the current flows through it to the battery is sufficiently long so that when the points have separated the current which has "piled" up induces an intensely hot spark at the plugs. This is an advantage inasmuch as it insures prompt starting and regular ignition at low engine speed as well as providing positive ignition at high engine speed. The method of taking the timer apart that is used on the latest Connecticut system employed on Overland cars is shown at Fig. 387. The various steps are shown and the assembling process is obviously a renewal of that outlined. This easily taken down construction makes it easy to take the timer apart for cleaning or inspection.

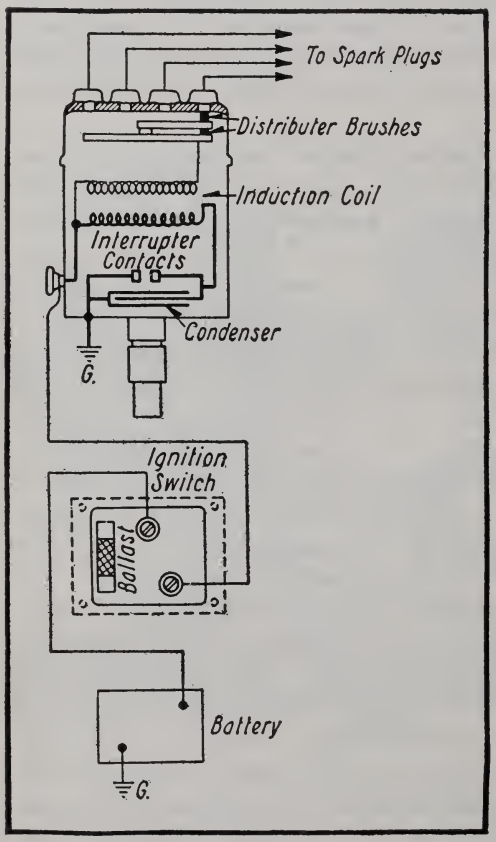


Fig. 385.—Showing Internal Wiring of Westinghouse Timer-Distributor and Coil Ignition Unit.

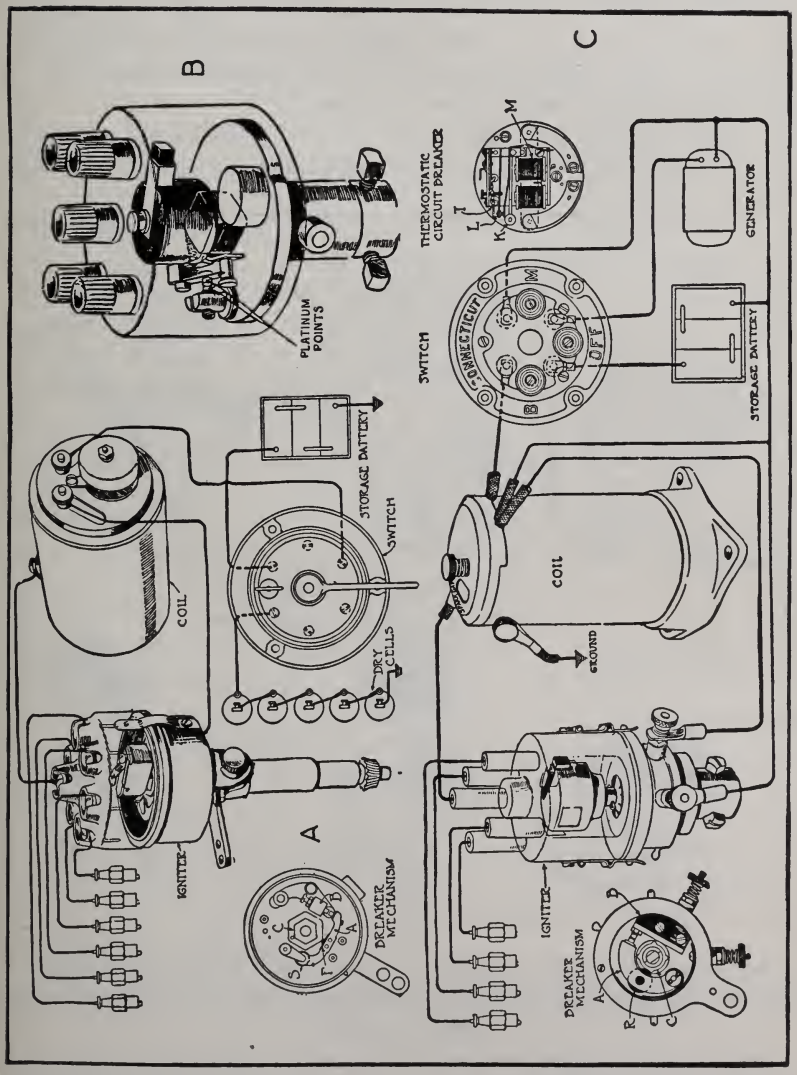


Fig. 296.—Typical Closed Circuit Battery Ignition Systems. A—Remy. C—Connecticut.

The thermostatic circuit breaking mechanism is very simple. This consists of the thermostat T, which heats when the current passes through it for from thirty seconds to four minutes without interruption, and thus is bent downward, making contact with the contact L. This completes an electrical circuit which energizes the magnets M, causing the arm K to operate like the clapper in an electric bell. This arm strikes against the plate, which releases whichever of the two buttons in the switch may be depressed.

As will be observed, the transformer coil provided has five terminals. One of these is connected directly with the ground, the other

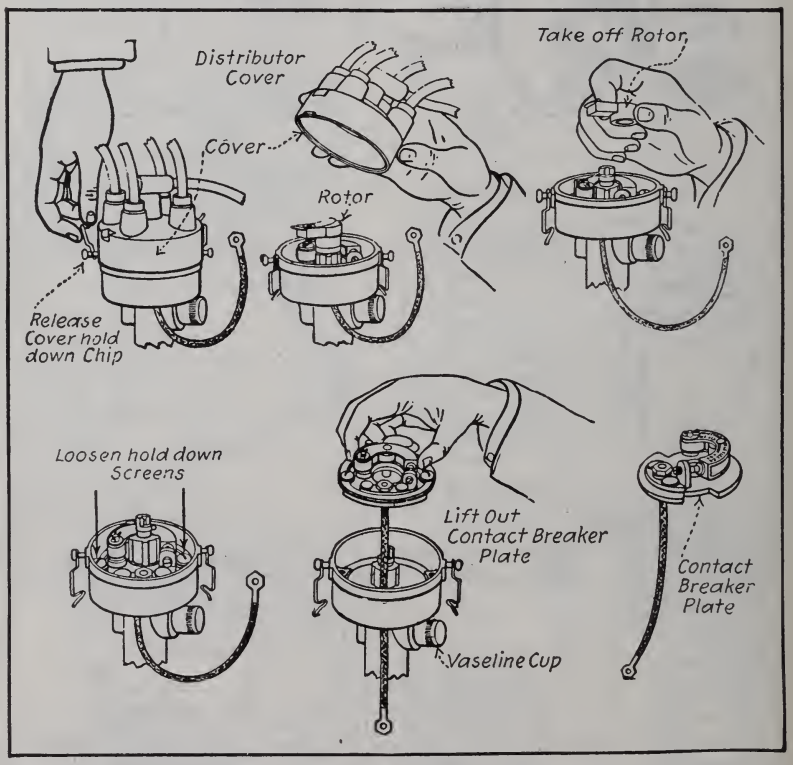


Fig. 387.—Steps in Dismantling Timer-Distributor Used in Overland Connecticut Ignition System.

leads to the central secondary distributing brush of the timer-distributor. Of the three primary leads, one goes to the switch, one to the wire leading from the storage battery to the timer, and one directly to a terminal on the timer. The switch is provided with three buttons, the one marked B being depressed to start the engine,

as the ignition current is then drawn from the storage battery. After the engine has been started the button marked M is pressed in, this taking the current directly from the generator. To interrupt ignition the button "off" is pressed in, this releasing whichever of the buttons, B or M, is depressed. Four wires run from the distributor section of the igniter to the spark plug.

The Remy system also operates on the closed circuit principle and is shown at A, Fig. 386, in a form adapted for six-cylinder engine ignition. The transformer coil is of the three terminal type, one secondary going to the central secondary distributing brush of the timer while one primary is joined to the primary contact terminal of the timer portion of the igniter. The remaining coil terminal is joined to the switch. One of the poles of the storage battery and one of the series connected dry cell batteries are grounded, while from the other two the wires run to the switch contacts. The current may thus be derived either from the dry cell batteries for emergency or from the storage battery for regular ignition purposes. The construction of the timer which incorporates the breaker mechanism is clearly shown. The movable platinum contact point is carried by the arm A, which fulcrums on the bearing S, and which has a piece of hard steel F riveted to it to act as a cam rider. The cam C is of hexagonal form, having six points which separate the contacts when they ride over the shoe F attached to the arm A. The fixed platinum contact point B is so arranged that it may be adjusted by moving in or out as conditions demand. It is to this member that the primary terminal of the coil is connected.

A typical combined timer distributor known as the Halladay is shown at B, Fig. 386. The make-and-break mechanism is very simple in design, as is the distributing mechanism. The contact between the platinum points is established by a four point cam. The secondary current is distributed from the central terminal to the four distributing terminals by a carbon brush very much similar in design to that employed in a high-tension magneto. This operates on the open circuit principle.

Features of Low-Tension Ignition System.—Though the low-tension ignition system is never used at the present time in automobile practice, a brief description of the method of producing a make-and-break spark is desirable so the reader may gain a thorough knowledge of the possible methods of ignition. In order to obtain a spark in the cylinder of any engine, it is necessary that there be a break in the circuit and that this break or interruption be inside of the combustion chamber. The igniter plate used is different in construction from the spark

plug forming part of the high-tension system, as the break is made by moving contacts which serve to time the spark as well as produce it.

A typical igniter is shown at A and B, Fig. 388. It consists of a drop-forged plate approximately triangular in form which has a coni-

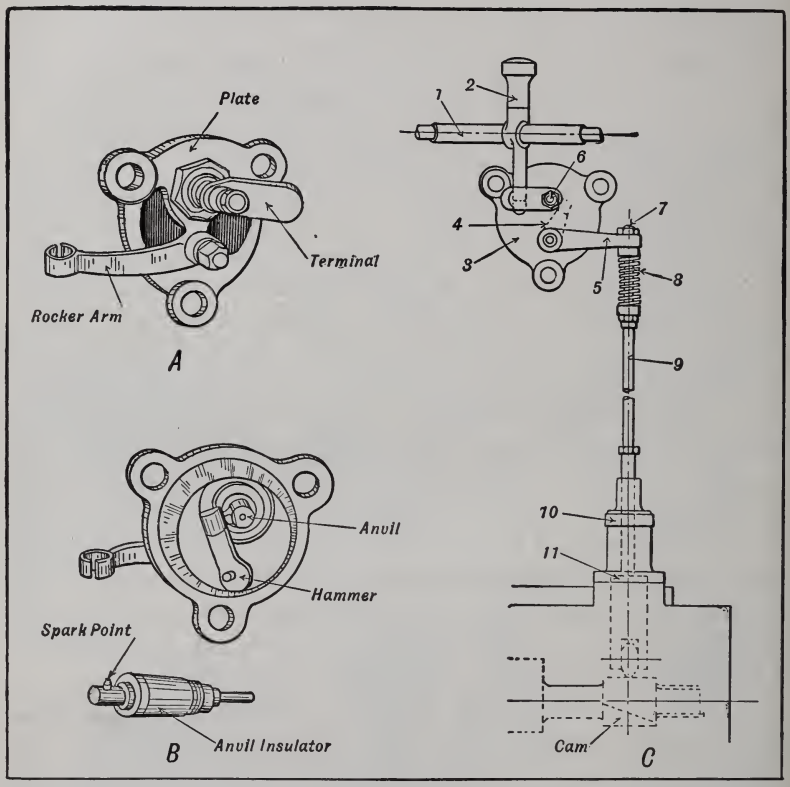


Fig. 388.—Low-Tension Ignition Plate by which Ignition Spark was Produced in Locomobile Cars of Early Vintage. A—External View Showing Rocker Arm. B—Inside View Depicting Contact Points. C—Method of Operation.

cal ground surface to fit a corresponding female member in the combustion chamber. It is secured by three bolts to a corner of the cylinder close to the inlet valve so the contact points will be traversed by the gases entering from the carburetor. As shown at B, the fixed contact point is called the anvil, while the movable or rocking member is called the hammer. The anvil is insulated from the igniter plate by a bushing of mica or lava, and the hammer alternately makes and breaks contact with the anvil. The method of actuating the hammer by a rocker arm is clearly shown at C. The rocker arm 5 is in

the form of a short lever ending in a slotted opening which is connected to the top of the vertical lifter rod 9. This is actuated by a cam on the inlet valve cam shaft which raises the valve plunger 11 in the guide bushing 10. When the lifter rod moves upward the contact point on the hammer inside of the cylinder comes into contact with the platinum point on the anvil and closes the circuit. When the igniter cam reaches the proper point for igniting the charge the lifter rod 9 falls and as the action is quickened by a spring at the bottom of the lifter rod the hammer arm 4 is separated from the contact point on the anvil 6 and a spark takes place as the points are pulled apart.

The coil used when batteries are employed to furnish the current is a simple form. It is a winding of comparatively coarse wire around a core composed of a bundle of soft iron wire. The battery current is intensified to a certain extent by the self-induction of one layer of wire upon the others, and when contact is broken a brilliant

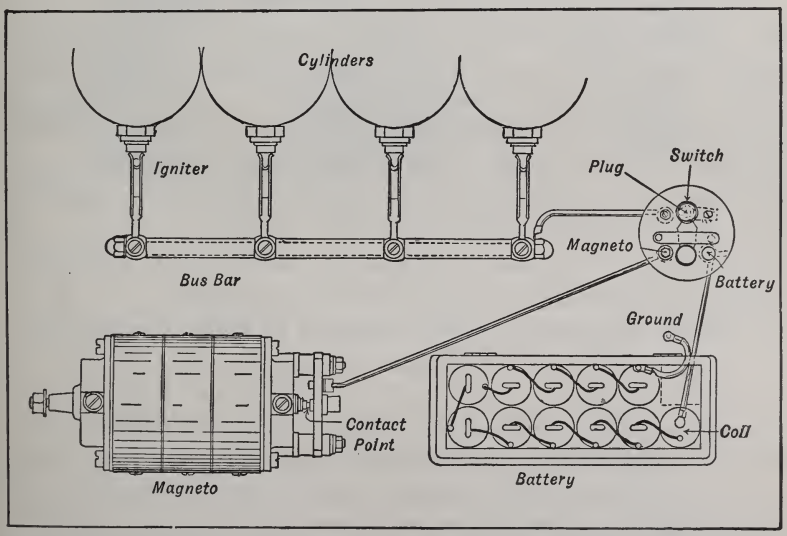


Fig. 389.—Low-Tension Ignition System for Four-Cylinder Motor Utilizes Battery and Magneto for Current Production.

spark occurs between the points of the igniter plate. Batteries are seldom used for regular service on the low-tension system because the demands are too severe.

One of the advantages of this system is that the wiring is extremely simple, as will be seen by consulting the diagram of the low-tension ignition system illustrated at Fig. 389. In this both a low-

tension magneto and set of batteries are provided, the former being used for regular ignition while the latter are carried for emergency service. A simple form of magneto will serve any number of cylinders because the insulated terminals of the igniters are joined together by a simple conductor or bus bar. A wire from the magneto terminal is joined to one side of the switch, while the other side of the switch is coupled to the coil which is carried in the battery box. A short wire connects the top of the switch lever with the bus bar. If the switch lever is swung to the left, the magneto produces the current for the igniters, and if the switch lever is placed on the button at the right, the current supply is taken from the batteries. The dry cells are joined together in series connection, one pole being joined to a coil terminal, the other being grounded. The coil and the igniter plates are in series with the batteries and the current is returned to the ground through the rocker arm, which is a metallic contact with the igniter plate.

The disadvantage which has militated against the general use of the make-and-break system of ignition is that it is very difficult to obtain synchronized spark after the mechanism had become worn, and unless the igniter plates were kept in perfect adjustment the spark time would vary and the efficiency of the engine would be lowered. As the moving electrodes operate under extremely disadvantageous conditions it is difficult to prevent rapid wear of the rocker arm bearing at the igniter plate and leakage of gas results. Owing to the multiplicity of joints in the operating mechanism it is difficult to secure regular action without backlash or lost motion.

With a high-tension system there are no moving parts inside of the cylinder and it is not difficult to maintain a tight joint between the plug body and the cylinder head. The timer mechanism which is employed when batteries and coils are utilized to furnish the current is a comparatively simple device which is not liable to wear because it can be easily oiled and has a regular rotating movement which can operate without getting out of time much better than the reciprocating parts of the make-and-break mechanism. When a direct high-tension magneto is used the system is not much more complicated as far as wiring is concerned than a low-tension group, and as the ignition is more reliable it is not strange that jump spark or high-tension ignition is almost generally used in automobile practice.

Magneto Generator Construction.—The magneto is a simple form of dynamo and a mechanical generator of electricity in which permanent magnets are used to produce the magnetic field and between which the armature revolves. The permanent magnets are called

" field magnets " and at their ends are provided cast-iron shoes which form the walls of the armature tunnel and which are known as pole pieces. A typical magneto adapted for single-cylinder ignition is shown in section at Fig. 390. It consists of two compound horseshoe magnets attached to the pole pieces which collect and concentrate the magnetism upon the armature. The armature is shuttle-shaped and carries a double winding of wire which consists of two coils, one of coarse, the other of fine conductor. The armature is attached to end pieces which carry shafts and the whole assembly revolves on annular ball bearings. An ebonite or hard rubber spool is carried

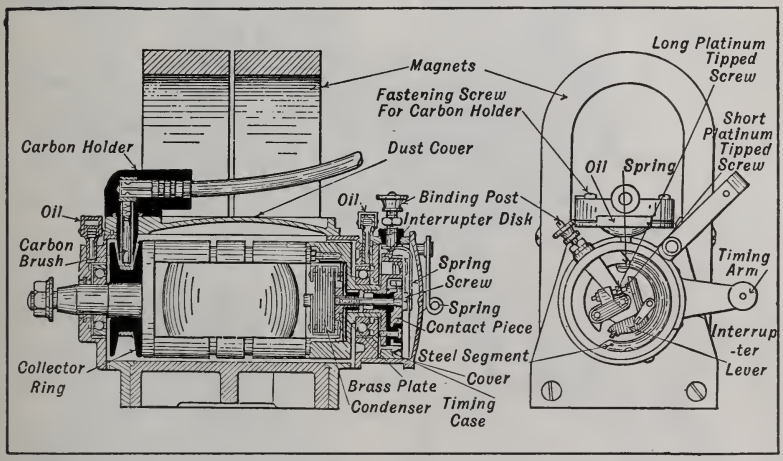


Fig. 390.—Simple High-Tension Magneto for One-Cylinder Ignition. A Complete Ignition Apparatus Comprising Source of Current and Timing Device as Well.

at one end while the condenser is housed at the other. The make-and-break mechanism is partly carried by an oscillating casing and the revolving member is turned from the armature shaft.

The current generated in the coil is delivered to a metal ring on the ebonite spool from which it is taken by a carbon brush and delivered directly to the spark plug. Every time the contact points in the make-and-break devices become separated, a current of high potential passes through the wire attached to the spark plug and produces a spark between the points. The magneto is the simplest and most practical form of ignition appliance as it is self-contained and includes the current generator and the timing device in one unit. In the one-cylinder form shown all connections are made inside of the device and but one wire leading to the spark plug is necessary to

form the external circuit. Some inventors have devised low-tension current generators of the dynamo type that have the advantage of the magneto in having timing and current distributing devices made integrally. A device of this kind is shown at Fig. 391, and while it is more bulky than a magneto it must be remembered that it supplies surplus current to charge a storage battery.

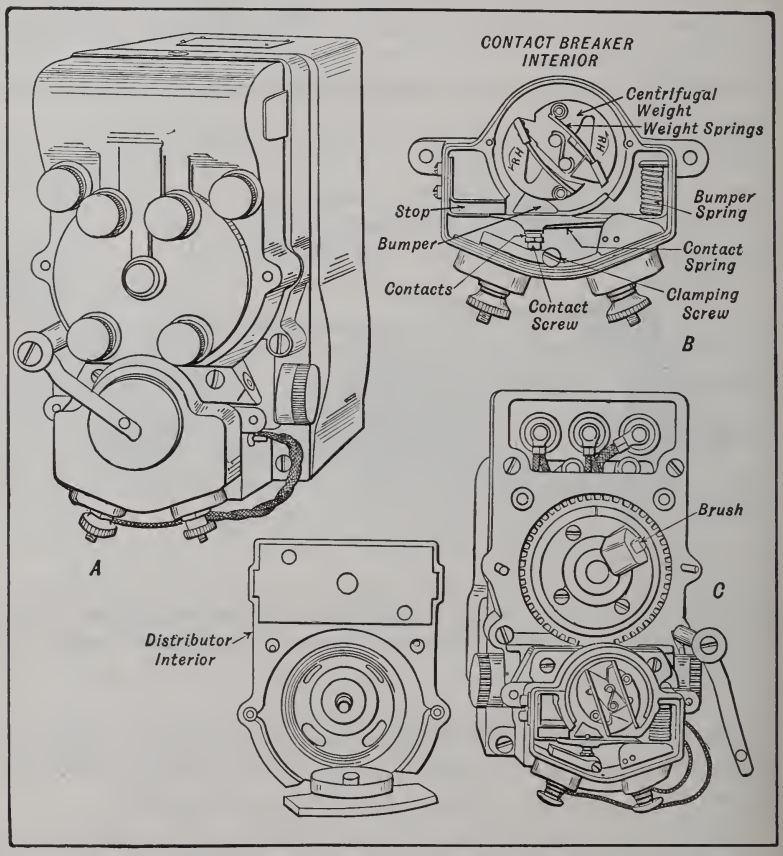


Fig. 391.—Showing Arrangement of Ignition Parts of Westinghouse Ignition-Generator Unit.

A magneto employed for multiple-cylinder ignition is not much more complicated than that used for single-cylinder service, the only difference being that a different form of cam is provided in the breaker box and that a secondary distributor is added to commutate the current to the plugs in the various cylinders. The distributor consists of a block of insulating material fixed to the magnets which

carries as many segments as there are cylinders to be fired. A central distributing arm or segment is driven from the armature shaft by means of gearing, and is employed to distribute the high-tension

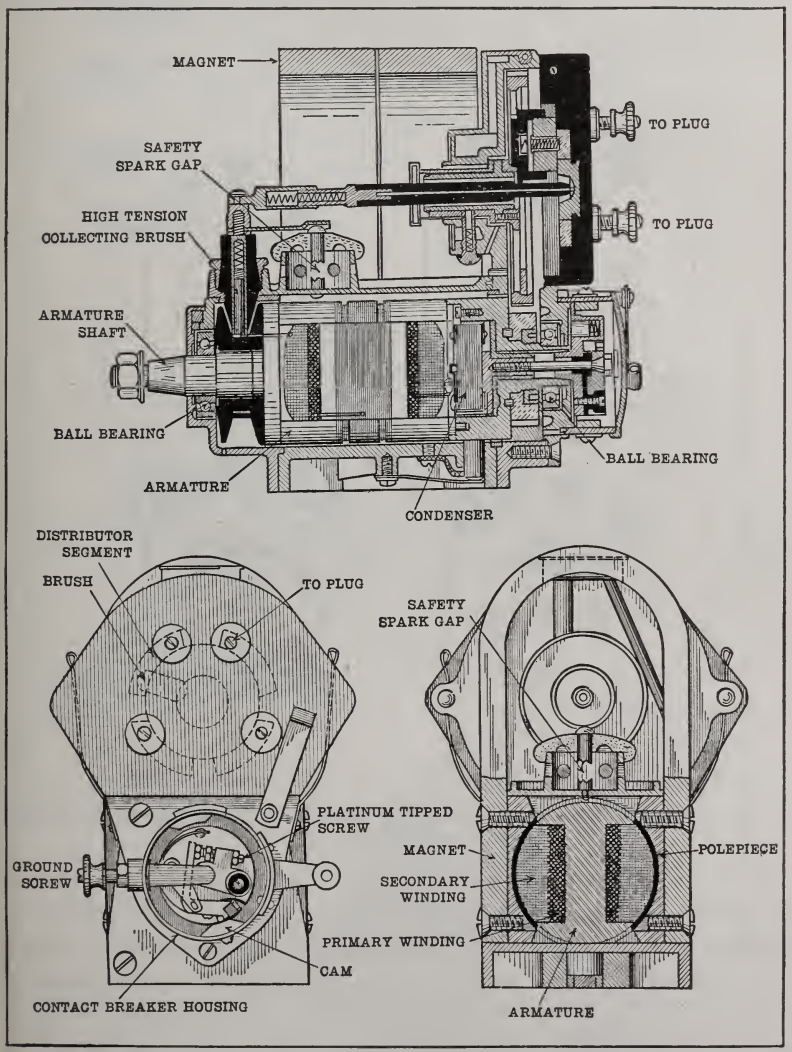


Fig. 392.—Views Showing Internal Construction of Bosch D U 4 High-Tension Magneto.

current to the spark plugs. The spacing of the distributor segments does not differ materially from that of the battery timers previously described. One of the most popular four-cylinder type magnetos, the

Bosch D U 4, is shown at Fig. 392, the general construction being clearly depicted and important parts indicated.

Various distributor forms used on magnetos are shown at Fig. 393. That at A is employed for a double opposed cylinder motor and

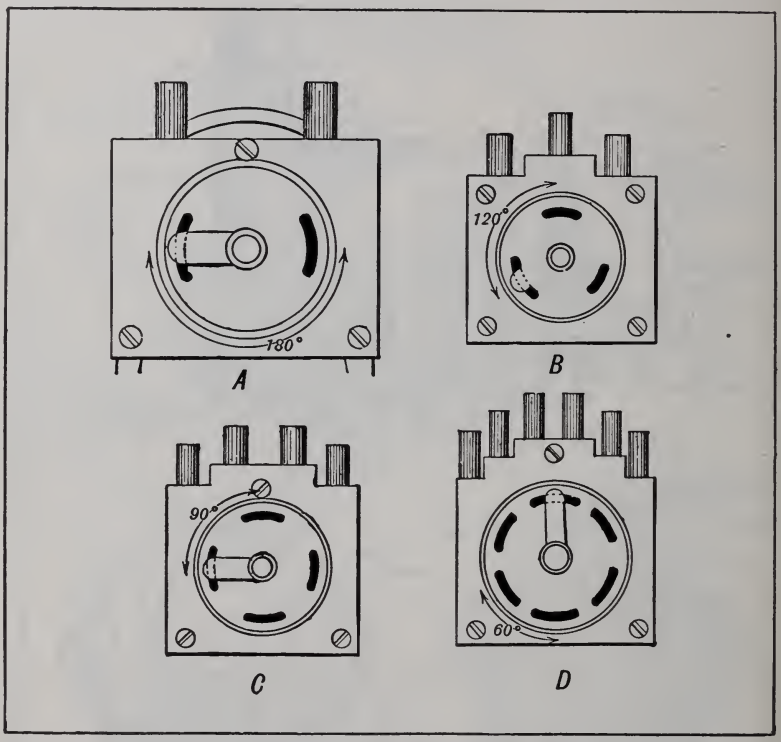


Fig. 393.—How Distributor Segments are Spaced on Two-, Three-, Four- and Six-Cylinder Magnetos.

the contacts are separated by a space of 180 degrees. When a three-cylinder engine is used, as is sometimes the case in the two-cycle forms, the distributor segments are separated by distances of 120 degrees. If the distributor is used on a four-cylinder motor the segments are spaced 90 degrees apart, as shown at C. To fire a six-cylinder motor, six segments must be used and they are placed 60 degrees apart, as indicated at D. Special magnetos using compound distributors have been devised for use with eight- and twelve-cylinder engines, though approved practice when magneto ignition is used for more than eight cylinders is to use two instruments. A twelve-cylinder engine would be provided with two six-cylinder magnetos.

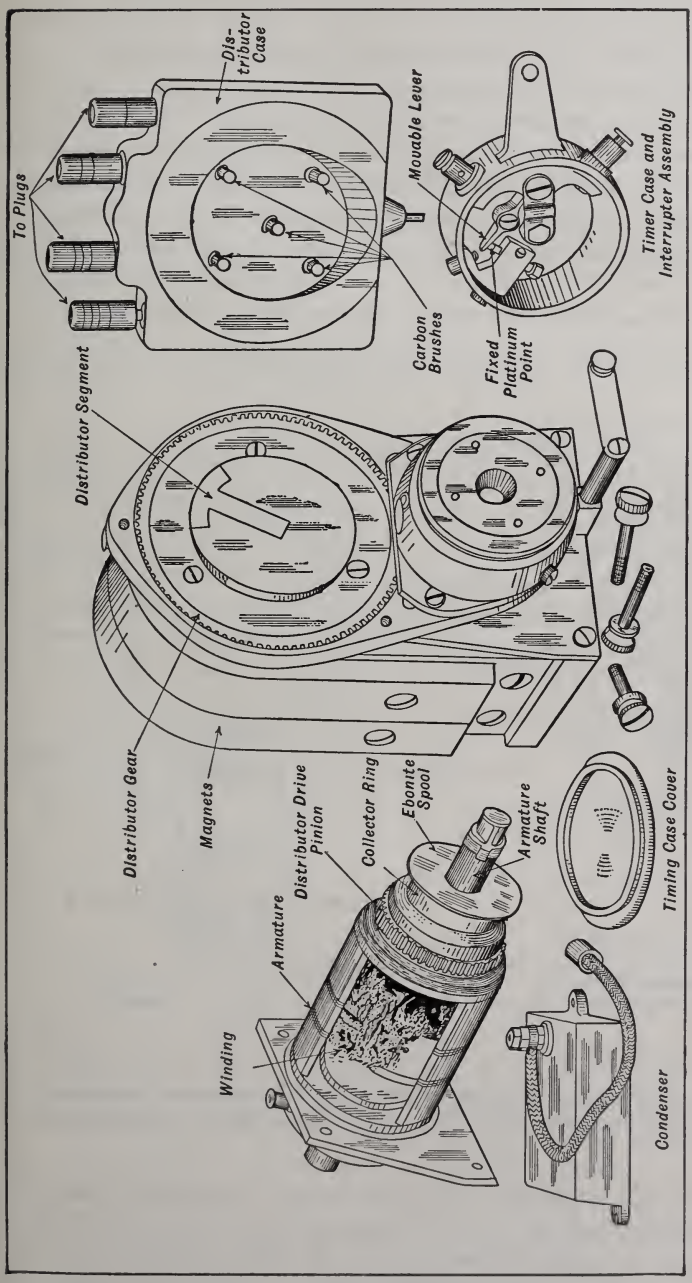


Fig. 394.—Partially Dismantled Four-Cylinder Magneto, Showing Important Parts of Current Producing and Distributing Elements.

The speed at which the armature of the magneto turns also varies with the number of cylinders. One- and two-cylinder forms turn at cam-shaft speed. The three-cylinder types when applied to a four-cycle engine turn at three-quarters the crank-shaft speed. The four-cylinder magneto armature is driven at crank-shaft speed, while that of the six-cylinder forms turn at one and one-half times crank-shaft speed. When used on two-cycle motors, the speeds given for four-cycle engines of the same number of cylinders should be doubled.

The important parts of a four-cylinder form of high-tension magneto are shown at Fig. 394, which is a view of a partially dismantled device. The armature assembly and one of the end plates by which

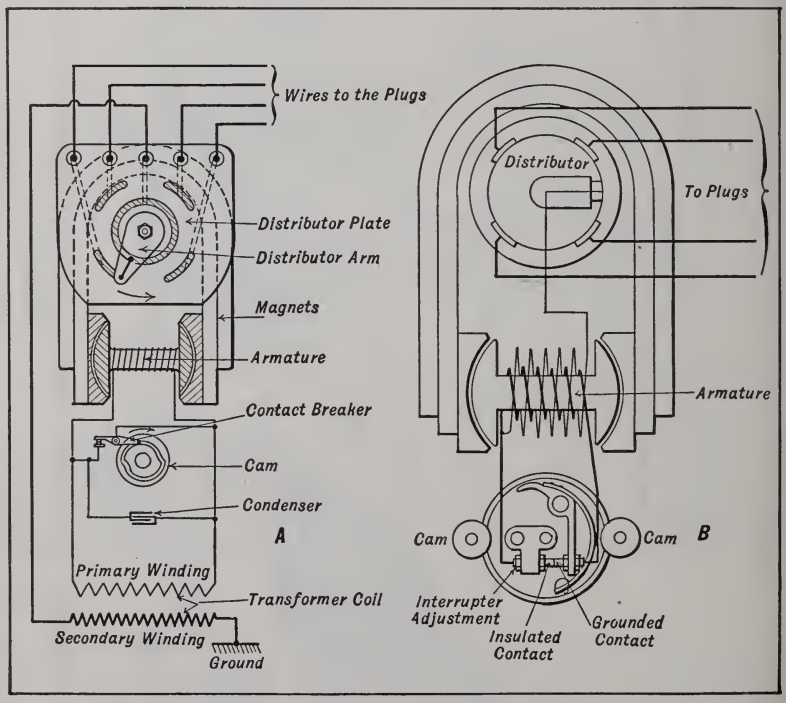


Fig. 395.—Diagrams Explaining Action of Low-Tension or Transformer Coil Magneto System at A and True High-Tension Magneto System at B.

it is supported are shown at the extreme left. Attached to the end of the armature shaft are the distributor drive pinion and the ebonite spool which carries the collector ring. The timer case and interrupter assembly are shown at the extreme right. Above it the distributor case is clearly depicted. When the device is assembled the end of the

armature shaft protrudes through the housing at the lower part of the magnet assembly which is shown in the center of the group, with the end plate which carries the distributor gear and disk and one end of the armature in place. The distributor gear serves to drive a hard rubber plate in which the distributor segment is imbedded. When the distributor case is screwed in place, the carbon brushes, which are spaced around the interior of the distributor case, collect current from the revolving distributor segment and lead it to the spark plugs by suitable cables which run from the terminals at the top of the distributor casing.

Two systems of high-tension magneto ignition are used, one termed the true high-tension system, in which a current of high potential is delivered directly from the armature; the other is the transformer coil system, so termed because the current produced by the armature winding is of low tension and must be stepped up or increased in value before it is delivered to the spark plug by an induction coil similar in construction to that needed in battery-ignition systems. In the former apparatus the high-tension current is produced by means of a secondary winding on the armature itself, and as the whole apparatus is self-contained it is much more compact and simpler to install than those which need a separate transformer coil. The difference between the two systems is clearly shown at Fig. 395. The essentials of a transformer coil system are shown at A, those of a true high-tension ignition device are outlined at B. It will be evident that the latter is the simplest electrically.

The Transformer System Uses Low-Voltage Magneto.—The magneto in the various systems which employ a transformer coil is very similar to a low-tension generator in general construction, and the current delivered at the terminals seldom exceeds 100 volts. As it requires many times that potential or pressure to leap the gap which exists between the points of the conventional spark plug, a separate coil is placed in circuit to intensify the current to one of greater capacity. The essential parts of such a system and their relation to each other are shown in diagrammatic form at Fig. 386. As is true of other systems the magnetic influence is produced by permanent steel magnets clamped to the cast-iron pole pieces between which the armature rotates. At the point of greatest potential in the armature winding the current is broken by the contact breaker, which is actuated by a cam, and a current of higher value is induced in the secondary winding of the transformer coil when the low-voltage current is passed through the primary winding.

It will be noted that the points of the contact breaker are together

except for the brief instant when separated by the action of the point of the cam upon the lever. It is obvious that the armature winding is short-circuited upon itself except when the contact points are separated. While the armature winding is thus short-circuited there will be practically no generation of current. When the points are separated there is a sudden flow of current through the primary winding of the transformer coil, inducing a secondary current in the other winding, which can be varied in strength by certain considerations in the preliminary design of the apparatus. This current of higher potential or voltage is conducted directly to the plug if the device is fitted to a single-cylinder engine, or to the distributor arm if fitted to a multiple-cylinder motor. The distributor consists of an insulator in which is placed a number of segments, one for each cylinder to be fired, and so spaced that the number of degrees between them corresponds to the ignition points of the motor. A two-cylinder motor would have two segments, a three-cylinder, three segments, and so on with the capacity of the instrument. In the illustration a four-cylinder distributor is fitted, and the distributing arm is in contact with the segment corresponding to the cylinder about to be fired.

True High-Tension Magnetos are Self-Contained.—The true high-tension magneto differs from the preceding inasmuch as the current of high voltage is produced in the armature winding direct, without the use of the separate coil. Instead of but one coil, the armature carries two, one of comparatively coarse wire, the other of many turns of finer wire. The arrangement of these windings can be readily ascertained by reference to the diagram B, Fig. 386, which shows the principle of operation very clearly. One end of the primary winding (coarse wire) is coupled or grounded to the armature core, and the other passes to the insulated part of the interrupter. While in some forms the interrupter or contact breaker mechanism does not revolve, the desired motion being imparted to the contact lever to separate the points by a revolving cam, in this the cam or tripping mechanism is stationary and the contact breaker revolves. This arrangement makes it possible to conduct the current from the revolving primary coil to the interrupter by a direct connection, eliminating the use of brushes, which would otherwise be necessary. In other forms of this appliance where the winding is stationary, the interrupter may be operated by a revolving cam, though, if desired, the use of a brush at this point will permit this construction with a revolving winding.

During the revolution of the armature the grounded lever makes and breaks contact with the insulated point, short-circuiting the primary winding upon itself until the armature reaches the proper posi-

tion of maximum intensity of current production, at which time the circuit is broken, as in the former instance. One end of the secondary winding (fine wire) is grounded on the live end of the primary, the other end being attached to the revolving arm of the distributor mechanism. So long as a closed circuit is maintained feeble currents will pass through the primary winding, and so long as the contact points are together this condition will exist. When the current reaches its maximum value, because of the armature being in the best position, the cam operates the interrupter and the points are separated, breaking the short circuit which has existed in the primary winding.

The secondary circuit has been open while the distributor arm has moved from one contact to another and there has been no flow of energy through this winding. While the electrical pressure will rise

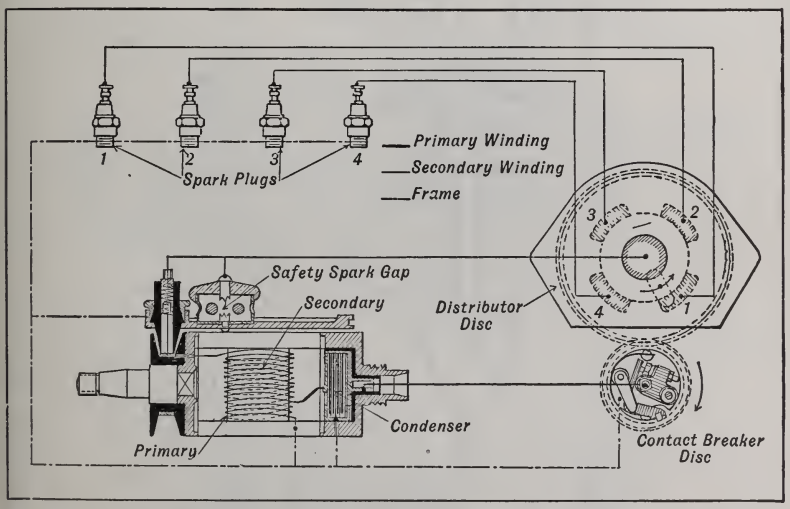


Fig. 396.—Simple Wiring Scheme when Four-Cylinder Magneto is Utilized for Gas Engine Ignition. Magneto Members Shown Separate to Facilitate Explanation of Principles of Operation.

in this, even if the distributor arm contacted with one of the segments, there would be no spark at the plug until the contact points separated, because the current in the secondary winding would not be of sufficient strength. When the interrupter operates, however, the maximum primary current will be diverted from its short circuit and can flow to the ground only through the secondary winding and spark-plug circuit. The high pressure now existing in the secondary winding will be greatly increased by the sudden flow of primary cur-

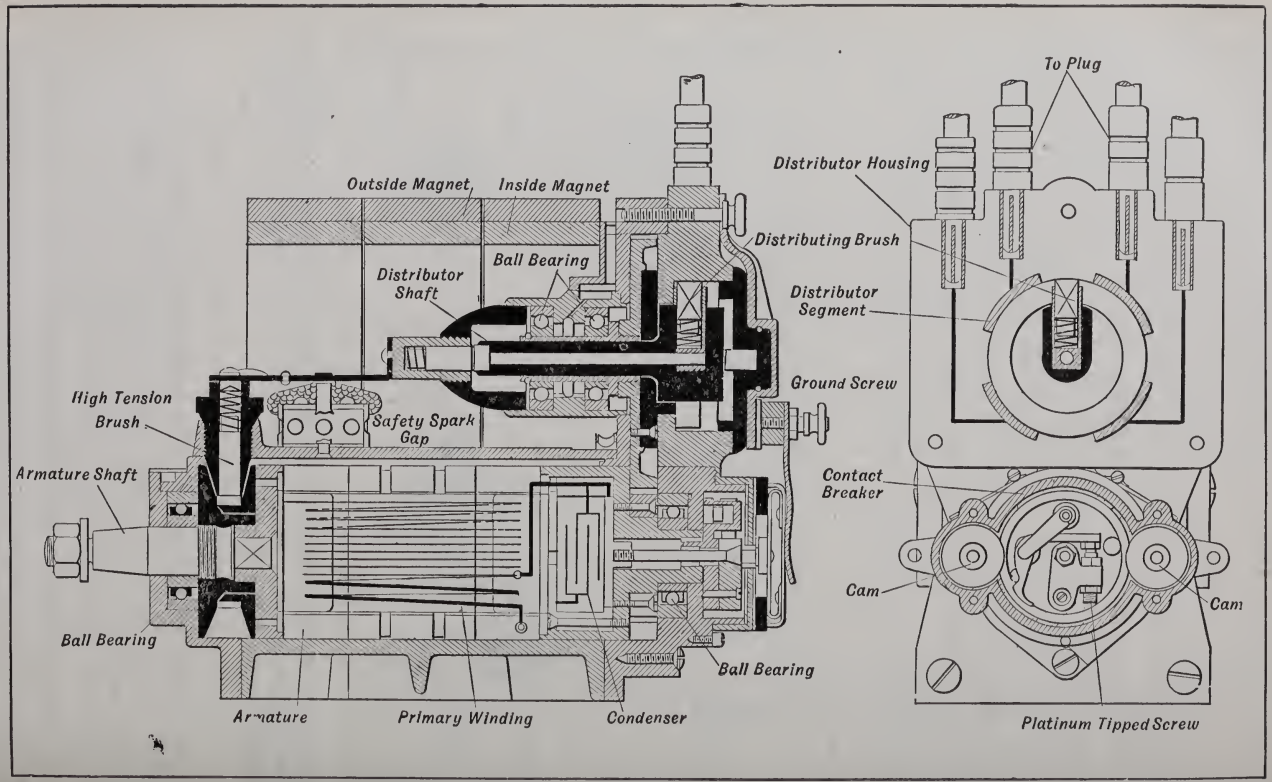


Fig. 397.—Side Sectional View of Bosch High-Tension Magneto Shows Disposition of Parts. End Elevation Depicts Arrangement of Interrupter and Distributor Mechanism.

rent and energy of high enough potential to successfully bridge the gap at the plug is thereby produced in the winding.

The simplified wiring system of a true high-tension magneto is shown at Fig. 396. The armature carries two windings, one indicated by the heavier lines at the bottom called the "primary"; the other, composed of finer conductor, is known as the "secondary." One end of the primary winding is grounded, the other is joined to the fixed contact screw of the contact breaker. This end is also joined to one end of the secondary winding and the free end of the secondary wind-

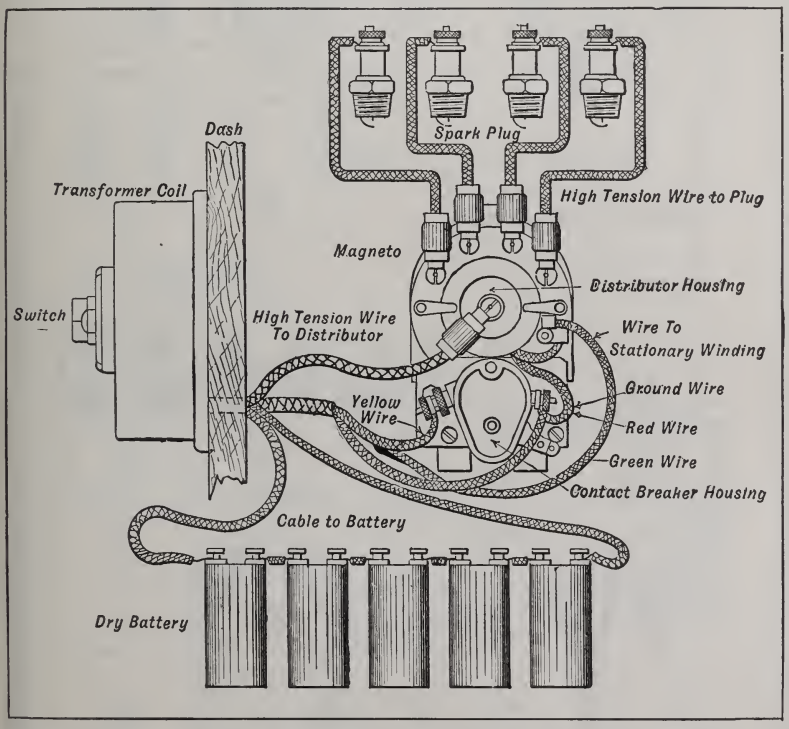


Fig. 398.—Wiring Diagram Outlining Method of Combining Magneto and Transformer Coil to Secure Four-Cylinder Engine Ignition System.

ing is attached to the collector ring carried by the ebonite spool. When the contact points separate, a current is induced in the primary and secondary windings and is delivered to the center terminal of the distributor disk by the carbon brush which bears against the collector ring.

The various segments of the distributor are connected to the spark plugs in the cylinders, and every time the contact points sep-

arate a spark will be produced at one of the plugs because the revolving distributor brush will be in contact with one of the distributor

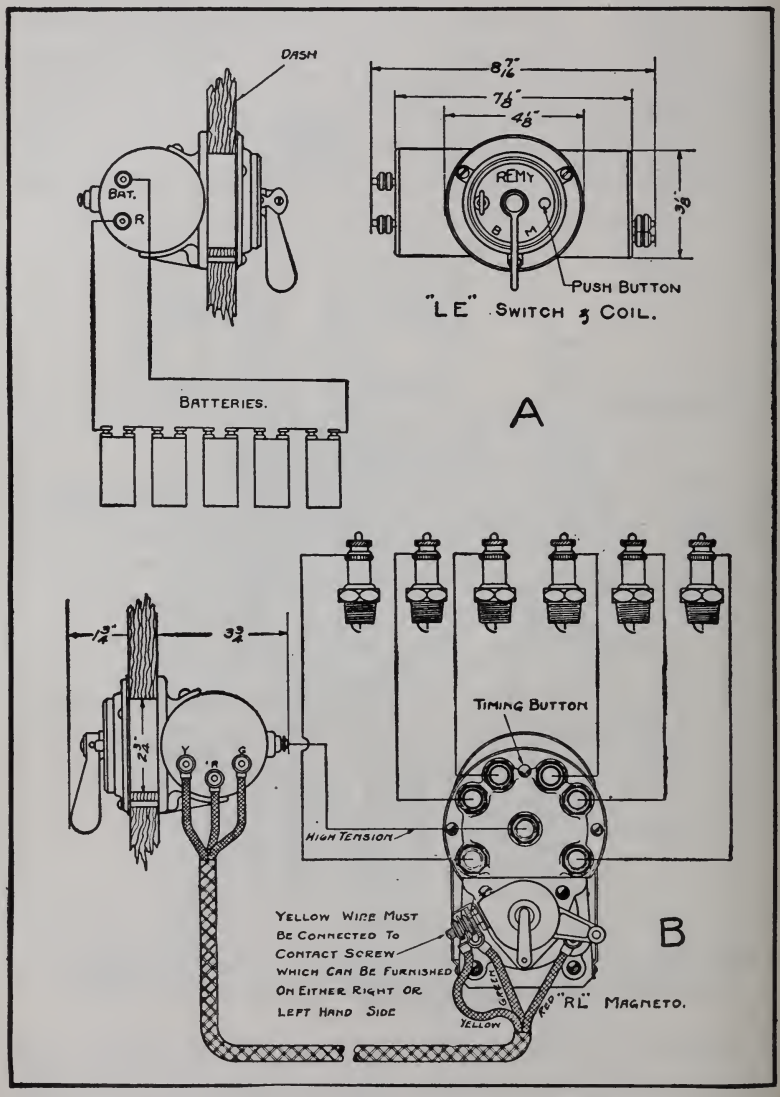


Fig. 399.—Wiring Diagram of the Remy Type R. L. Magneto.

segments. A cross-section view of the Bosch high-tension magneto is shown at Fig. 397 and the important parts are clearly shown. As the internal connections are very similar to those shown diagrammati-

cally, the same description given of the course of current in the former applies equally well to the latter.

The wiring of a four-cylinder magneto which employs a transformer coil is shown at Fig. 398. A set of batteries is provided to furnish current for starting, as it is sometimes difficult to turn the motor sufficiently fast by hand to generate the proper amount of magneto current to insure prompt starting. The high-tension wire from the spark coil or transformer is led to the center of the distributor and the current is commutated to the plugs just as though the high-tension current had been produced in the magneto itself instead

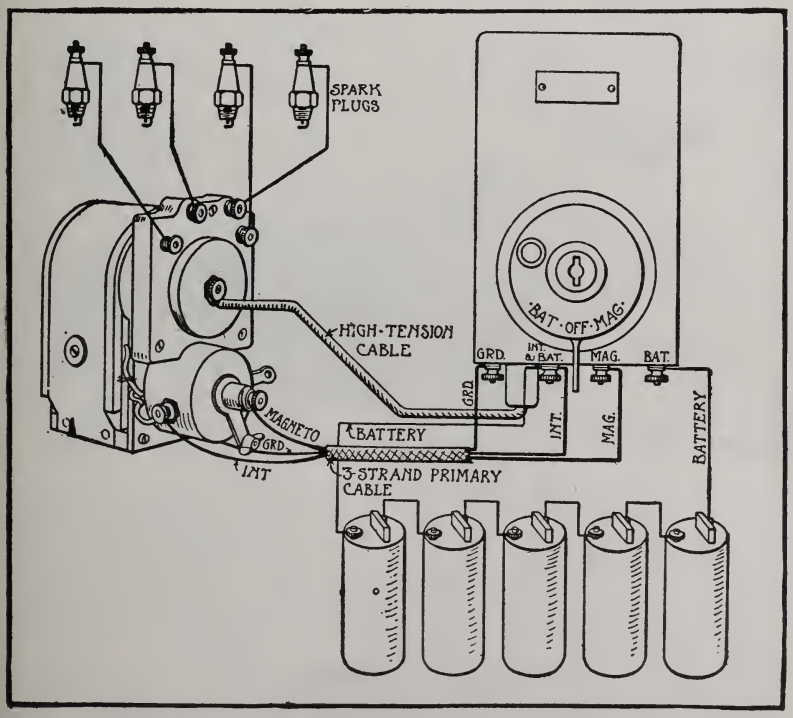


Fig. 400.—Typical Transformer-Coil Magneto System for Four-Cylinder Engine Ignition.

of in the transformer. The diagrams at Fig. 399 and 400 show other transformer-coil systems with all wiring clearly indicated. The method of wiring a transformer-coil magneto system so two sparks can be produced in each cylinder by using a special double magneto is shown at Fig. 401.

The Connecticut magneto, which is a transformer-coil type, is shown in longitudinal section and end elevation at Fig. 402. In this, the transformer coil is mounted between the magnets above the armature tunnel and the secondary current is applied directly to the distributing brush by means of a secondary collecting member which bears against a suitable terminal in the bottom of the coil casing. With this magneto the wiring is as simple as it would be with the true high-tension form and only five wires are needed in the external

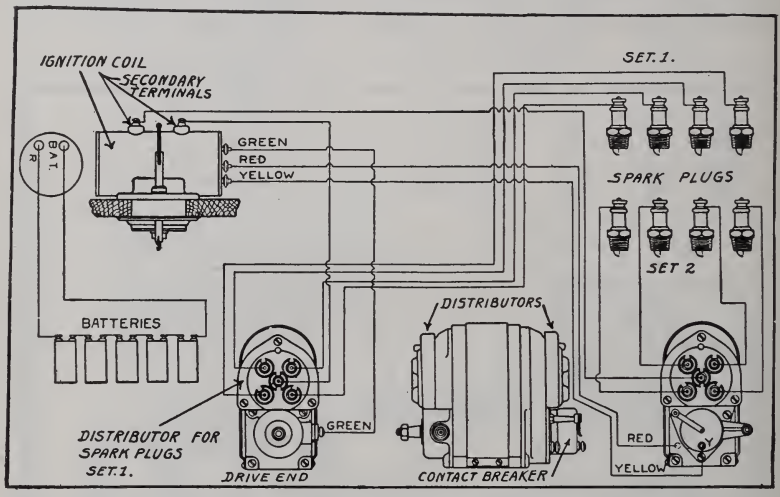


Fig. 401.—How Remy Two-Spark Magneto is Wired in Ignition Systems.

circuit. Of these, four secondary leads run direct from the distributor to the plug while the remaining one is a primary ground wire having a switch in circuit through which the primary coil current may be grounded instead of going to the transformer coil, thus stopping the motor.

All magnetos do not employ a revolving winding. Some utilize a stationary coil of wire and use rotating inductor members to cause the lines of magnetic force to flow through the wire and generate a current therein. A simplified wiring diagram of the K.W. magneto, which is an igniter of this type, is shown at Fig. 403, while a sectional view of the device itself is presented at Fig. 404. The stationary coil is composed of two windings, a primary and a secondary, and is mounted in the center of the device so that the rotary inductor shaft passes through it, one inductor being placed at each side of the stationary coil. The secondary wire passes through the insulated electrode

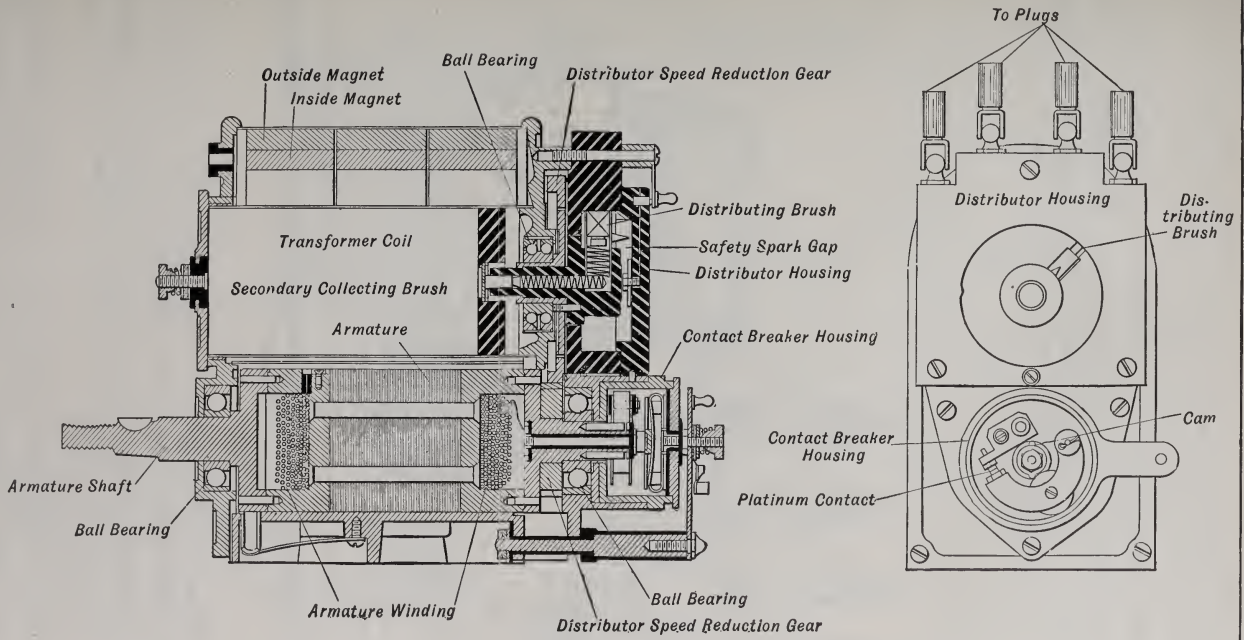


Fig. 402.—Defining Construction of Connecticut Magneto, a Form in which Transformer Coil is Placed Between Magnets Above Armature Tunnel.

through a bridge or strap member which is connected at one end to the spark gap and at the other to a bent conductor which conveys the current to a revolving distributor arm.

When the contact points are separated by the cam a current of electricity is induced in the primary coil and transformed to a high-tension current in the secondary winding and is delivered to the spark plugs by the conventional form of distributor. Except for the sta-

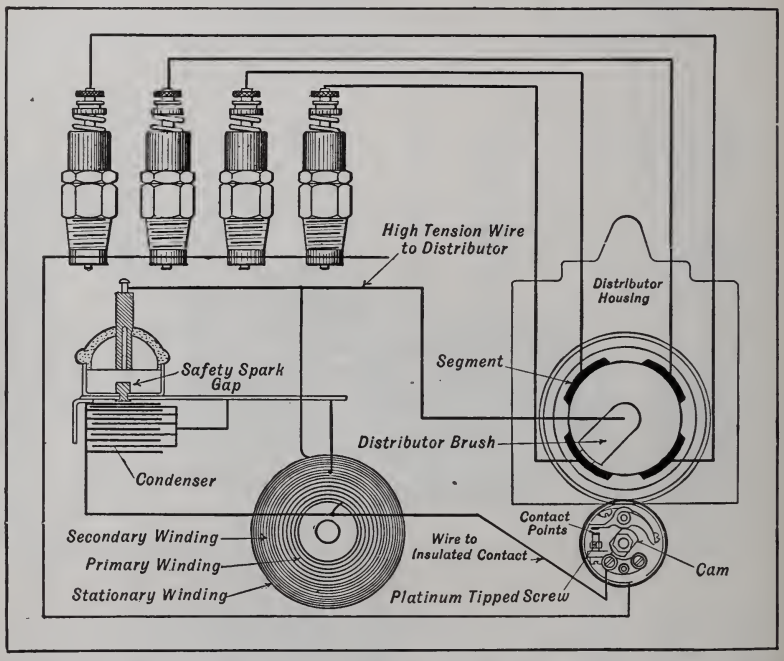


Fig. 403.—Showing Application of High-Tension Principle in K. W. Four-Cylinder Magneto.

tionary winding and the use of inductor pieces to reverse the lines of magnetism through the coil, the construction does not differ from the forms previously described. It is advanced that the stationary winding offers some advantages inasmuch as brushes are not required to collect the primary current.

The function of the safety spark gap is to take care of any excess current which might damage the insulation of the winding by allowing it to go to the ground. The air gap between the points has high enough resistance so that the spark will not jump it under normal conditions, but should the voltage become suddenly increased in value,

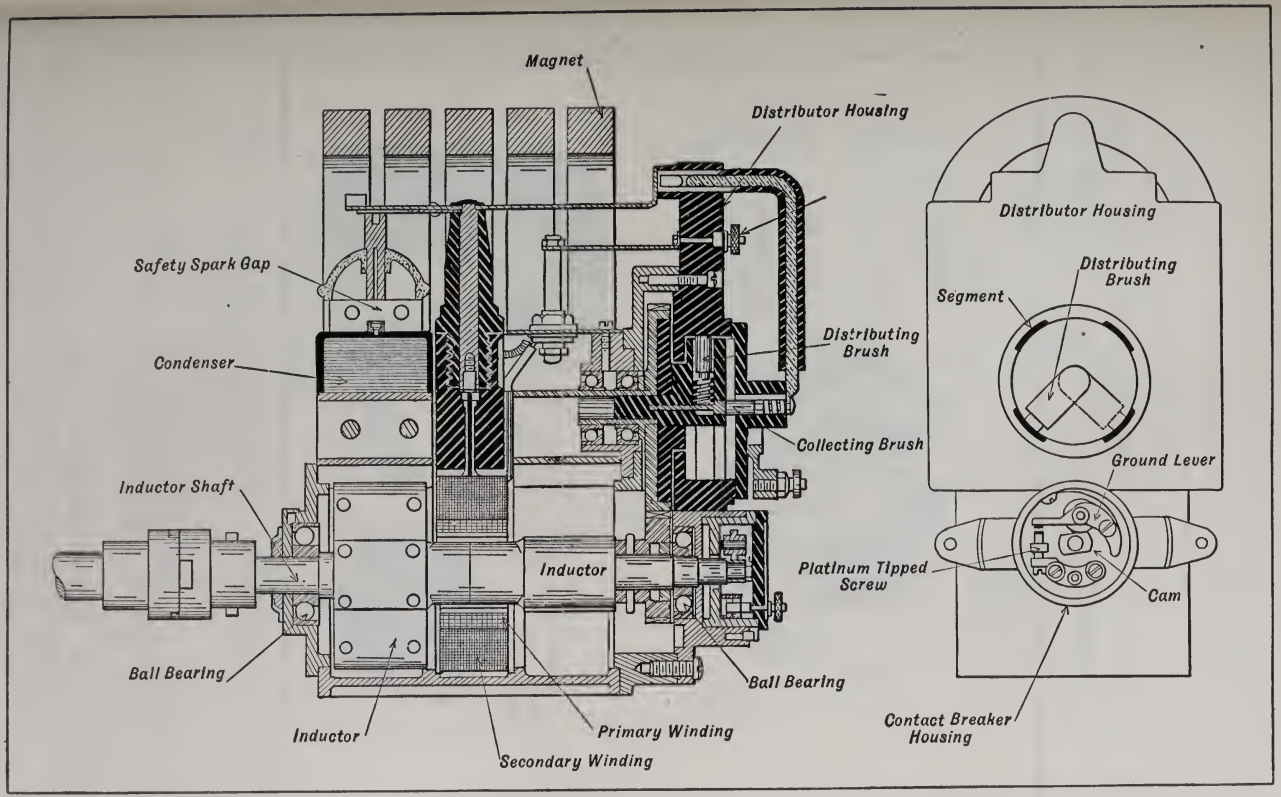


Fig. 404.—K. W. High-Tension Magneto, a Distinctive Form Utilizing Stationary Winding and Revolving Inductor Elements to Produce Current for Ignition.

as might be the case if one of the plug wires became disconnected, it will leap this gap in preference to overcoming the resistance of the insulation of the winding. The purpose of the condenser in a magneto is the same as that used in a coil, i. e., it is interposed in the primary circuit in such a way that it is in shunt connection with the contact-breaker points and absorbs any current which would tend to produce excessive sparking. The Splitdorf Dixie magneto, which

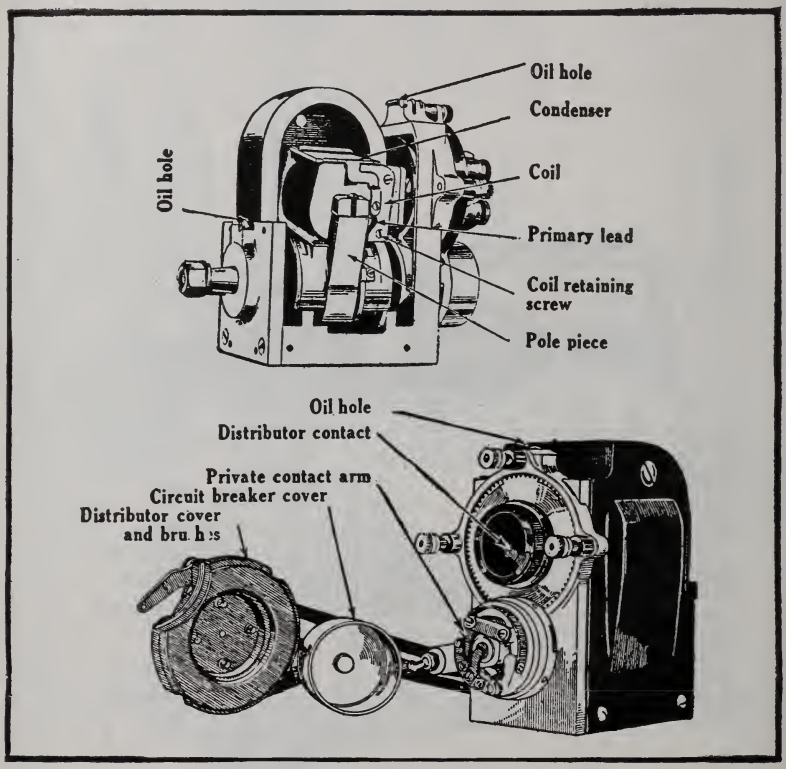


Fig. 405.—Splitdorf Dixie Magneto Used in 1916 Overland Cars.

is shown at Fig. 405, also has an inductor and fixed or non-rotating winding. The sectional view at Fig. 406, A, shows the interior construction.

Application of Typical Magneto Forms.—Some of the leading forms of American magnetos are shown at Fig. 407. That at A is the Heinze device and differs from the conventional form in that magnets of round section are used instead of the conventional horseshoe magnets of rectangular cross section. The form shown at B is

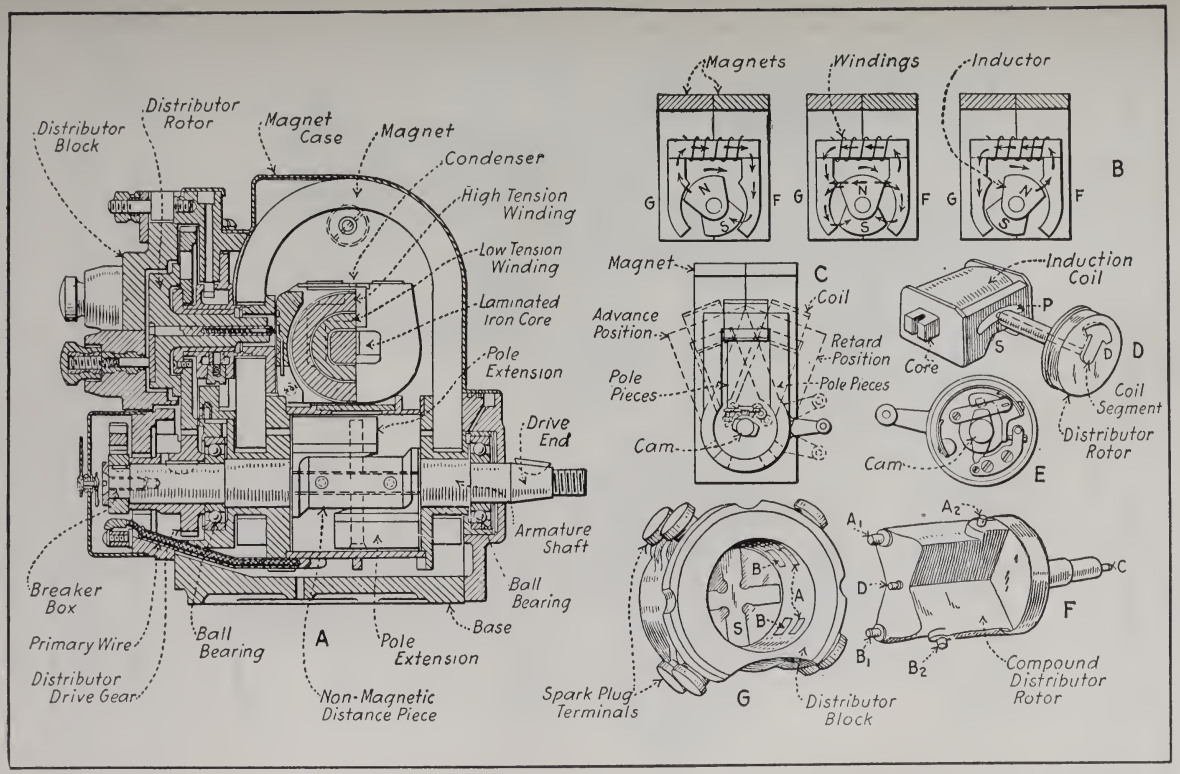


Fig. 406.—Sectional View of the Splitdorf Dixie Magneto at A and Views of Compound Distributor Construction at G and F.

the Kingston magneto, which is used in connection with a transformer coil. The Connecticut, which has been previously shown in section at Fig. 402, is depicted at C. The double distributor form intended to be used in connection with two-spark ignition systems shown at D is a Splitdorf design and should be used with a separate transformer coil.

The usual method of installing a magneto is to place it on a bracket fastened to the engine base so the contact breaker and dis-

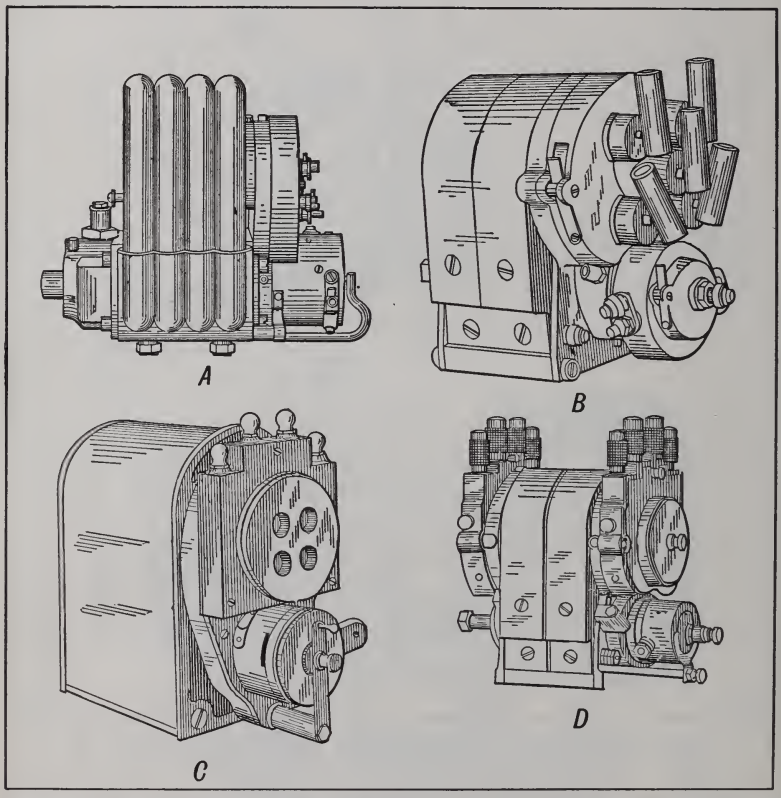


Fig. 407.—Typical American Magneto Forms. A—Heinze Machine with Round Section Magnets. B—Kingston Magneto for Dual Ignition. C—Clean Cut Design of Connecticut Device. D—Splitdorf Double Distributor Form Designed for Two-Spark Ignition Systems.

tributor will be handy for immediate inspection or adjustment. It is desirable to place the device on the inlet side of the engine and as far away from the exhaust piping as possible because the excess heat which exists at this point is liable to injure the insulation of the wind-

ings. Methods of installation which are typical of conventional practice are shown at Fig. 408. At A the magneto is placed on a cast bracket formed integral with the top half of the engine base and is driven from the timing case at the front of the engine by a length of shaft. At B the magneto is also housed at the rear end and is carried on a base plate formed integrally with one of the crank-case

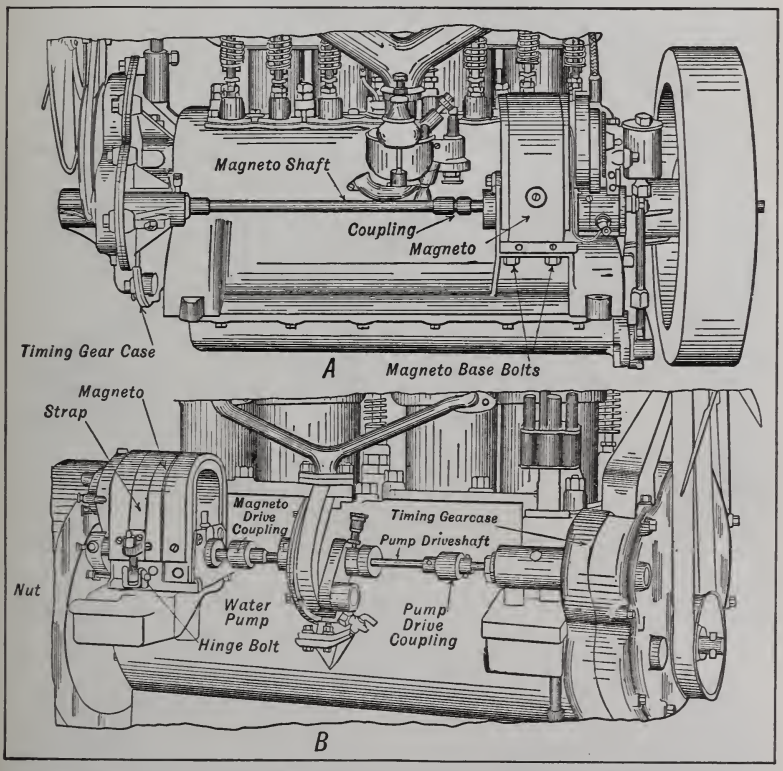


Fig. 408.—Conventional Methods of Placing and Driving Magnetos.

supporting arms. The drive is by an extension of the pump shaft, that member being driven by suitable gearing in the cam-shaft timing gear casing.

Gear drive is the best method of driving a magneto armature and direct spur-gear connection is better than either bevel or spiral gear trains because it is the best wearing form of gearing. Silent chains may be used for driving if some form of adjustment is provided to compensate for chain stretch. When a magneto is driven by a shaft, it is customary to provide some sort of a universal joint or Oldham coupling between the armature and the driving member in order that

any inaccuracies in alignment of the driving shaft will not stress the ball bearings supporting the armature. It is desirable to protect the instrument from oil or water by placing it in a case of fiber or leather, and in modern types the contact breaker and distributor housings are closed by easily removed and yet practically dust-tight coverings.

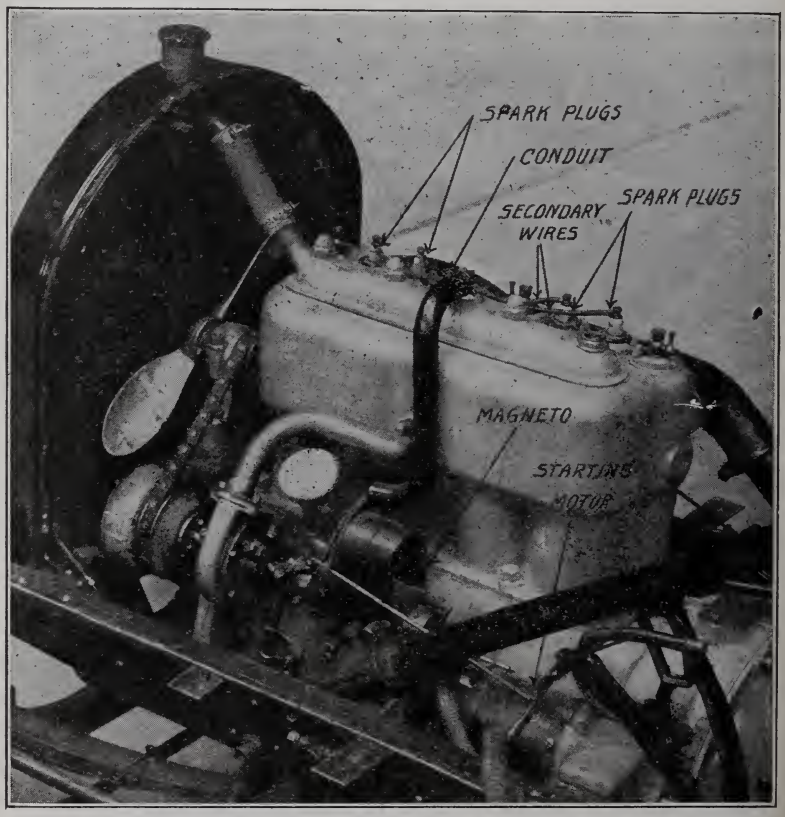


Fig. 409.—How Magneto is Installed on Jeffery Four-Cylinder Power Plant.

Some modern magneto installations are shown at Figs. 409 and 410 and are self-explanatory.

Metallic or carbon particles and dirty oil may cause internal short circuiting and it is desirable to have the contact-maker case and the distributor cover arranged in such a way that they may be easily reached for cleaning. Modern magnetos are usually secured in some way that will permit a ready removal. In that shown at A, Fig. 408, a number of through bolts are screwed from the under side of the bracket into the magneto base and it is necessary to remove these

before the magneto can be lifted off its support. The method shown at Fig. 408, B, is preferable, as the ignition device may be re-

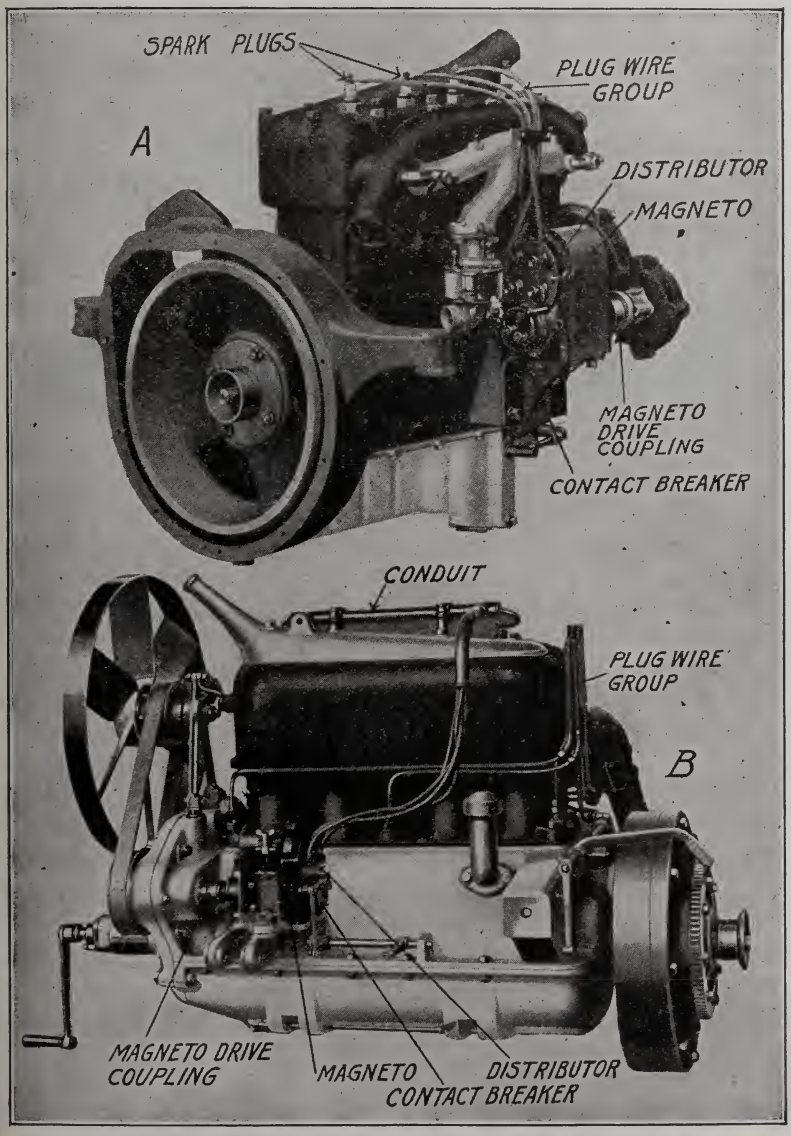


Fig. 410.—Typical Modern Magneto Installations. A—Simms Magneto on Maxwell Motor. B—Bosch D U 4 on White "45" Engine.

moved from the base by slackening one nut on the hinge bolt which keeps the metallic strap tight, thus holding the magneto in place.

Various other methods of utilizing strap members are shown at Fig. 411. In that shown at A the strap is made in two pieces and is held together at the top by a clamp bolt. The method of securing a

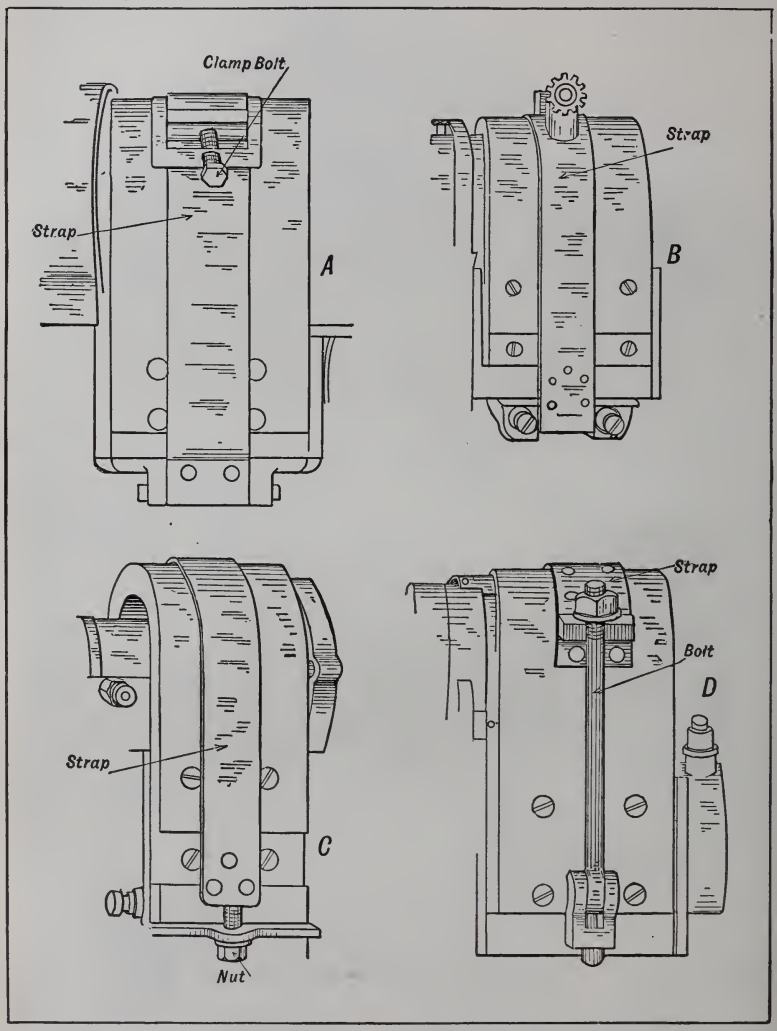


Fig. 411.—Simple Methods of Holding Magnetos in Place on Engine Base to Permit of Easy Removal of Apparatus when Desired.

magneto, shown at B, is practically the same, except that the retention member is a small knob which can be easily turned by the hand. At C the strap encircles the magneto completely and is held in place

by a single nut under the bracket. A modification of this method is depicted at D. The strap, in this instance, is just bent over the arch of the magnets and held in place by the long swinging bolt which is hinged at the bottom of the magneto.

One of the simplest methods of driving a magneto is that shown at Fig. 412, which is a bottom view of the Ford engine case. The

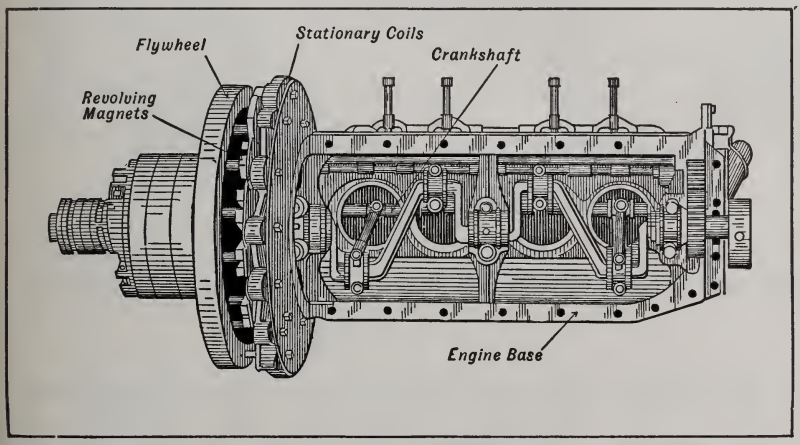


Fig. 412.—The Ford Magneto is Integral with Engine Base and Revolving Magnets are Attached to Fly Wheel. Direct Drive from Crankshaft is Possible without Gears.

stationary coils of the magneto are attached to the crank case, and the revolving magnets rotate with the fly wheel, which in turn is securely attached to the crank shaft. With this form of drive there can be no interruption in current generation and there are no gears, chains, or other connections to wear and produce noise or interfere with generation of current. The Ford ignition system, which is illustrated diagramatically at Fig. 413, and as applied to the engine at Fig. 414, is the only one of its kind. A simple roller contact timer is used, having four contacts and one revolving member. This sends the magneto current to the four vibrator coils carried on the dash and each coil sends the induced secondary or high-tension discharge to but one plug. Each cylinder evidently has its own coil.

When the magneto was first introduced it was looked upon with suspicion by the motoring public. Therefore some designers compromise and furnish two separate systems, one composed of a magneto, the other an auxiliary group comprising a battery, timer and coil, which supply the current to a set of spark plugs distinct from those supplied from the magneto. It was found difficult with some types

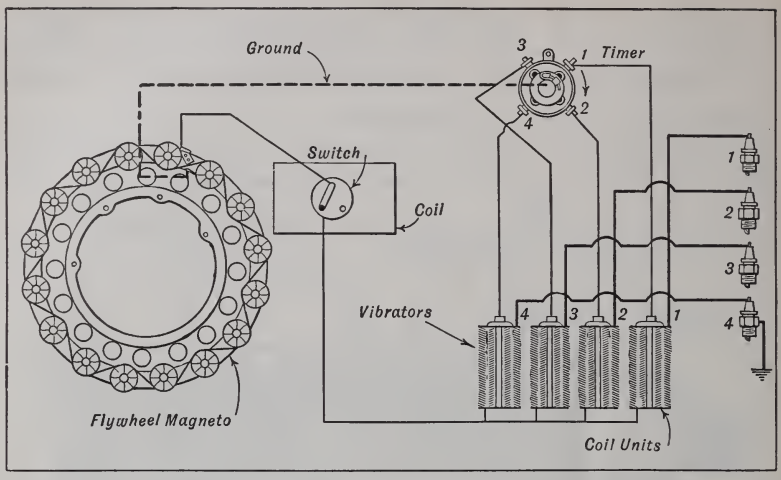


Fig. 413.—Diagram Showing Ford Magneto-Individual Coil Ignition System.

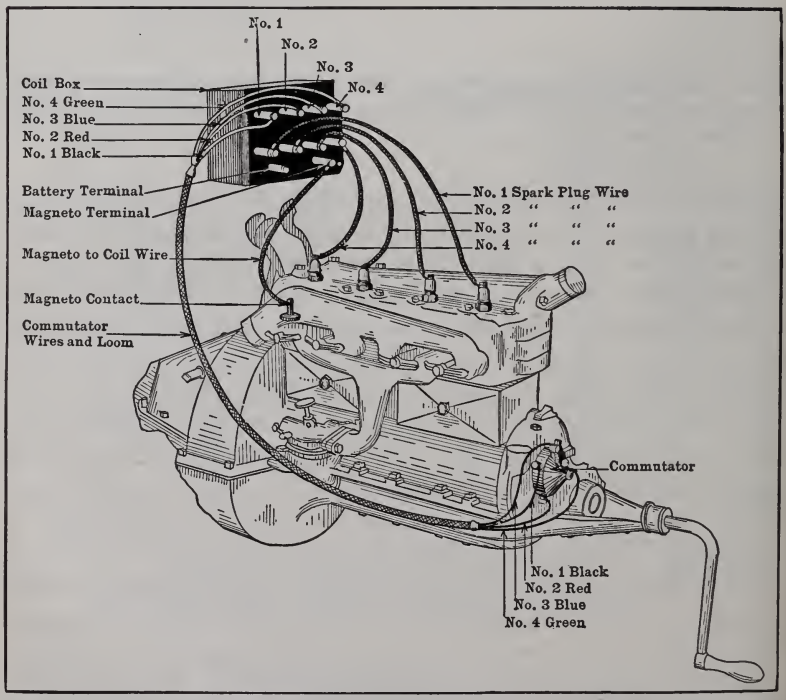


Fig. 414.—Complete Ford Magneto Ignition System, a Distinctive Construction Found Only on This Car.

of magnetos to start the engine directly from magneto current so the battery outfit was depended upon for starting the engine as well as emergency service. The parts of the modern high-tension magneto have been simplified and strengthened and as the various parts may be removed easily and replaced without trouble and special care taken so the adjustments and cleaning necessary may be easily understood by the layman there is very little liability at the present time of a magneto giving out without warning.

An old style magneto ignition system used in connection with a battery set is shown at Fig. 415. Six dry cells are used to supply the

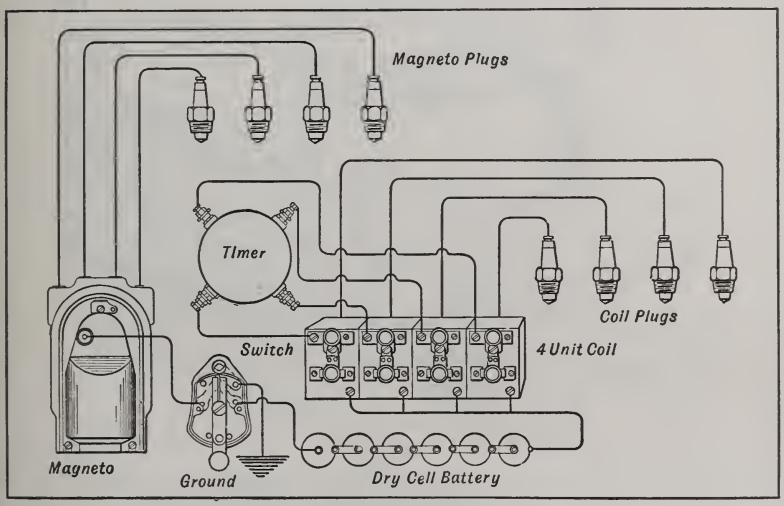


Fig. 415.—Double Ignition System Utilizing Battery and Induction Coil Group for Starting and Emergency Service and High-Tension Magneto as Main Ignition System.

current and a conventional four-point timer commutates the battery current to the four individual units of the coil box, which in turn delivers secondary current to the plugs. When the switch is thrown to one side the magneto system is utilized. When the contacts are reversed the battery system furnishes the ignition energy. The parts are shown arranged in diagram form so that the wiring may be easily followed and the relation of the various parts to each other definitely ascertained. The methods of wiring old style double systems are further exemplified by diagram shown at Fig. 416.

Connections of parts comprising the Bosch dual ignition system are shown at Fig. 417. With this method but one set of spark plugs is needed as the secondary distributor of the magneto is utilized

to distribute the high-tension current obtained either from the magneto armature or the battery and coil system. A separate timer is used to interrupt the battery current, and the coil carried on the dash is of such a nature that depressing a button will bring a vibrator in circuit and throw a constant stream of sparks across the air gap of the spark plug in the cylinder about to fire. This will start the engine, if a four- or six-cylinder form, without cranking when condi-

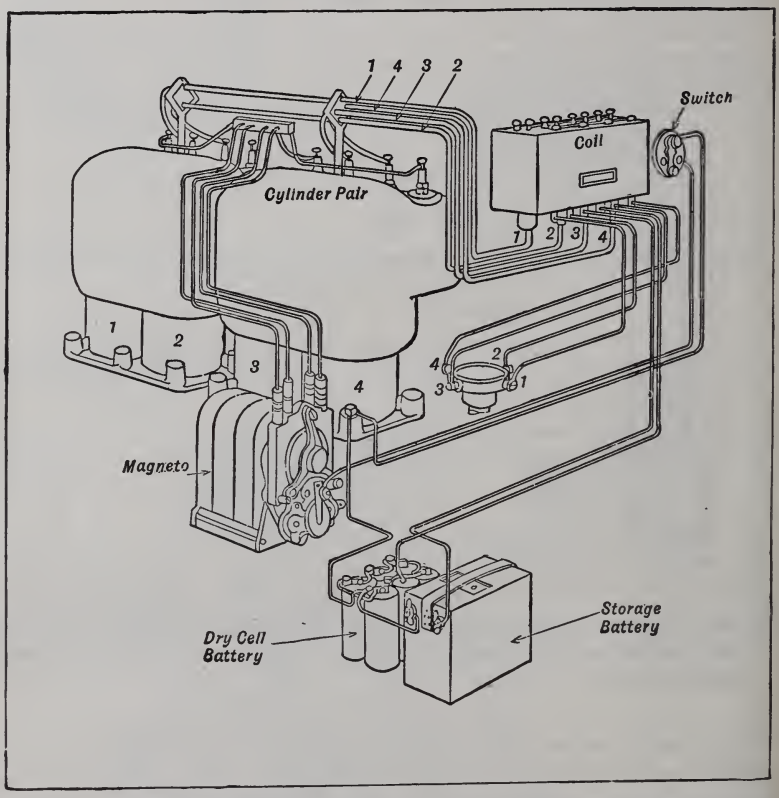


Fig. 416.—Practical Application of Double Ignition System to Four-Cylinder Power Plant.

tions are favorable. Ordinarily when running on the battery system the coil vibrator is not used, a single spark taking place between the points of the spark plug. The various connections are clearly shown in illustration and further description would be superfluous. The Duplex system differs from the dual system in the character of breaker box provided, as shown at Fig. 418. In the latter two conducting segments are placed on the inside of the breaker box cover to control

the primary current and no separate primary timer is needed, and instead of the separate induction coil of the dual system, the armature windings of the "duplex" magneto armature are used to intensify the battery current.

When a magneto is installed some precautions are necessary relating to wiring and also the character of the spark plugs employed. The conductor should be of good quality, have ample insulation and be well protected from accumulations of oil which would tend to decompose rubber insulation. It is customary to protect the wiring

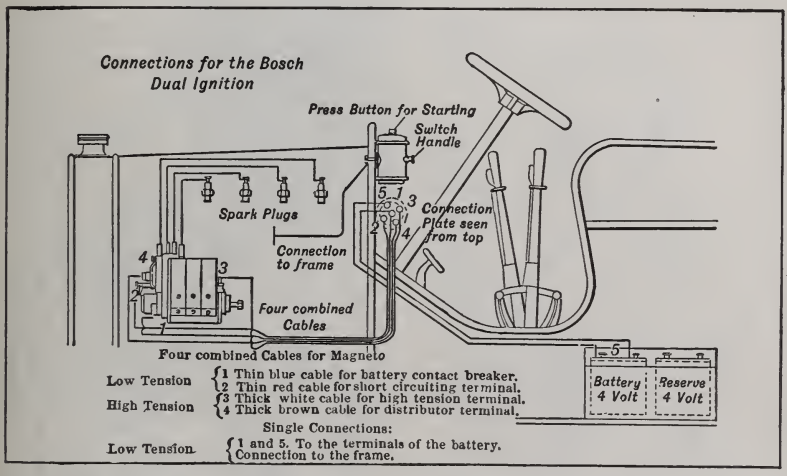

Connections for the Bosch Dual Ignition
Press Button for Starting
Switch Handle
Spark Plugs
Connection Plate seen from top
Connection to frame
Four combined Cables
Four combined Cables for Magneto
Low Tension
1 Thin blue cable for battery contact breaker.
2 Thin red cable for short circuiting terminal.
High Tension
3 Thick white cable for high tension terminal.
4 Thick brown cable for distributor terminal.
Single Connections:
Low Tension
1 and 5. To the terminals of the battery.
Connection to the frame.
Battery 4 Volt
Reserve 4 Volt

Fig. 417.—Method of Applying Bosch Dual Ignition System to Conventional Four-Cylinder Power Plant.

by running it through the conduits of fiber or metal tubing lined with insulating material. Multiple strand cables should be used for both primary and secondary wiring and the insulation should be of rubber at least $\frac{3}{16}$ inch thick.

The spark plugs commonly used for battery and coil ignition cannot always be employed when a magneto is fitted. The current produced by the mechanical generator has a greater amperage and more heat value than that obtained from transformer coils excited by battery current. The greater heat may burn or fuse the slender points used on some battery plugs and heavier electrodes are needed to resist the heating effect of the more intense arc. While the current has greater amperage it is not of as high potential or voltage as that commonly produced by the secondary winding of an induction coil, and it cannot overcome as much of a gap. Manufacturers of magneto plugs usually

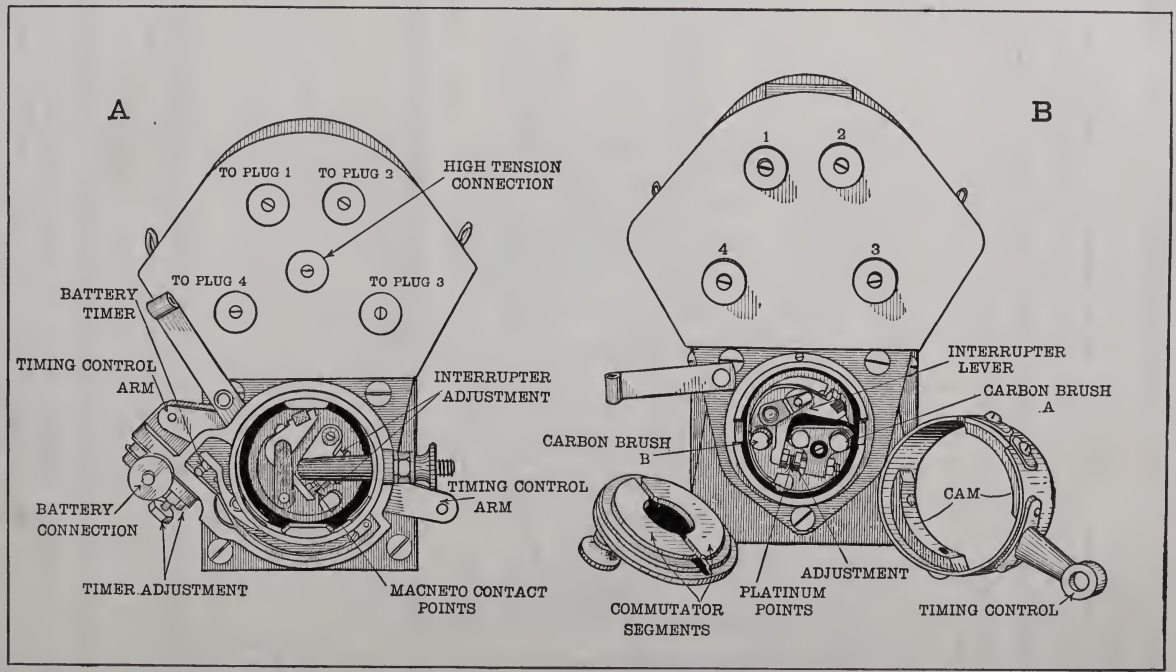


Fig. 418.—Contact Breakers for Bosch Magneto Double Systems. A—Arrangement for Dual Ignition. B—The Duplex Type.

set the spark points about $\frac{1}{64}$ of an inch apart. The most efficient magneto plug has a plurality of points so that when the distance between one set becomes too great the spark will take place between one of the other pairs of electrodes which are not separated by so great an air space.

Magneto with Automatic Advance.—The ignition time is advanced and retarded on most magnetos by rocking the contact breaker back and forth by a suitable mechanical connection with the spark lever on the steering wheel, as shown at Fig. 419. This drawing is

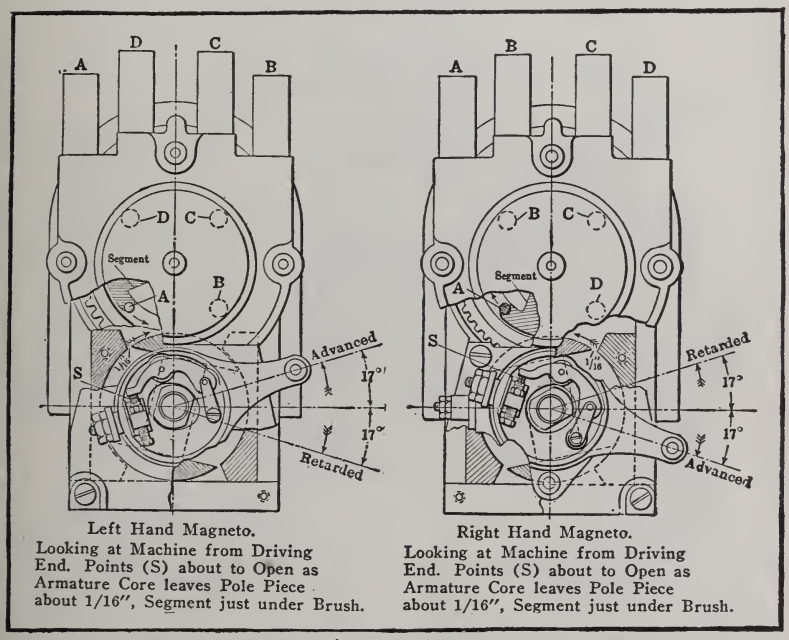

A
D
C
B
Segment
S
Advanced
17°
Retarded
Left Hand Magneto.
Looking at Machine from Driving End. Points (S) about to Open as Armature Core leaves Pole Piece about 1/16", Segment just under Brush.
Right Hand Magneto.
Looking at Machine from Driving End. Points (S) about to Open as Armature Core leaves Pole Piece about 1/16", Segment just under Brush.

Fig. 419.—Explaining Method of Timing Splitdorf Magneto.

also valuable in showing how a magneto is timed. The spark points should open only when the piston in the cylinder about to fire is at the top of its stroke. In the Eisemann magneto outlined an automatic spark control or advancing mechanism, which increases the lead of the spark as the engine speed increases, is included. This is clearly shown at Fig. 420. The operation of this automatic timer is very much the same as that of the Delco automatic spark advance, previously described. The governor weights are carried by a sleeve or quill mounted on an extension of the armature shaft, which has a rectangular block sliding within it. This block is threaded for re-

ceiving a spirally cut shaft, which is driven by direct connection with the engine through some form of gearing. The governor weights are attached to the sliding block by means of links, and as the shaft is revolved the weights tend to spread apart, and as they do the block is made to slide in the quill. In so moving it travels along the threaded shaft, which results in slightly rocking the block. As the block oscillates it carries the quill in which it works forward a small amount and also the armature shaft to which the quill is fixed. The armature is thus advanced and also the commutator, which is attached to the front end of the armature shaft. As the speed increases the

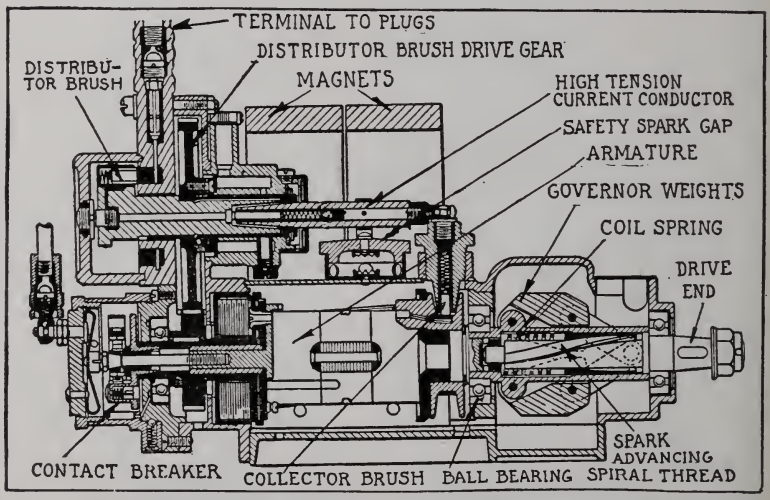


Fig. 420.—The Eisemann High-Tension Magneto with Automatic Spark Advance.

governor weights fly farther out and advance the time of ignition. When the speed diminishes the weights tend to close up, this being assisted by the action of a coil spring, against which the governor weights work at all times. An automatic spark advance may be obtained from 18-57 degrees with this construction.

Impulse Starters.—Special forms of couplings, as illustrated at Fig. 421, may be used to drive the magneto armature. This provides a hot spark even when cranking slowly, as the armature speed is accelerated by a spring arrangement so the speed approximates that obtained when the engine is turning over under power. The device illustrated is known as the Eisemann impulse starter coupling. This may be attached to any model of Eisemann magneto and is said to have no effect upon its regular operation except at slow

speeds, when it causes the armature to rotate in a series of jumps instead of at a uniform speed. These jumps cause the armature to cut the lines of force of the magnets quickly, or at the same speed that it does when the motor is revolving swiftly, so that a hot spark is generated. This removes any necessity for auxiliary battery ignition for starting on heavy duty motors, for a hot fat spark is generated at any speed, regardless of how slowly

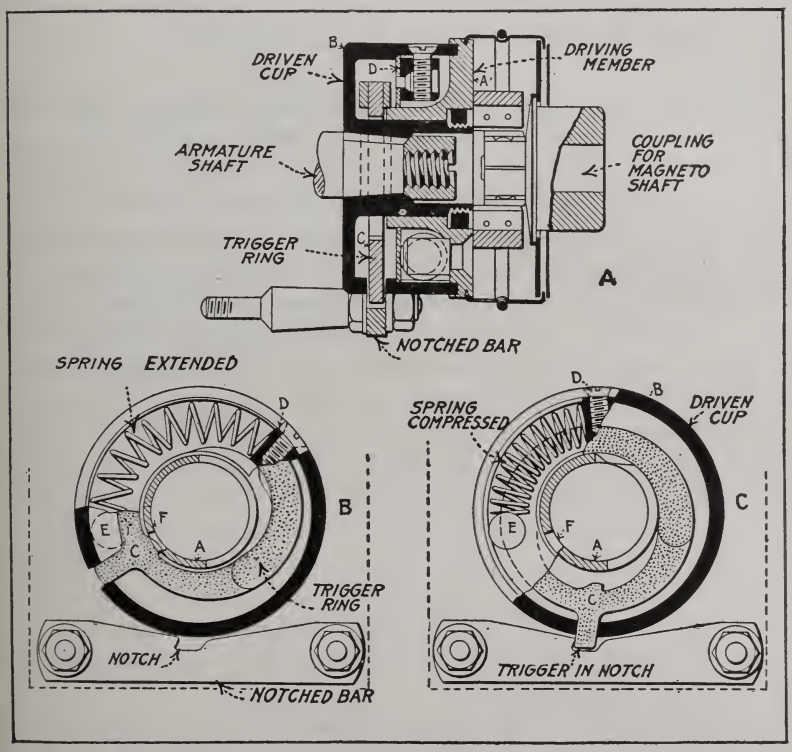


Fig. 421.—Diagrams Explaining Action of Eisemann Impulse Starter.

the crank is turned. This is an important advantage in starting truck motors, for which magneto ignition is very popular. The coupling consists of a driving tube A in the center and a driven cup B inclosing the device, the two being connected by a spring. Within the driven cup is a loose ring C, known as the trigger, this ring having a lip which extends through a slot on the periphery of the cup. At the bottom of the coupling a notched bar is so positioned that as the cup revolves the notch registers with the slot in the cup, so that the

trigger lip drops down by gravity and thus locks the cup against rotation. This is the position shown in the view at C. On the outside of the trigger ring is a cam which engages a corresponding cam cut in the driving tube. When the lip has engaged the notched bar and the cup ceases to rotate the driving tube continues to turn. This turning compresses the spring which is seated against a driving pin on the tube and a block fixed to the cup. At a predetermined point the cam on the trigger ring engages that on the tube, and lifts the trigger, releasing it and allowing the spring to jerk the armature drive member around, cut the magnetic force quickly and generate a hot spark.

Distributor for Eight- and Twelve-Cylinder Engines.—The compound distributor construction used with Dixie magnetos for eight- and twelve-cylinder engines is clearly shown at Fig. 406. As shown at G, the distributor block has a plate S imbedded into it, which is made "live" by the contact of the brush D, shown in the center of the distributor rotor outlined at F. This brush is in contact with the main secondary current delivery plate on the induction coil at all times. Two brushes rotate over the cross-shaped plate S, these being marked A1 and B1 and are connected to the corresponding brushes on the periphery of the rotor, A2 and B2. The path of brush A2 includes the four segments or plug terminal plates A, while brush B2 sweeps over the terminal segments B. Now, since the two brushes A1 and B1 are arranged 135 degrees apart, it follows that eight sparks will be distributed to their respective terminals in one revolution of the distributor block in equal divisions of time. The timer gear is in the ratio of two to one, so that this magneto runs at engine speed, an unusual feature of an eight-cylinder magneto. On the twelve the distributor gear ratio is three to one, requiring a speed one and one-half times the engine speed.

The distributor for the twelves is identical in every respect except that the contact star at the base of the box is six-pointed instead of four, to supply the twelve terminals which are arranged in two layers of six instead of four, as shown in the external view (Fig. 406, G). By the use of the compound distributor block on the eights and twelves as many as 285 sparks of high intensity can be obtained per second. Owing to this high speed of spark production a double contact breaker having two breaker arms and contact points is used on the twelves.

Constructionally the Dixie magnetos are up to the present high standard of practice. The shaft runs on ball bearings, as shown at Fig. 406, A, tightly fitting brass side covers inclose the magnetos and

the whole instrument can be dismantled with no other tool than a screw-driver. The sectional view is that of a four-cylinder magneto. The diagrams at B show how the magnetism flow is reversed by the rotor poles. The method of advancing and retarding the spark is shown at C. The connection between the distributor rotor and induction coil is depicted at D. The contact breaker for a four-cylinder magneto is shown at E. The magnet itself is in two parts and fits into place without bolting, having semi-circular notches which embrace the shaft bearing. Great accuracy has been used in the manufacture of the rotating pole extensions, the clearance between the ends and the stationary poles being brought down to the workable minimum. An interesting point in connection with the operation of these pole extensions is that end thrust is neutralized by the equal magnetic pull on both ends of the rotor. The compactness of the magnets can be realized from the dimensions which except in the height are practically identical in all models. The common width is 4.125 inches and the total length 8.375 inches. On the twelve the height of the magnet is 7.5 inches, being one inch more than the others so as to provide a stronger magnetic field.

CHAPTER VIII

LUBRICATION AND ENGINE COOLING SYSTEMS

Reason for Lubrication of Mechanism—Definition of Friction—Theory of Lubrication—Requirements of Engine Oils—Derivation of Lubricants—Classification of Lubricants—Correct Oil Body of Vital Importance—How Viscosity is Tested—Oil Destruction Due to Exposure to Heat—Sight-Feed Oil Cups—Gravity Feed Systems—Mechanical Oiling Methods—Oil Pump Forms—Oil Distribution Methods—Oil Supply by Constant Level Splash System—Saxon Air Lock System—Hupmobile Flywheel Oil Distribution—Distributing Lubricant by Pressure—Function of Oil Pressure Gauge—Regulating Oil Pressure—1917 Pierce-Arrow System—Oiling V Engines—Individual Pump Oilers—Lubrication Don'ts—Why Cooling Systems are Necessary—Cooling Systems Generally Applied—Cooling by Positive Water Circulation—Cooling Action of Radiator—Water-Circulating Pumps—Water Circulation by Natural System—Radiator Location—Cooling Fan Construction—Radiator with Air Shutters—Thermostatic Temperature Regulators—Radiator Construction—Solderless Radiator for Trucks—Direct Air Cooling Methods—Utility of Auxiliary Exhaust Valves—Air Cooled Two-Cycle Engine—Blower Cooled Engines.

THE importance of minimizing friction at the various bearing surfaces of machines to secure mechanical efficiency is fully recognized by all mechanics, and proper lubricity of all parts of the mechanism is a very essential factor upon which the durability and successful operation of the motor car power plant depends. All of the moving members of the engine which are in contact with other portions, whether the motion is continuous or intermittent, of high or low velocity or of rectilinear or continued rotary nature, should be provided with an adequate supply of oil. No other assemblage of mechanism is operated under conditions which are so much to its disadvantage as the motor car, and the tendency is toward a simplification of oiling methods so that the supply will be ample and automatically applied to the points needing it.

In all machinery in motion the members which are in contact have a tendency to stick to each other and the very minute projections which exist on even the smoothest of surfaces would have a tendency to cling or adhere to each other if the surfaces were not kept apart by some elastic and unctuous substance. This will flow or spread out

over the surfaces and smooth out the inequalities existing which tend to produce heat and retard motion of the pieces relative to each other.

A general impression which obtains is that well machined surfaces are smooth and while they are apparently free from roughness and no projections are visible to the naked eye, any smooth bearing surface, even if very carefully ground, will have a rough appearance if examined with a magnifying glass. An exaggerated condition to illustrate this point is shown at Fig. 422. The amount of friction

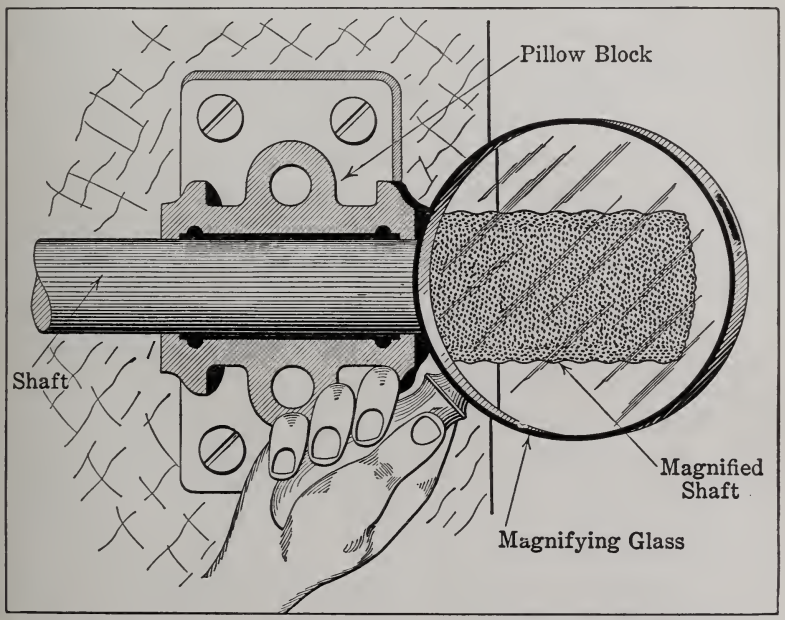


Fig. 422.—Showing Use of Magnifying Glass to Demonstrate that Apparently Smooth Metal Surfaces May Have Minute Irregularities which Produce Friction.

will vary in proportion to the pressure on the surfaces in contact and will augment as the loads increase, the rougher surfaces will have more friction than smoother ones and soft bodies will produce more friction than hard substances.

Definition of Friction.—Friction is always present in any mechanism as a resisting force that tends to retard motion and bring all moving parts to a state of rest. The absorption of power by friction may be gauged by the amount of heat which exists at the bearing points. Friction of solids may be divided into two classes: sliding friction, such as exists between the piston and cylinder, or the bearings

of a gas engine, and rolling friction, which is that present when the load is supported by ball or roller bearings, or that which exists between the tires or the driving wheels and the road. Engineers endeavor to keep friction losses as low as possible and much care is taken in all modern automobiles to provide adequate methods of lubrication, or anti-friction bearings at all points where considerable friction exists.

Theory of Lubrication.—The reason a lubricant is supplied to bearing points will be easily understood if one considers that these elastic substances flow between the close fitting surfaces, and by filling up the minute depressions in the surfaces and covering the high spots act as a cushion which absorbs the heat generated and takes the wear instead of the metallic bearing surface. The closer the parts fit together the more fluid the lubricant must be to pass between their surfaces and at the same time it must possess sufficient body so that it will not be entirely forced out by the pressure existing between the parts.

Oils should have good adhesive, as well as cohesive, qualities. The former are necessary so that the oil film will cling well to the surfaces of the bearings; the latter, so the oil particles will cling together and resist the tendency to separation which exists all the time the bearings are in operation. When used for gas-engine lubrication the oil should be capable of withstanding considerable heat in order that it will not be vaporized by the hot portions of the cylinder. It should have sufficient cold test so that it will remain fluid and flow readily at low temperature. Lubricants should be free from acid, or alkalis, which tend to produce a chemical action with metals and result in corrosion of the parts to which they are applied. It is imperative that the oil be exactly the proper quality and nature for the purpose intended and that it be applied in a positive manner. The requirements may be briefly summarized as follows:

First—It must have sufficient body to prevent seizing of the parts to which it is applied and between which it is depended upon to maintain an elastic film, and yet it must not have too much viscosity in order to minimize the internal or fluid friction which exists between the particles of the lubricant itself.

Second—The lubricant must not coagulate or gum, must not injure the parts to which it is applied, either by chemical action or by producing injurious deposits, and it should not evaporate readily.

Third—The character of the work will demand that the oil should not vaporize when heated or thicken to such a point that it will not flow readily when cold.

Fourth—The oil must be free from acid, alkalis, animal or vegetable fillers, or other injurious agencies.

Fifth—It must be carefully selected for the work required and should be a good conductor of heat.

Derivation of Lubricants.—The first oils which were used for lubricating machinery were obtained from animal and vegetable sources, though at the present time most unguents are of mineral derivation. Lubricants may exist as fluids, semifluids, or solids. The viscosity will vary from light spindle or dynamo oils, which have but little more body than kerosene, to the heaviest greases and tallows. The most common solid employed as a lubricant is graphite, sometimes termed "plumbago" or "black lead." This substance is of mineral derivation.

The disadvantage of oil of organic origin, such as those obtained from animal fats or vegetable substances, is that they will absorb oxygen from the atmosphere which causes them to thicken or become rancid. Such oils have a very poor cold test as they solidify at comparatively high temperatures and their flashing point is so low that they cannot be used at points where much heat exists. In most animal oils various acids are present in greater or less quantities, and for this reason they are not well adapted for lubricating metallic surfaces which may be raised high enough in temperature to cause decomposition of the oils.

Lubricants derived from the crude petroleum are called "Oleonapthas" and they are a product of the process of refining petroleum through which gasoline and kerosene are obtained. They are of lower cost than vegetable or animal oil and as they are of nonorganic origin they do not become rancid or gummy by constant exposure to the air and they will have no corrosive action on metals because they contain no deleterious substances in chemical composition. By the process of fractional distillation mineral oils of all grades can be obtained. They have a lower cold and higher flash test and there is not the liability of spontaneous combustion that exists with animal oils.

The organic oils are derived from fatty substances which are present in the bodies of all animals and in some portions of plants. The general method of extracting oil from animal bodies is by a rendering process which consists of applying sufficient heat to liquefy the oil and then separating it from the tissue with which it is combined by compression. The only oil which is used to any extent in gas-engine lubrication that is not of mineral derivation is castor oil. This substance has been used on high-speed racing automobile engines and on aëroplane power plants. It is obtained from the seeds of the castor plant, which contain a large percentage of oil.

Among the solid substances which may be used for lubricating purposes may be mentioned tallow, which is obtained from the fat of animals, and graphite and soapstone, which are of mineral derivation. Tallow is never used at points where it will be exposed to much heat, though it is often employed as a filler for greases used in transmission gearing. Graphite is sometimes mixed with oil and applied to cylinder lubrication, though it is most often used in connection with greases in the running gear parts. Graphite is not affected by heat, cold, acids, or alkalis and has a strong attraction for metal surfaces. It mixes readily with oils and greases and increases their efficiency in many applications. It is sometimes used where it would not be possible to use other lubricants because of extremes of temperature. Graphite can be applied to advantage to practically all portions of the motor-car mechanism.

The oils used for cylinder lubrication are obtained almost exclusively from crude petroleum derived from American wells. Special care must be taken in the selection of the crude material, as every variety will not yield oil of the proper quality to be used as a cylinder lubricant. The crude petroleum is distilled as rapidly as possible with fire heat to vaporize off the naphthas and the burning oils. After these vapors have been given off superheated steam is provided to assist in distilling. When enough of the light elements have been eliminated the residue is drawn off, passed through a strainer to free it from grit and earthy matters, and is afterwards cooled to separate the wax from it. This is the dark cylinder oil and is the grade usually used for steam-engine cylinders.

The oil that is to be used in the gasoline engine must be of high quality and for that reason the best grades are distilled in a vacuum that the light distillates may be separated at much lower temperatures than ordinary conditions of distilling permit. If the degree of heat is not high the product is not so apt to decompose and deposit carbon. If it is desired to remove the color of the oil which is caused by free carbon and other impurities it can be accomplished by filtering the oil through charcoal. The greater the number of times the oil is filtered the lighter it will become in color. The best cylinder oils have flash points usually in excess of 500 degrees F. and while they have a high degree of viscosity at 100 degrees F. they become more fluid as the temperature increases.

Classification of Lubricants.—The lubricating oils obtained by refining crude petroleum may be divided into three classes:

First—The natural oils of great body which are prepared for use by allowing the crude material to settle in tanks at high temperature

and from which the impurities are removed by natural filtration. These oils are given the necessary body and are free from the volatile substances they contain by means of superheated steam which provides a source of heat.

Second—Another grade of these natural oils which are filtered again at high temperatures and under pressure through beds of animal charcoal to improve their color.

Third—Pale, limpid oils, obtained by distillation and subsequent chemical treatment from the residuum produced in refining petroleum to obtain the fuel oils.

Authorities agree that any form of mixed oil in which animal and mineral lubricants are combined should never be used in the cylinder of a gas engine as the admixture of the lubricants does not prevent the decomposition of the organic oil into the glycerides and fatty acids peculiar to the fat used. In a gas-engine cylinder the flame tends to produce more or less charring. The deposits of carbon will be much greater with animal oils than with those derived from the petroleum base because the constituents of a fat or tallow are not of the same volatile character as those which comprise the hydrocarbon oils which will evaporate or volatilize before they char in most instances.

A suitable lubricant for gas-engine cylinders is a pure hydrocarbon oil having a high vaporizing point, about 200 degrees F., a flash point of 430 degrees F., and a fire test of about 600 degrees F. It is fortunate that many brands of good oils may be obtained at the present time and in this connection it is well to state that the best oil is none too good for the motor-car engine cylinders. There is an impression among many motorists of economical tendencies that any oil will answer and that the cheapest is obviously best because it costs less. A point that cannot be too strongly impressed upon all who have machinery of any description in their care is that efficient operation can only be obtained by selecting proper lubricant, and that high quality oils can only be obtained by paying for them. In this application the old adage, "The best is the cheapest in the end," is particularly apropos.

Correct Oil Body of Vital Importance.—To many motorists all oils are the same and should be equally effective for gas-engine lubrication. This is not true, as careful experiments have demonstrated that it is possible to lose considerable power by using unsuitable oil, even though it be of the highest grade. This matter is discussed by C. W. Stratford, M. E., an expert on lubricants and lubrication, as follows:

"In all phases of lubrication the matter of correct viscosity is

one of prime importance and its effect is far-reaching. The curves shown in Fig. 423 will point out the effect that viscosity has upon horse power, and fuel and oil consumption. Even the veriest novice can readily note the difference between the power and rapidity of acceleration of his motor when using a light or medium oil (180 to 350 seconds) as compared to an extremely heavy oil (2,300 seconds). When oils lighter than 180 seconds are used the horsepower falls off very rapidly until the pistons and bearings finally seize, with oil of approximately 100 seconds. It will be seen that the fuel consumption

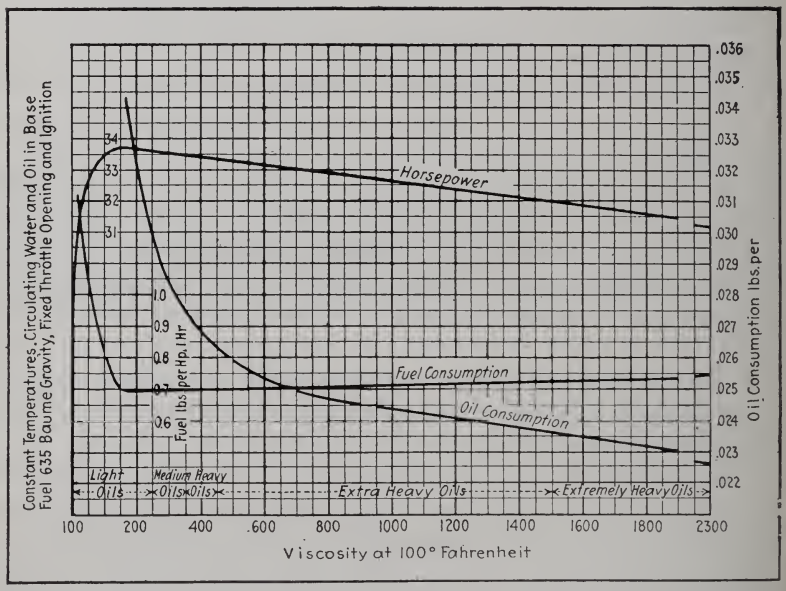


Fig. 423.—Chart Showing Relative Oil Consumption and Horse-power Delivered in Tests of Oils of Various Bodies.

reaches its minimum when a light oil of about 180 seconds is used. Oil of this viscosity gives the maximum horsepower obtainable. As the viscosity increases from 180 seconds the fuel consumption increases uniformly with it. With oils below 180 seconds the fuel consumption mounts to its maximum.

"Considering the curve of oil consumption a most extraordinary variation in the quantity of light and heavy oils burned will be remarked. Between 800 and 2,300 seconds the variation is comparatively slight, a fact which indicates that there is no advantage to be gained by the use of oils heavier in body than 800 seconds. Passing from 800 to the light oils it becomes evident at once that there must

be some point (viscosity) where the highest economy of both fuel and oil is attained together with high horsepower. Both laboratory and service tests on the road have demonstrated that this point lies between 300 and 800 seconds and that it depends directly upon the condition of the motors in which the oils are used and upon their average operating temperatures. Were it not for the difficulty of a more rapid carbonization (when heavy oils are used) no oil having a viscosity of less than 300 would be recommended, in the light of these facts. But a practical compromise must be reached; consequently light and medium oils (180 to 300 seconds) are regularly specified as being the most fool-proof in character and hence best capable of meeting the most widely differing conditions of service."

How Viscosity is Tested.—The measure of viscosity given is determined by how quickly a given amount of oil at a certain temperature will escape through a definite, unchangeable orifice. Light oil will run out quicker than heavier lubricants, so the amount of time needed to pass through the orifice will vary with the different oils. The time unit is a convenient way to measure viscosity.

Oil Destruction Due to Exposure to Heat.—In discussing the influence of operating conditions on the durability and efficiency of lubricating oil, C. W. Stratford, M. E., of the Platt and Washburn Refining Company, who has made extended service and laboratory tests to determine the behavior of lubricants, can be quoted as an authority on this essential subject:

"The operating temperature of motor parts chart (Fig. 424) shows that motor oils are exposed continuously to much higher temperatures in an internal combustion engine than they are in the usual run of laboratory heat tests. Especially is this true within the explosion chambers, upon the upper surfaces of the cylinder walls and upon the lower surfaces of the piston heads. Below the piston heads, though the heat conditions there are somewhat less severe than above, chemical reactions within the oil are just as inevitable and continuous. No lubricating oil exists that will not undergo a chemical and, naturally, a physical change when exposed to the high temperatures on both sides of the pistons of automobile motors. In other words, there is no motor oil known that will not deposit sediment in the crank case. A very marked difference does, however, exist in the rate of sedimentation of oils of good and of poor quality, used in the same motor under the same operating conditions. It seems logical to conclude, therefore, that the rate of sedimentation must be a dependable measure of durability and efficiency.

"For the purpose of the following tests, let us assume that two

yellow oils of the same viscosity, say, between 200 and 300 seconds Saybolt at 100° Fahrenheit, be used. When a motor is run on the test stand or in a car for a few hours with a filtered oil of the highest quality and a sample taken for examination, it will be seen that the oil has changed from its original yellow to a grayish-blue by reflected light. After running several days it will be found that the oil has turned entirely black and become opaque. A sample drained from the motor into a long narrow tube and allowed to stand twenty-four hours will show a black sediment at the bottom. The oil floating above the sediment is red in color by transmitted light and is equally

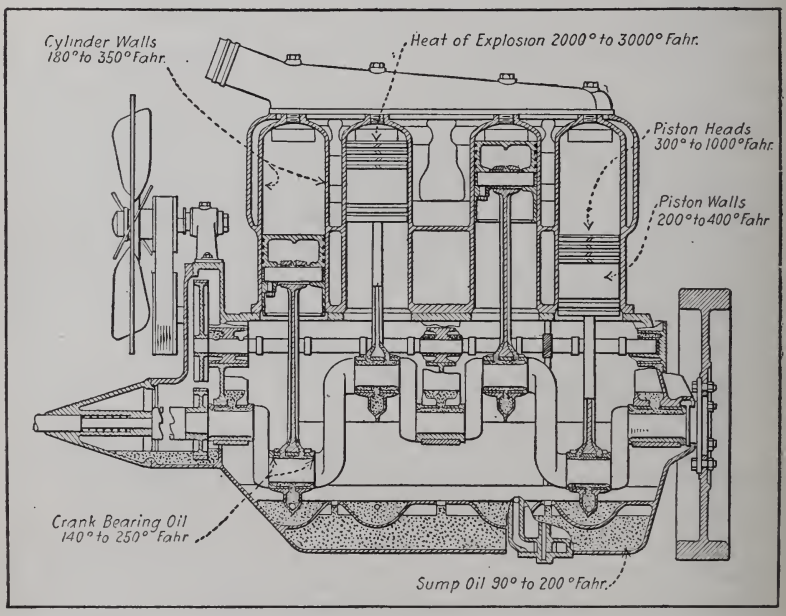


Fig. 424.—Sectional View of Four-Cylinder Motor, Showing the Temperature Attained by Various Engine Parts and Heat Imparted to the Lubricating Oil.

as serviceable as when fresh. The volume of this sediment depends upon the operating temperatures of motor parts with which it has come in contact, particularly the temperature of the piston heads, upon the presence or absence of mechanical defects (leaks) in the motor, and upon the quality, *i. e.*, degree of purity and stability of the oil used.

"Let a poor oil be run in the same motor under like conditions of time and temperature and samples examined. At the end of a few minutes the oil will turn to a dense and lustrous black. After

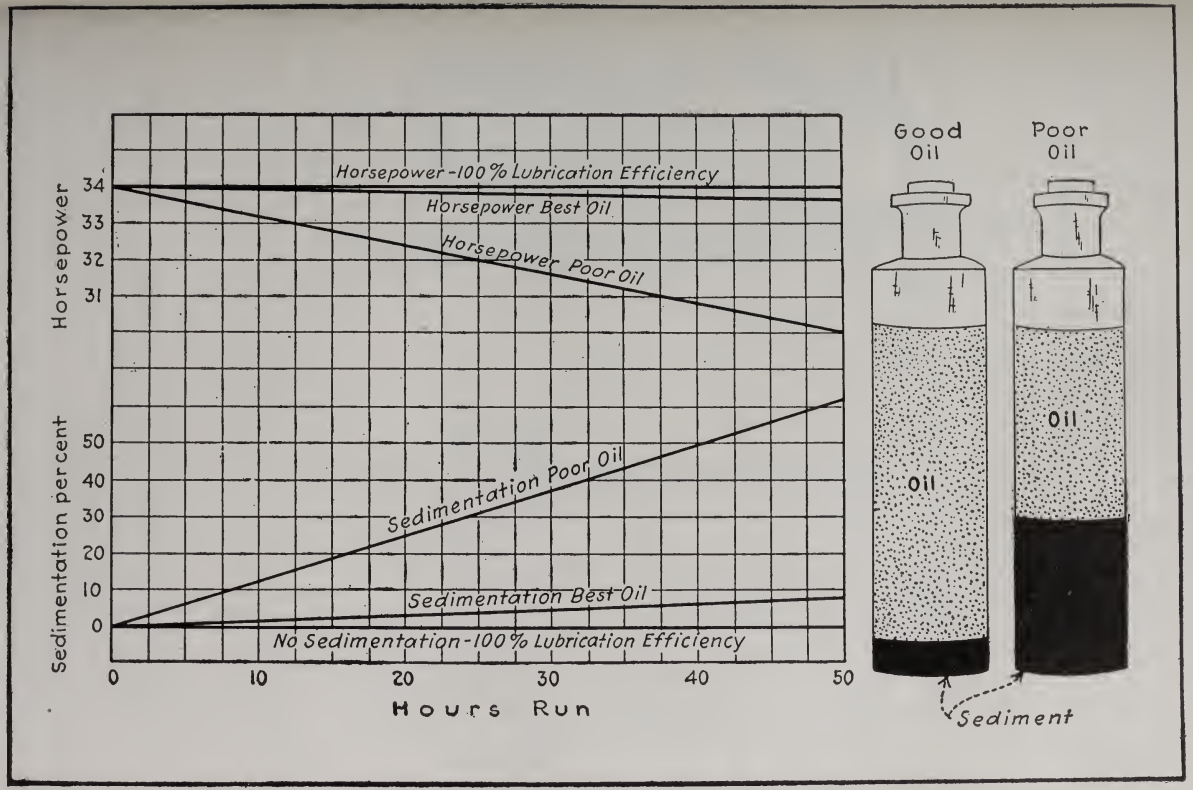


Fig. 425.—Graphic Illustration of Difference in Power with Good and Poor Lubrication Oil and Difference in Sediment Deposit.

standing twenty-four hours the sample used several days will show a voluminous black sediment, several times greater than that of good oil. In the interpretation of these results, let us assume the most favorable case for the poor oil—that the portion remaining above the sediment is still usable, though more often it is not. The good oil is still vastly more durable and economical than the poor. (Fig. 425.) Chemically, this low resistance to heat shown by poor oils is again traceable to the nefarious and destructive effect of 'sulpho' compounds present. It may also be caused by the presence of unstable compounds which decompose easily or the absorption of oxygen by the oil. Regarding the probable effect which the presence of 'sulpho' compounds might have upon the bearings and other parts within the motor, when decomposed by heat into free sulphuric acid, it may be expected that corrosive action would be almost negligible. The effect of hot sulphuric acid gas upon highly heated exhaust valves and seats is very noticeable, however, causing rapid pitting of the surfaces and leakage."

Devices for Supplying Lubricant.—The method of supplying the lubricant will depend largely upon the nature of the part to be oiled as well as the character of the oily medium. The various parts of the internal combustion engine demand continued lubrication and means must be provided which will insure positive supply of lubricant in measured quantities for more or less extended periods. Engine lubricators should be positive in action and not liable to be affected by varying weather conditions. The lubricant should not be supplied in excess and in some early systems it was desirable that the feeds be adjusted as desired and independently of each other.

Any oiling device should be as nearly automatic in action as possible and the modern types require but little further attention from the motorist than to keep a proper amount of lubricant in the container. The oil feed to the moving parts should start as soon as the engine begins to turn and the supply should be interrupted only when the mechanism stops. The only system which combines all the desirable features is that which includes a mechanical drive from the source of power. Lubricators may be divided into two classes, those which depend upon natural phenomena such as the attraction of gravity or displacement by air pressure, and others which are worked by mechanical means and which deliver the oil in measured quantities by positively driven pumps. The former class is now nearly obsolete.

Sight-Feed Oil Cups.—The simplest form of lubricating appliance is that in which oil is carried in a tank or oil cup placed higher than the points to which it is applied and then delivered to the bearing

points in drops. A simple form of sight-feed gravity oiler is shown at Fig. 426, A. This device has a glass body so that the amount of oil at the disposal of the motorist may be instantly noted and two sight-feed gauges at the bottom which are connected to the points needing lubricant. The opening through which the oil drips is regulated by an adjustable knurled screw, which turns a needle controlling

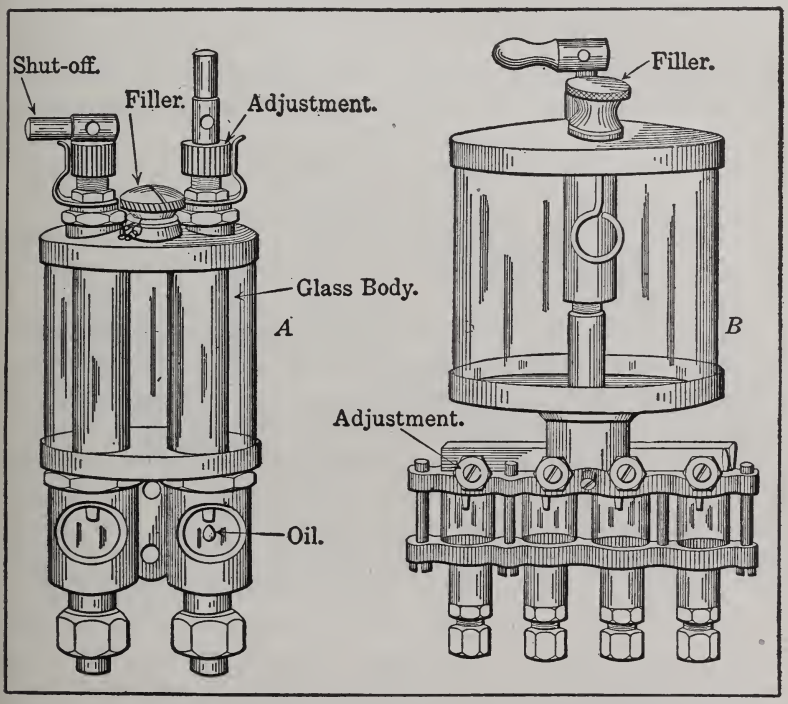


Fig. 426.—Simple Gravity Feed Oil Cups with Glass Body to Show Height of Lubricant in Container and Sight Gauges to Give Visible Evidence of Amount of Oil Supplied.

the supply orifice. In connection with the adjustable feature a simple lever is usually provided by which the needle may be raised from its seat and the oil allowed to flow into the siglrt-feed glass.

In the device shown at A the shut-off lever, which is horizontally placed, allows the needle to seat against the opening in the bottom of the lubricator and the flow of oil is stopped. When placed vertically, as shown at the right, the needle is raised from its seat and the oil may flow to the part with which the sight-feed glass is coupled. When more than two feeds are desired, the oil from the main con-

tainer may drip into a manifold fitting which will have any desired number of sight-feed glasses and their individual connections. A gravity oiler having four sight-feed glasses is depicted at Fig. 426, B.

Gravity-Feed Systems.—A disadvantage of oilers which depend upon gravity is that great care must be exercised in selecting lubricant which will have the proper viscosity or body to flow under the specific conditions of operation which may obtain at different times. For instance, during warm weather oil will flow readily and heavier bodied lubricants may be used without danger of clogging the supply pipe or the opening in the body of the oiler. When the weather becomes colder the oil may congeal and lighter fluid must be supplied to maintain an uninterrupted feed. Should the oil leads to the bearing become clogged by a particle of foreign matter the oil feed will be interrupted because the weight of the oil is not sufficient to dislodge the particle which hinders its flow. The result is that no oil reaches the bearing point and the part which needs the lubricant will be deprived of oil and cause trouble.

With devices of this form it is necessary to frequently manipulate the adjustments. Every atmospheric change that causes a difference of temperature must be reckoned with, and if the oiler is adjusted during cold weather it will feed too fast when the temperature is higher. If the supply of oil is regulated during warm weather when the oil flows easily, as soon as the lubricant congeals it will not pass through the supply pipes so readily and the opening must be increased in area to compensate for the greater viscosity of the lubricant. The gravity oiler is seldom used in modern automobiles and is only found on cars of early vintage which are still in use in large numbers in some parts of the country. It is utilized to some extent in marine applications where it can be mounted very close to the engine and kept at a uniform temperature by the heat given off from the power plant.

Mechanical Oiling Methods Described.—The oiling systems of the late forms of motor cars depend upon some positive oil pump to maintain circulation of the lubricant or to force it to the bearing point. Two forms of pumps are shown in section at Fig. 427. That at A is a simple plunger pump in which the plunger is operated by means of a cam driven by worm gearing from some suitable point on the power plant. When the pump plunger is drawn out toward the end of the cylinder the suction lifts the inlet check valve, which is a small steel ball, from its seat and the pump cylinder fills with oil. On the downstroke of the pump plunger the outlet check valve is unseated by the oil pressure and the lubricant is expelled from the pump cylinder to

the bearing point in a positive manner and under some degree of pressure. The stroke of the pump plunger may be varied by a suitable adjustment and the quantity of oil directed to the bearing point will depend upon the stroke of the pump plunger. Most forms of the device described use a multiplicity of pumps and individual leads to the different bearing points. The arrangement, which is now nearly obsolete in automobile practice, is such that each bearing is served by its own pump member. It is still used in marine and stationary applications, however.

In other systems a single pump of large capacity is used, as shown at the top of Fig. 428, this supplying oil to a manifold fitting from

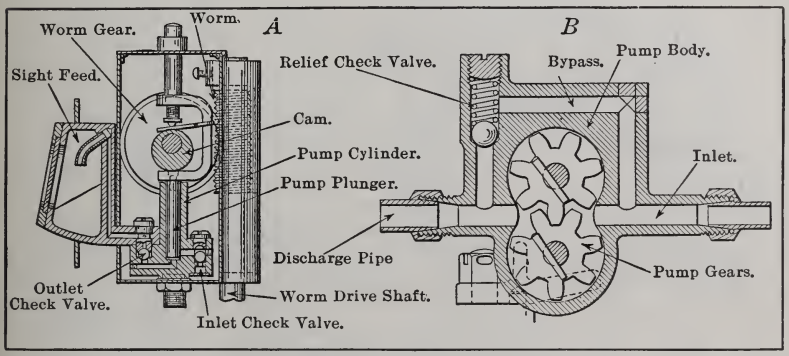


Fig. 427.—Positive Mechanical Methods of Supplying Lubricant. A—Worm-Gear Driven Plunger Pump Oiler. B—Gear Pump with High Pressure Relief Valve.

which it is distributed to the cylinders or to the engine base, from which it is picked up and splashed about by fingers on the bottom of the connecting rods. Another form of pump which is used more in maintaining circulation of oil in systems where distribution is by connecting rods than in individual supply systems is shown at Fig. 427, B. One of a pair of gears is driven by the engine and turns the other one so that the oil which fills the pump body is entrapped in spaces between the teeth of the gears and forced along through the discharge pipe. The form of pump shown has a ball check valve which seats against an opening which communicates with the discharge pipe. Should there be a great increase in engine speed which will result in excessive pressure the relief valve will unseat and the pressure will be diminished by a quantity of the oil flowing back into the inlet end through the by-pass passage.

Oil Distribution.—Two methods of distributing oil in the interior of internal combustion engines are outlined at Fig. 429. That at A consists in providing an oil pick-up finger or splasher at the bottom

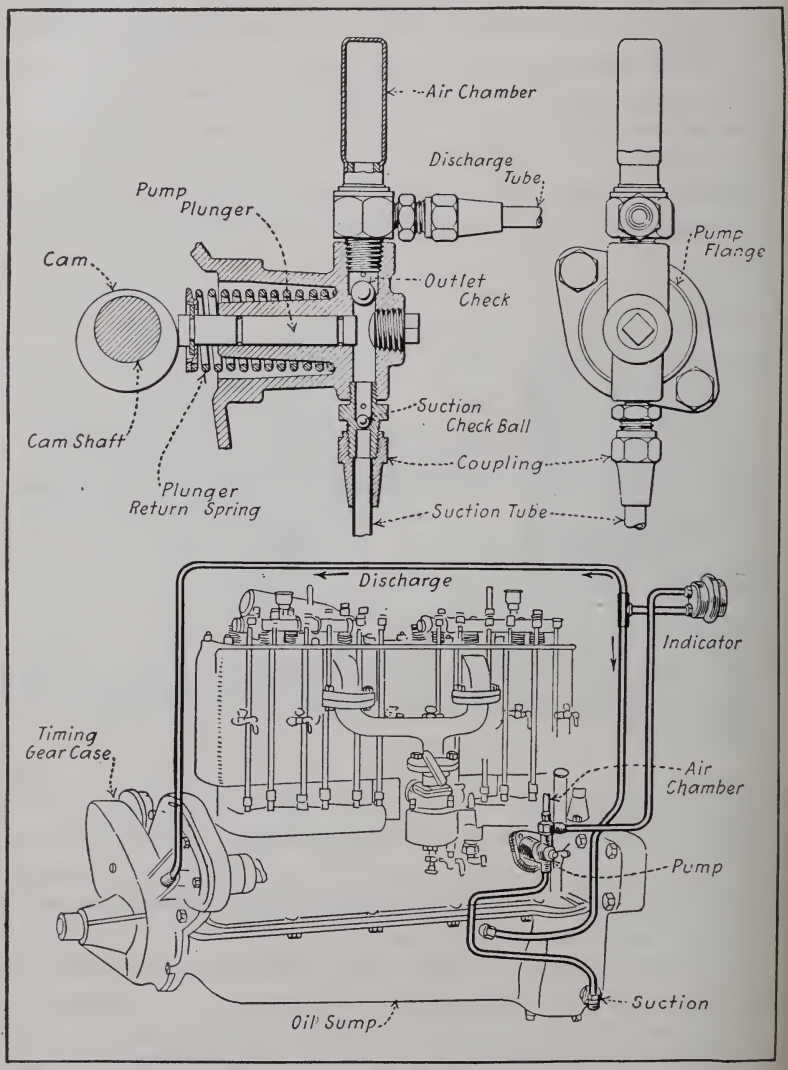


Fig. 428.—Pump Used in Pressure Feed Lubrication System of Grant Six-Cylinder Engine.

of the connecting rod big end, which dips into the lubricant carried in an oil trough directly under the connecting rod. As the crankshaft re-

volves in the direction of the arrow, a certain amount of lubricant will be picked up from the trough, and as the speed increases the rapid movement of the pick-up finger through the oil will splash it around the interior of the motor base. The form of oil trough shown is that used on the Knight engines and it is supported at one end on a bearing rod which is interconnected with the throttle so that as the gas supply is opened up to accelerate the engine, the oil trough is tilted in such a way that the proper quantity of lubricant will be supplied the cylinder, the oil "pick-up" dipping deeper into the oil as the speed is augmented.

A simple method which is applicable on engines having horizontally disposed cylinders is outlined at Fig. 429, B. In this the oil is

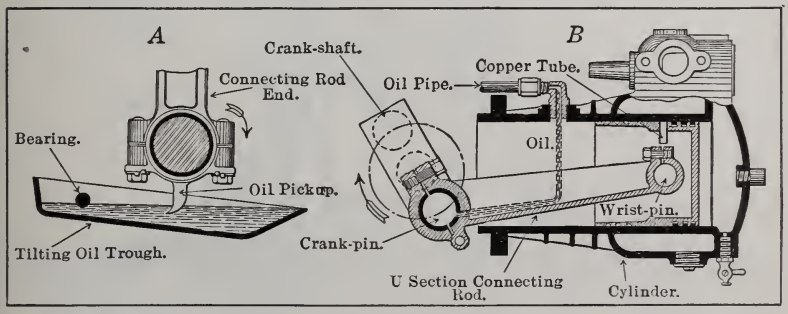


Fig. 429.—How Oil May Be Supplied to Interior Mechanism of Internal Combustion Motor. A—Oil Pick-up Finger on Connecting Rod End. B—Oil Drops into Channel in Horizontal Connecting Rod.

applied to a point about midway in the cylinder and in such a position that it is swept by the piston on its up or down stroke. When in the position shown in the drawing the piston is traveling toward the open end of the cylinder, and until the oil hole is shut off by the wall of the piston the lubricant will drip directly into the bottom of a U section connecting rod. When the rod is at the angle shown the oil will flow to the crank-pin bearings. When the piston reaches a point in the cylinder so that the copper tube carried by it registers with the oil opening the stream of lubricant will pass through the copper tube and onto the wrist pin. The cylinder wall and other points which need oiling are kept covered with a film of oil derived from the spray or mist composed of finely divided particles of oil which is present in the crank case all times the engine is in operation.

Oil Supply by Constant Level Splash System.—The splash system of lubrication that depends on the connecting rod to distribute the

lubricant is one of the most successful and simplest forms if some means of maintaining a constant level is provided. If too much oil is supplied the surplus will work past the piston rings and into the combustion chamber, where it will burn and cause carbon deposits.

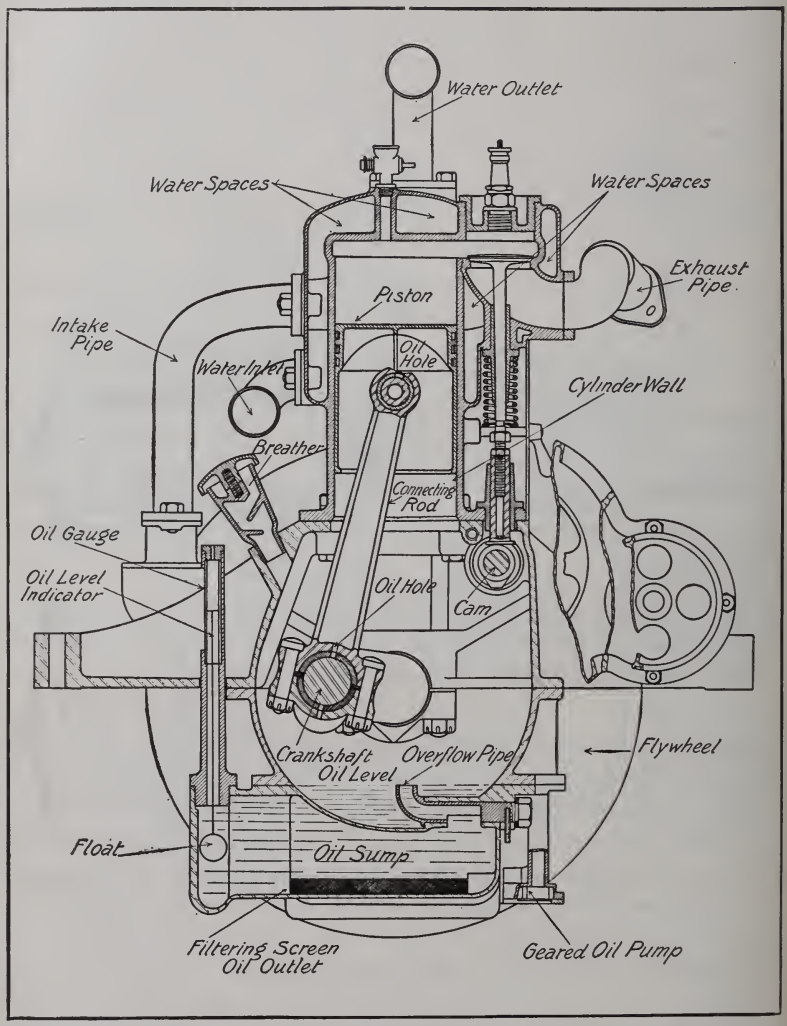


Fig. 430.—Sectional View of Typical Motor, Showing Parts Needing Lubrication and Method of Applying Oil by Constant Level Splash System.

Too much oil will also cause an engine to smoke and an excess of lubricating oil is usually manifested by a bluish-white smoke issuing from the exhaust.

A good method of maintaining a constant level of oil for the successful application of the splash system is shown at Fig. 430. The engine base casting includes a separate chamber which serves as an oil container and which is below the level of oil in the crank case. The lubricant is drawn from the sump or oil container by means of a positive oil pump which discharges directly into the engine case. The level is maintained by an overflow pipe which allows all excess lubricant to flow back into the oil container at the bottom of the cylinder. Before passing into the pump again the oil is strained or filtered by a screen of wire gauze and all foreign matter removed. Owing to the rapid circulation of the oil it may be used over and over again for quite a period of time. The oil is introduced directly into the crank case by a breather pipe and the level is indicated by a rod carried by a float which rises when the container is replenished and falls when the available supply diminishes.

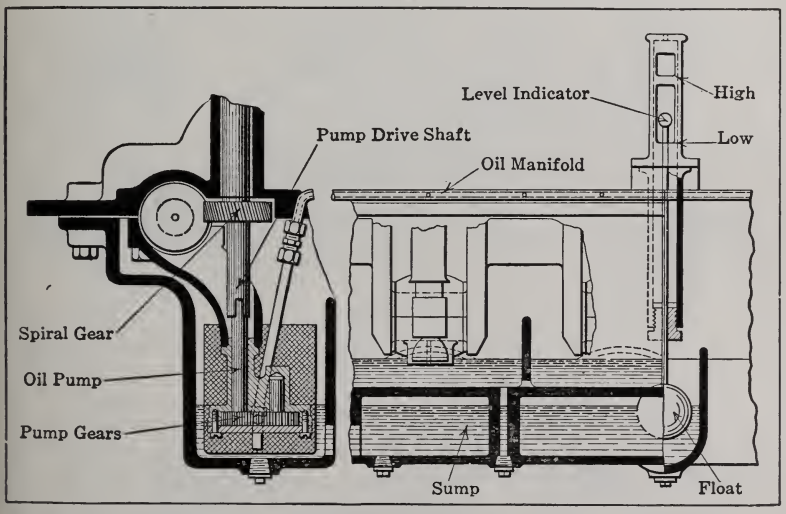


Fig. 431.—Sectional View of Part of Rutenber Engine, Depicting Method of Driving Oil Pump and Distribution of Oil to Bearing Points.

The system depicted at Fig. 431 is very similar to that previously described, except that the oil feed from the pump is first directed into an oil manifold pipe from which leads connect to the various main bearings of the engine. The oil dripping from these journals collects in the crank case until it reaches a certain level and then drains back into the sump or oil container through suitable overflow openings. The ends of the connecting rods are provided with scoops or oil pick-up members which splash the lubricant around the interior

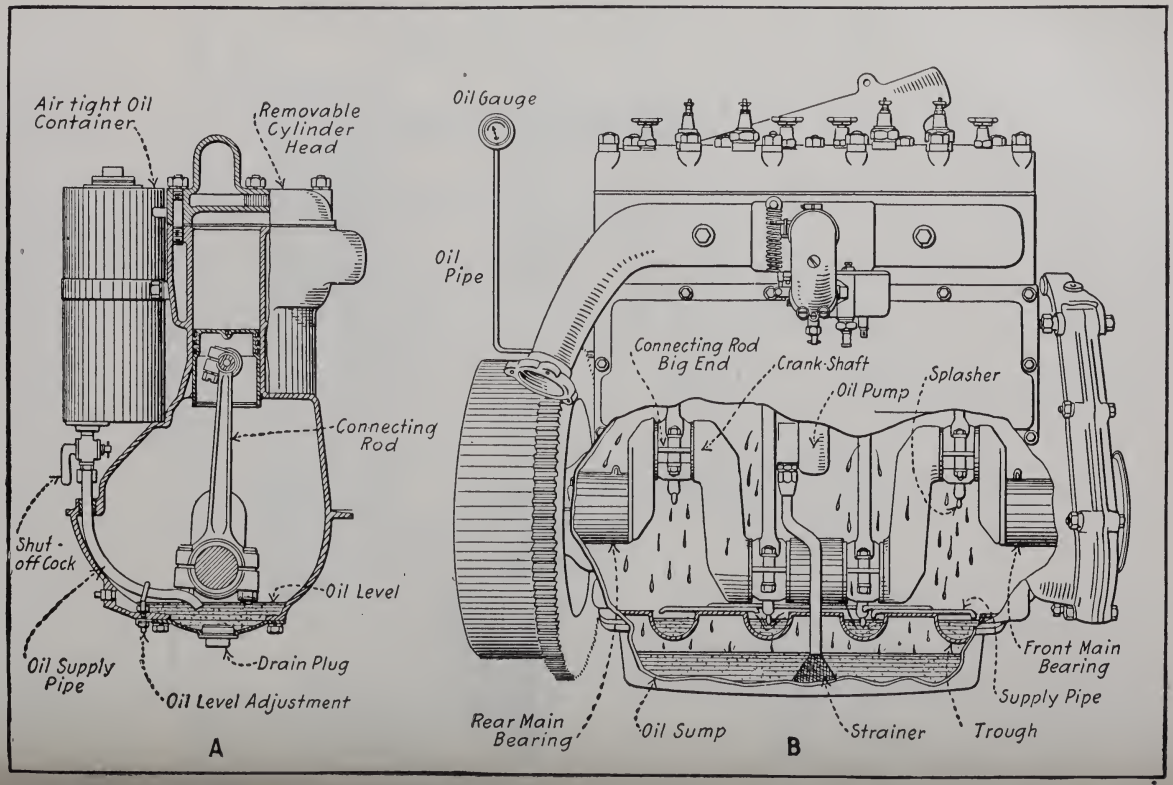


Fig. 432.—Simple Constant Level Splash System. A—Saxon Vacuum Feed. B—Overland Pump System.

of the engine. The amount of oil available is shown by a float controlled indicator, as in the previously described system. The pump is driven from the cam shaft by means of a pair of spiral gears. In the system shown at Fig. 432, B, the manifold directs the oil directly to the oil troughs, the main bearings depending on oil splashed by the rod big ends.

It will be noted that with such system the only apparatus required besides the oil tank which is cast integral with the bottom of the crank case is a suitable pump to maintain circulation of oil. This member is always positively driven, either by means of chains and sprockets, shaft and universal coupling, or direct gearing. As the pump is used to circulate oil but little wear will result during the life

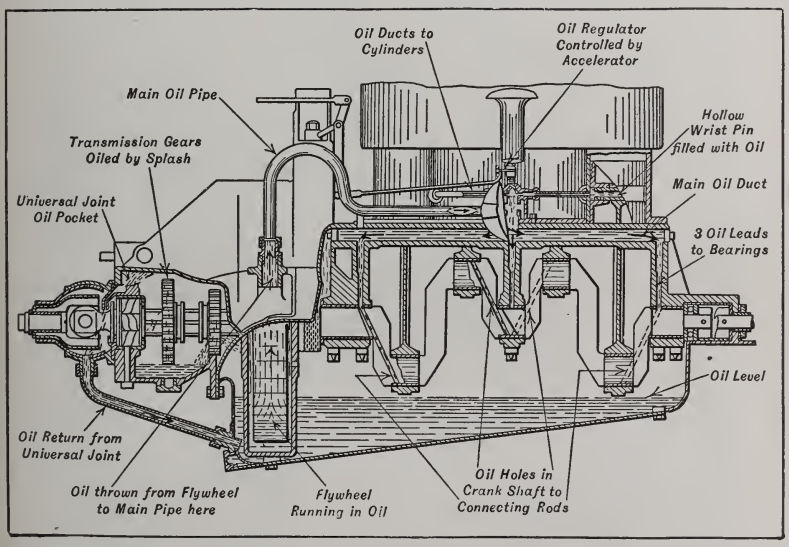

Oil Ducts to Cylinders
Oil Regulator Controlled by Accelerator
Main Oil Pipe
Hollow Wrist Pin filled with Oil
Transmission Gears Oiled by Splash
Main Oil Duct
Universal Joint Oil Pocket
3 Oil Leads to Bearings
Oil Level
Oil Return from Universal Joint
Oil thrown from Flywheel to Main Pipe here
Flywheel Running in Oil
Oil Holes in Crank Shaft to Connecting Rods

Fig. 433.—Oil Supply System of Hupmobile Motor Depends on Flywheel to Circulate Lubricant.

of the engine because all parts of the pump mechanism are operating in a constant bath of lubricant. The screens or filters are usually installed at points which will permit them to be easily removed when cleaning is necessary.

The self-contained oiling systems of the constant level type greatly simplify the power plant and insure the economical use of lubricant. The proper level of oil is regulated at the factory by the position of the overflow pipes and it must remain in adjustment because there is no way of altering it on most motors. As the lubricating oil is carried in the bottom of the engine case it is heated up as soon as the

engine has been in operation for a few moments, and as the viscosity of the lubricant cannot be altered by varying conditions of temperature or climate the same grade of oil may be employed during the entire year. Other advantages are that the lubricating system is entirely automatic in action, that it will furnish a positive supply of oil at all desired points, and that it cannot be tampered with by the inexpert motorist because no adjustments are provided or needed. While the pump is the commonly used oil supply medium, the Saxon system, shown at Fig. 432, A, maintains a constant level by an air-lock system. The oil is carried in an air-tight container and the supply pipe is set so that when the oil level becomes too low, air is admit-

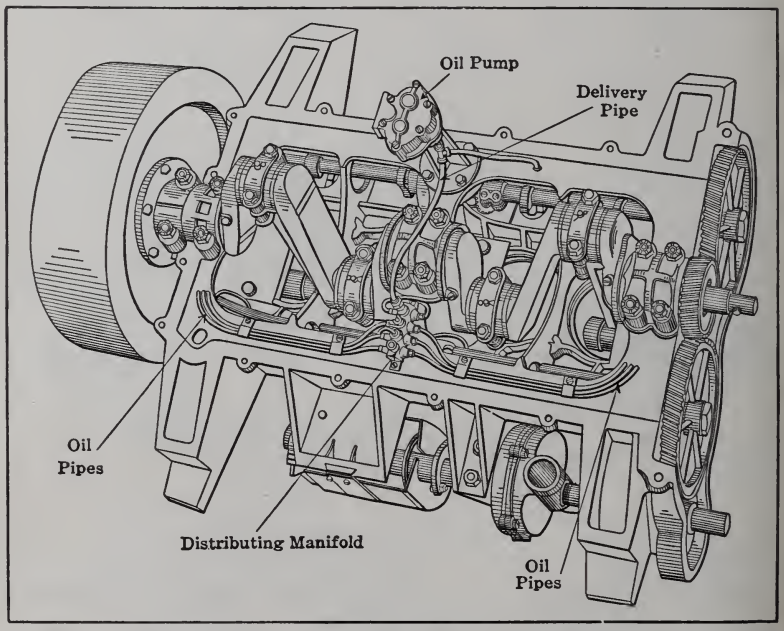


Fig. 434.—Oil Distribution System with Pump Feed to Manifold and Individual Leads to Bearing Points.

ted, because the end of the pipe is uncovered, and this allows oil to flow into the engine base until it covers the end of the supply pipe again. Whenever the container is filled, it is necessary to close the shut-off valve to prevent the oiling from running into the engine base as it is poured into the tank. This valve must be opened as soon as the tank cover is in place. The Hupmobile system, shown at Fig. 433, utilizes the flywheel to circulate the oil. The flywheel of the Ford Model T engine is also used for this purpose.

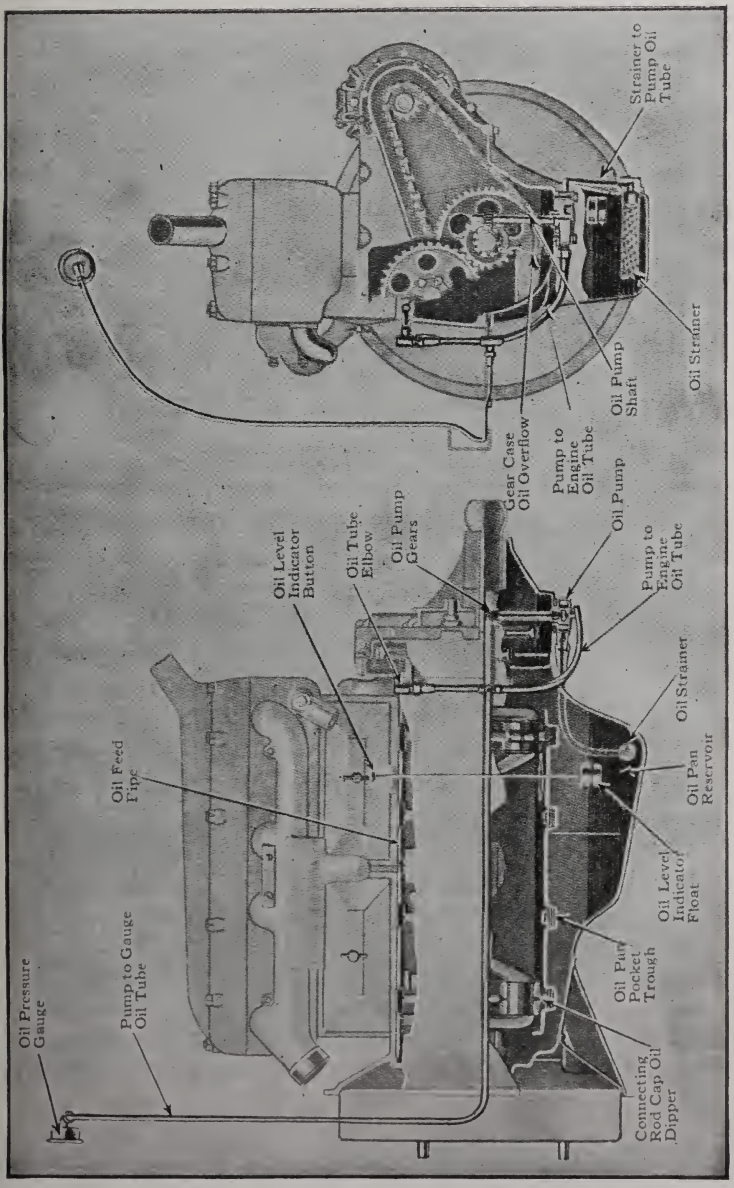


Fig. 435.—Oiling System of Dodge Bros. Engine.

The constant level system may be modified in a number of respects. Sometimes the oil is fed directly to the crank case compartment and the connecting rods depended upon solely to distribute the lubricant. In other systems, the oil delivered by the pump is conveyed to a distributing manifold, as shown at Fig. 434. From this manifold member the oil is delivered to important bearing points, such as the main journals, and directly to the cylinder walls by small copper pipes before it is allowed to drain back into the crank case and from this member overflow into the sump or container. In some systems no separate oil container is cast with the crank case, this member being made deeper so that the oil level will be below the point where the connecting rods will pass through it. When this practice is followed small troughs are provided in the engine base into which the scoops on the connecting rod dip, as shown at Fig. 435. This shows the Dodge lubricating system, and is a combination of the oil pressure and splash distribution methods.

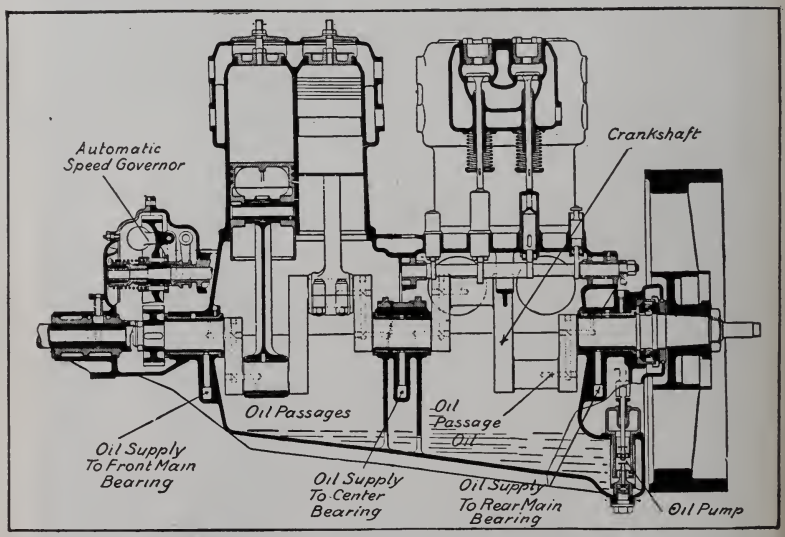


Fig. 436.—Method of Supplying Oil Under Pressure to Main Bearings, from which It is Directed to Connecting Rods by Passages Drilled in the Crankshaft.

Distributing Lubricant by Pressure.—In some power plants, especially constant duty types and V engines, it is considered desirable to supply the oil directly to the parts needing it by suitable leads instead of depending solely upon the distributing action of scoops on the connecting rod big ends. An early system of this nature is

shown at Fig. 436, while the more modern system used on the Packard twin-six engine is clearly shown at Figs. 437 and 438. The oil is carried in the crank case, as is common practice, but the normal oil level is below the point where it will be reached by the connecting

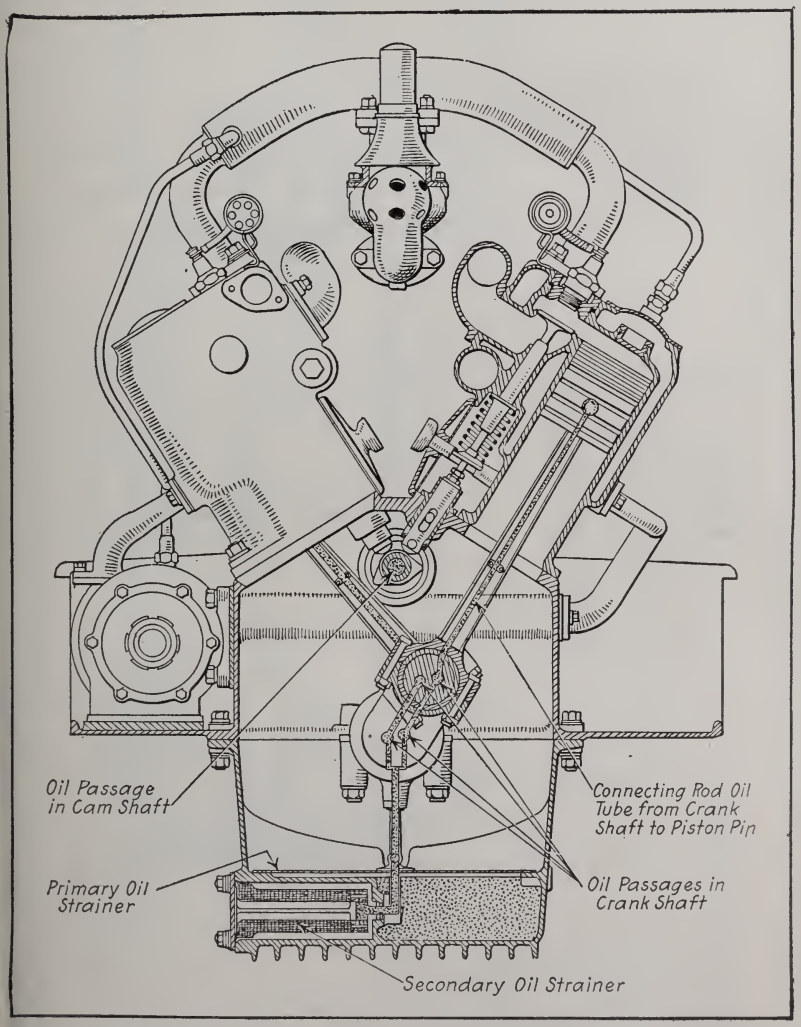

Oil Passage in Cam Shaft
Primary Oil Strainer
Connecting Rod Oil Tube from Crank Shaft to Piston Pin
Oil Passages in Crank Shaft
Secondary Oil Strainer

Fig. 437.—Part Sectional View of Packard Twin-Six Engine, Showing Passages for Oil Circulation in Engine Parts.

rod. It is drawn from the crank case by suitable pump, which directs it to a manifold leading directly to conductors, which supply the main journals. After the oil has been used on these points it drains back

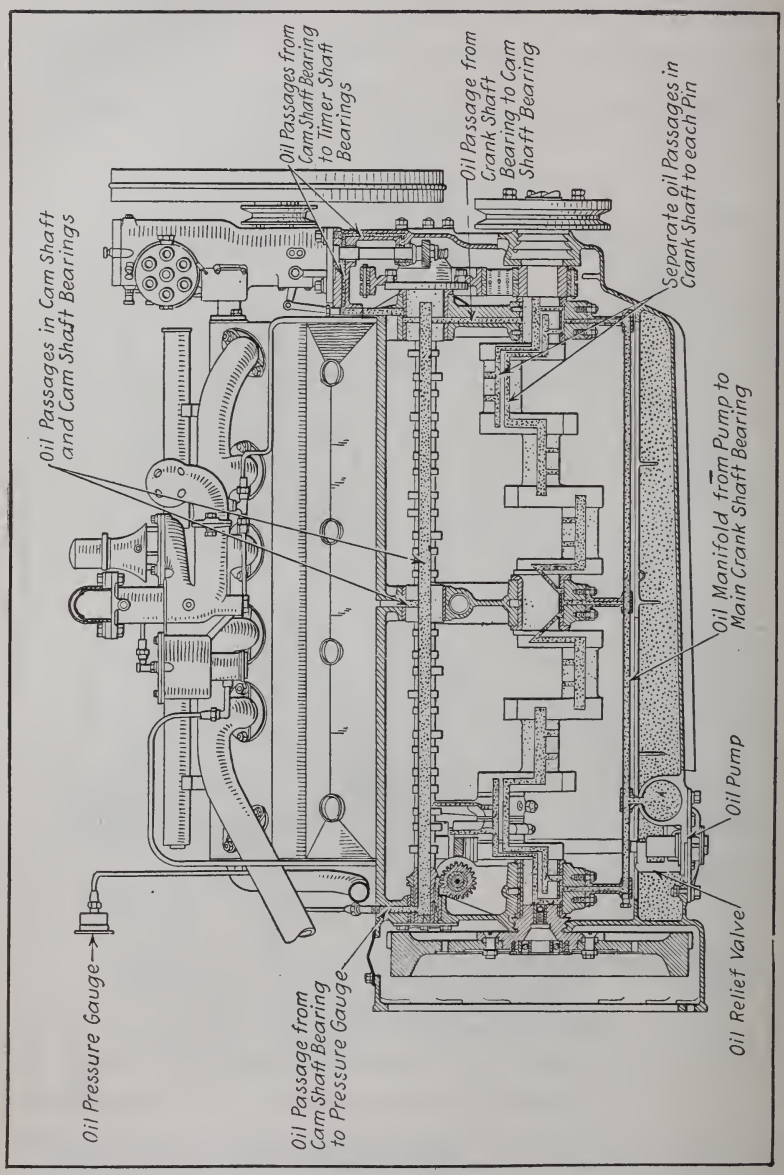

Oil Passages in Cam Shaft and Cam Shaft Bearings
Oil Passages from Cam Shaft Bearing to Timer Shaft Bearings
Oil Passage from Crank Shaft Bearing to Cam Shaft Bearing
Separate oil Passages in Crank Shaft to each Pin
Oil Manifold from Pump to Main Crank Shaft Bearing
Oil Pump
Oil Relief Valve
Oil Pressure Gauge
Oil Passage from Cam Shaft Bearing to Pressure Gauge

Fig. 438.—Longitudinal Sectional View of Packard Twin-Six Engine, Showing Path of Oil Through Crankshaft, Bearings and Camshaft.

into the bottom of the crank case. An excess is provided which is supplied to the connecting rod ends by passages drilled into the webs of the crank shaft and part way into the crank pins, as shown by the dotted lines in Fig. 436, and in the shaded portions of Figs. 437 and 438. The oil which is present at the connecting rod crank pins is thrown off by centrifugal force and lubricates the cylinder walls and other internal parts. Small cups are sometimes cast at the upper end of the connecting rods to collect oil, and suitable passages allow the lubricant to flow between the wrist pin and wrist-pin bushing.

Function of Oil Pressure Gauge.—If the indicator on the oil pressure gauge (Fig. 439, A), which is mounted on dash board in the

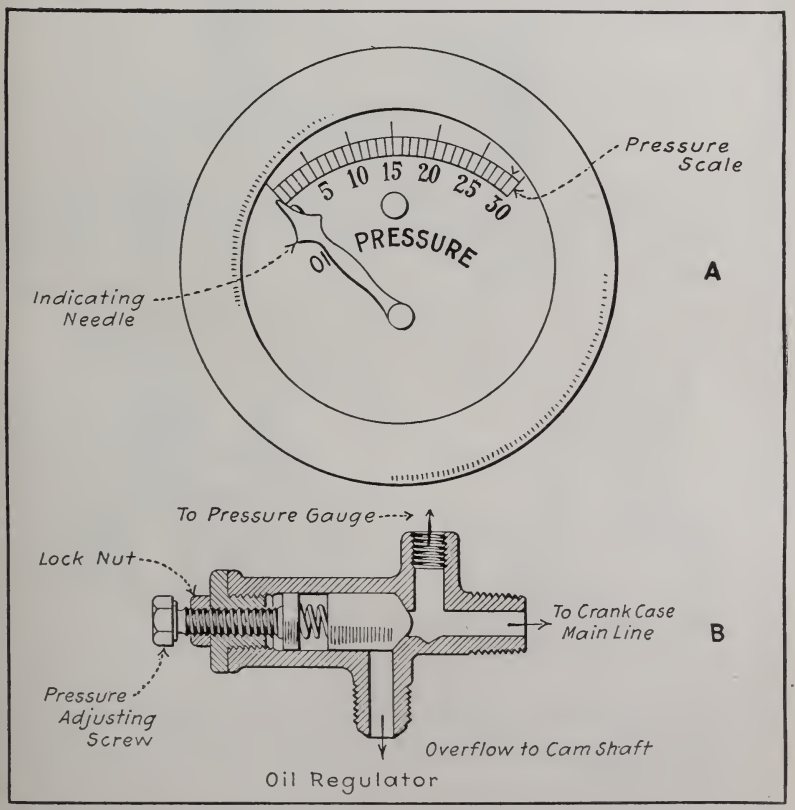


Fig. 439.—Pump and Oil Pressure Gauge Used in Pressure Feed Oiling System.

Cole Eight, vibrates or falls to zero when the engine is running, it indicates that the oil level is low or that for some other reason oil is not being forced to the bearings and other parts of the engine. In cold

weather it may be an indication that the cold test of the oil you are using is not sufficiently low and that the oil has congealed to a point where the pump cannot draw it from the oil pan. Do not under any consideration continue to run the engine if the hand on the oil pressure gauge vibrates or returns to zero or if it remains at zero after starting the engine.

The pressure of the oil is regulated by a valve under spring tension. The tension of the spring is adjustable. A section of this is

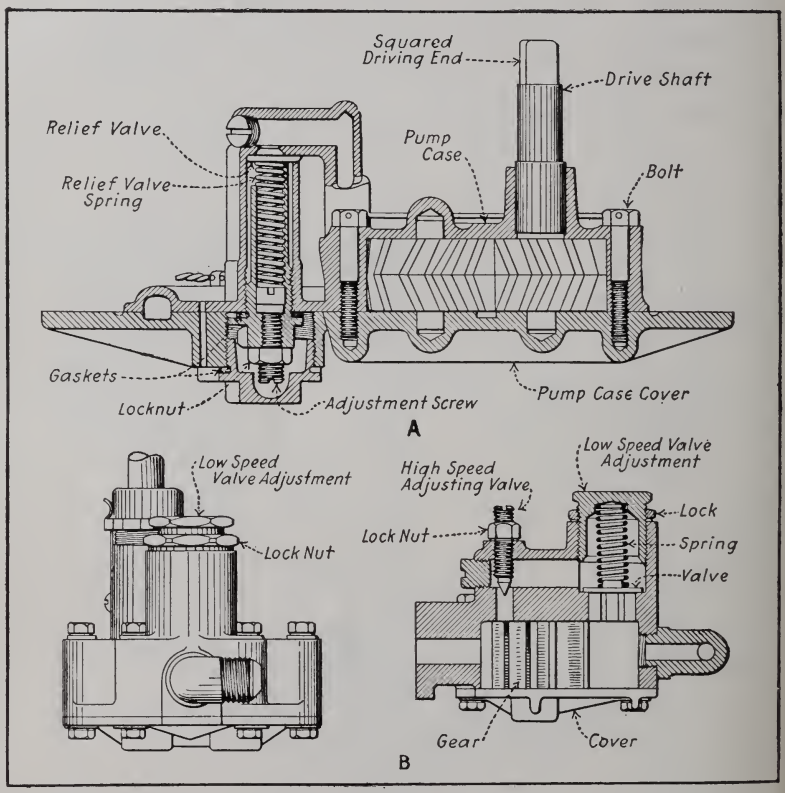


Fig. 440.—Typical Pressure Feed Oil Pumps of the Gear Type. A—Pump Used on Packard Twin-Six Engine. B—Pierce-Arrow Design. Note Relief By-pass Valves.

shown in Fig. 439, B. The housing containing the valve is located on the left-hand side of motor at the front end. A cap screw extends from the cap on the housing containing the valve. This cap screw is held from turning by a lock nut. To increase the oil pressure for any given engine speed, loosen the lock nut and screw in on the cap

screw—that is, turn it clockwise. To decrease the oil pressure for any given engine speed, loosen the lock nut and unscrew the cap screw. It is best to make this adjustment when the engine is running at high speed. Under these conditions the pressure should be between 15 and 20 pounds. Do not make the adjustment until the engine and oil are thoroughly warmed up. Be sure to properly tighten the lock nut after making the adjustment.

The oil relief valve of the Packard Twin Six oiling system is contained in the pump body, and is clearly shown at Fig. 440, A. It is controlled by the tension of a coil spring, which should be set to maintain a pressure of from 20 to 30 pounds with the motor warm and running at a speed of about 1,000 R. P. M., which is equivalent to a car speed of approximately 26 miles per hour. The relief valve inlet is connected with the pump discharge passage, and any excess pressure causes the valve to open and allows the oil to return to the inlet side of the pump body. To raise the oil pressure, remove the plug from the bottom of the pump housing, loosen the jam nut on the adjusting stud and increase the spring tension until the proper pressure is obtained. To lower the oil pressure the spring tension should be decreased. Make sure that the jam nut is screwed up tight before the plug is replaced.

Pierce-Arrow 1917 System.—The oiling system of the Pierce-Arrow six-cylinder engines is shown at Fig. 441, and is by the now generally accepted force-feed system. The pump draws oil up from the sump in the crankcase, forces it up through a horizontal pipe H and five branch pipes to the first, third, fifth and seventh crankshaft bushings and to the timing gear case E, and also to an oil gauge Q on the dash. The crankshaft journals and arms of the cranks are drilled through their centers and the crankshaft R is also provided with radial holes at the center of the journals, to provide a passage for the main flow of oil under pressure to all bearings of the crankshaft. Pipes P, running up the connecting rods O to the gudgeon pins, lubricate these in an effective manner. After performing its various functions, all the oil finds its way back through the well W in the lower half of the crankcase and is drawn through the strainer by the pump V. The pressure in the oiling system is shown by the oil gauge mounted on the dash. It should be from three to four pounds when the engine is throttled down to its lowest speed and thirty-five pounds when running at fifty miles per hour. When running at a speed of fifteen to twenty miles an hour on direct drive, gauge should show six to ten pounds. If less, give more oil or examine oil system. These pressures must be real and can only be

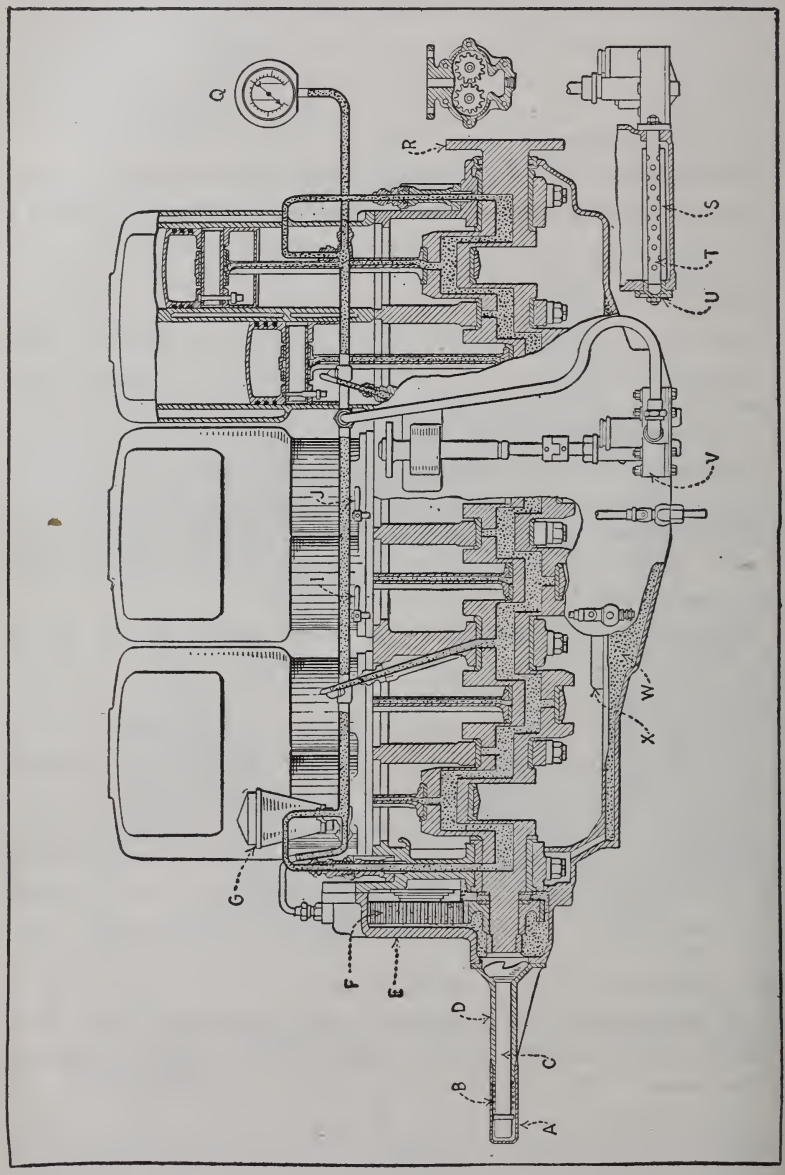


Fig. 441.—Part Sectional View of Pierce-Arrow Six-Cylinder Engine, Showing Pressure Feed Oiling System.

taken as correct when the oil and the engine are hot. When engine is cold, the pressure reading will be considerably higher. The oil pressure can be regulated by adjusting oil pump valves.

The adjustment of the oil pressure is altered by two regulating valves on the oil pump. The low speed pressure adjustment is obtained in the following manner. First, have the motor hot, then back off on the small high speed adjusting valve K, Fig. 440, B, which is found on the side of the pump next to the crank case, until this valve is entirely open. Then throttle the engine down to its lowest free running speed and adjust the low pressure by means of the outer regulating valve B (the large one). When adjustment has been effected, lock the locking nut C on this valve. To make the high speed adjustment, take the car out on the road and give the necessary adjustment to high speed valve K, by screwing down on same until when running at thirty-five miles per hour, the gauge reads 23 lbs.—38 and 48 H.P.; 18 lbs.—66 H.P. Then lock the locking nut J, on this adjustment. Adjustments should not be changed unless absolutely necessary, possibly after overhauling.

Oiling V Engines.—Pressure feed without splash is the accepted method of oiling the twin-four and twin-six engines recently developed. The reason for this is graphically shown in the illustrations at Fig. 442, that at A showing the distribution when splashers on the connecting rod big ends is depended on, while the oil supply by the approved system is shown at B.

Oil projection by the dippers on the connecting rod ends from constant level troughs is unequal upon the cylinder walls of the two cylinder blocks. This gives rise, on one side of the motor, to under-lubrication, and, on the other side, to over-lubrication. This applies to all modifications of splash lubricating systems. When a force feed lubricating system is used the oil, escaping past the cheeks of both ends of the crank pin bearings, is thrown off at a tangent to the crank pin circle in all directions supplying the cylinders on both sides with an equal quantity of oil.

Individual Pump Oilers.—Individual pump oilers are not so widely used at the present time as they have been in the past, but a number of designers of boat and stationary engines contend that these devices are superior to the simpler splash systems because only clean oil is delivered to the bearing points and in measured quantities. It is advanced that with splash systems the oil soon becomes impregnated with minute carbon particles which even the filter screens cannot remove and that it is not as suitable for lubricating purposes as the clean lubricant supplied from the mechanical oiler. In most

systems where a mechanical oiler is employed, the splash system is depended upon to a certain extent as well, so that it is not readily apparent how the disadvantage cited can be applied in favor of the individual pump method of supply.

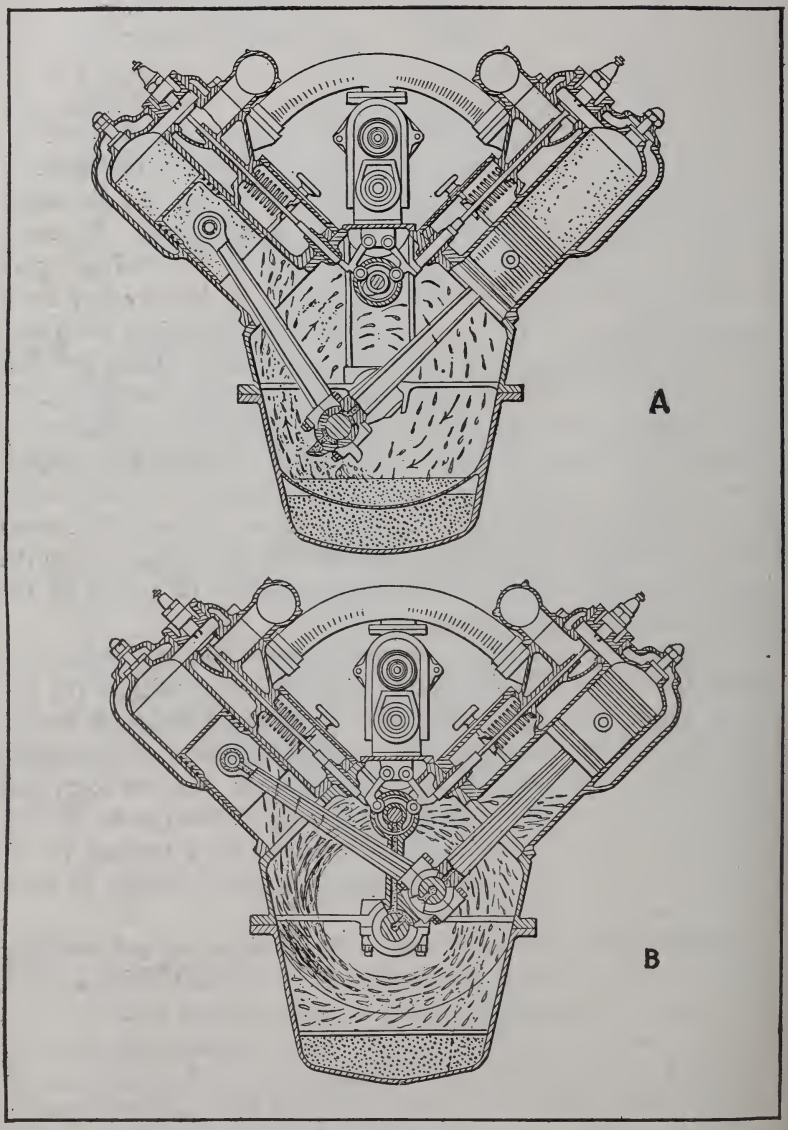


Fig. 442.—Views Detailing Advantages of Pressure Feed in Eight- and Twelve-Cylinder V Motors. A—Splash System Does Not Provide Even Distribution. B—Pressure Feed Lubricates Both Cylinders the Same Amount.

A typical system using a mechanical oiler is outlined at Fig. 443. In this one main pump supplies a manifold fitting carried on the dashboard from which the oil drips into sight gauges through needle-valve regulated orifices. A series of smaller individual pumps draw the oil from the sight-feed manifold and force it through pipes which communicate with the individual cylinders and with the front and rear crank case compartments respectively. Regulating screws are provided so that the amount of oil supplied the different points may

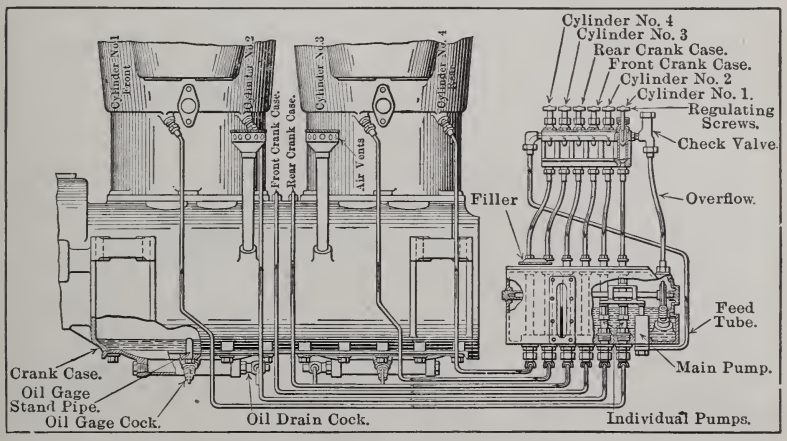


Fig. 443.—Showing Application of Mechanical Oiler Having Individual Pumps and Leads to Bearing Points in Connection with Sight Feed on Dash. An Old System, Practically Obsolete Now.

be regulated at will. A relief check valve is installed to take care of excess lubricant and to allow any oil that does not pass back into the individual pumps to overflow into the main container.

Lubrication Don'ts.—The following hints are furnished by the Platt and Washington Refining Company and can be read to advantage by all motorists.

Don't expect your lubricating oil to perform the impossible task of correcting mechanical defects. Too much clearance between the piston and cylinder, or bad and leaky piston rings, will surely fill the explosion chamber with carbon, even when the best lubricating oil is used.

Don't fill the sump or reservoir of your motor above its correct level and expect your motor not to smoke and not to carbonize the cylinders. Enough is sufficient—too much is useless waste and the cause of trouble.

Don't fill your motor by pouring oil into it through a dirty or sandy funnel. Sand and dirt do not lubricate, but they do destroy.

Don't use too light an oil under the impression that an oil must be very light in order to reach all parts. The temperature of your motor is so high that too light an oil will be so thinned out as to be of little use as a lubricant. For efficiency and economy use the heaviest oil permissible with your lubricating system. Even heavy oils run freely when exposed to the heat within the crank case.

Don't forget that an air-cooled motor requires heavier oil than a water-cooled motor, because of its higher operating temperature.

Don't think that oil never wears out. When you drain the old oil from the crank case always rinse it out thoroughly with kerosene before filling in the fresh oil. Be sure to close all drain cocks. A more responsive motor will be your reward.

Don't judge the viscosity (or body) of your oil at atmospheric temperature. Remember that when oil passes through the bearings it has a much higher temperature than the surrounding air.

Don't under-estimate the effect which poor carburetor adjustment has upon the carbon deposit. Carburetor flooding, and too rich mixture will cause a voluminous deposit of carbon in the form of lampblack. The absence of sufficient oxygen in a rich mixture renders impossible the complete oxidation or burning of both fuel mixture and oil vapors. As a consequence, carbon is deposited from the partially burned fuel, and, more rapidly, from the highly heated unburned oil.

Don't fail to see that your carburetor is adjusted, while the motor is hot, to the point where it flares back from leanness of mixture. When this point is ascertained, increase the fuel feed very slightly until popping ceases.

Don't drive your engine at high speed while the bearings are tight. Wait until you have made at least 500 to 1,000 miles and the bearings are properly run in. Over-lubricate, rather than under-lubricate, while your car is new and stiff.

Don't forget that *regularity* in supplying the right oil to your motor and other parts of the car is the surest means of securing unalloyed pleasure in driving, and freedom from annoyances on the road.

Don't lose sight of the fact that proper lubrication is by far the most important thing in the operation of any internal combustion engine. Three-fourths of all motor troubles arise from, and can be traced directly to, faulty lubrication.

Why Cooling Systems are Necessary.—The reader should understand from preceding chapters that the power of an internal combus-

tion motor is obtained by the rapid combustion and consequent expansion of some inflammable gas. The operation in brief is that when air or any other gas or vapor is heated, it will expand and that if this gas is confined in a space which will not permit expansion, pressure will be exerted against all sides of the containing chamber. The more a gas is heated, the more pressure it will exert upon the walls of the combustion chamber it confines. Pressure in a gas may be created by increasing its temperature and inversely heat may be created by pressure. When a gas is compressed its total volume is reduced and the temperature is augmented.

The efficiency of any form of heat engine is determined by the power obtained from a certain fuel consumption. A definite amount of energy will be liberated in the form of heat when a pound of any fuel is burned. The efficiency of any heat engine is proportional to the power developed from a definite quantity of fuel with the least loss of thermal units. If the greater proportion of the heat units derived by burning the explosive mixture could be utilized in doing useful work the efficiency of the gasoline engine would be greater than that of any other form of energizing power. There is a great loss of heat from various causes, among which can be cited the reduction of pressure through cooling the motor and the loss of heat through the exhaust valves when the burned gases are expelled from the cylinder.

The loss through the water jacket of the average automobile power plant is over 35% of the total fuel efficiency. This means that more than one-third of the heat units available for power are absorbed and dissipated by the cooling water. Another 35% is lost through the exhaust valves, and but 33⅓% of the heat units are available to overcome motor friction and do useful work. These losses have been previously shown in chart at Fig. 154. The great loss of heat through the cooling systems cannot be avoided, as some method must be provided to keep the temperature of the engine within proper bounds. It is apparent that the rapid combustion and continued series of explosions would soon heat the metal portions of the combustion chamber and valves to a red heat if some means were not taken to conduct much of this heat away. The high temperature of the parts would burn the lubricating oil, even that of the best quality, and the piston and rings would expand to such a degree, especially when deprived of oil, that they would seize in the cylinder. This would score the walls, and the friction which ensued would tend to bind the parts so tightly that the piston would stick, bearings would be burned out, the valves would warp, and the engine would soon become inoperative.

The best temperature to secure efficient operation is one on which considerable difference of opinion exists among engineers. The fact that the efficiency of an engine is dependent upon the ratio of heat converted into useful work compared to that generated by the explosion of the gas is an accepted fact. It is very important that the engine should not get too hot, and at the other hand it is equally vital that the cylinder be not robbed of too much heat. The object of cylinder cooling is to keep the temperature of the cylinder below the danger point but at the same time to have it as high as possible to secure maximum power from the gas burned.

Cooling Systems Generally Applied.—There are two general systems of engine cooling in common use, that in which water is heated by the absorption of heat from the engine and then cooled by air, and the other method, now rarely used except on motorcycle engines, in which the air is directed onto the cylinder and absorbs the heat directly instead of through the medium of water. When the liquid is employed in cooling it is circulated through jackets which surround the cylinder casting and the water may be kept in motion by two methods. The one generally favored is to use a positive circulating pump of some form which is driven by the engine to keep the water in motion. The other system is to utilize a natural principle that heated water is lighter than cold liquid and that it will tend to rise to the top of the cylinder when it becomes heated to the proper temperature and cooled water takes its place at the bottom of the water jacket.

Air-cooling methods may be by radiation or convection. In the former case the effective outer surface of the cylinder is increased by the addition of flanges or spines cast thereon, and the air is depended on to rise from the cylinder as heated and be replaced by cooler air. When a positive air draught is directed against the cylinders by means of a fan, cooling is by convection and radiation both. Sometimes the air draught may be directed against the cylinder walls by some form of jacket which confines it to the heated portions of the cylinder.

Cooling by Positive Water Circulation.—A typical modern water-cooling system in which a pump is depended upon to promote circulation of the cooling liquid is shown at Figs. 444 and 445, and the components of such a group are shown separately so the construction may be more easily understood at Fig. 446. The radiator is carried at the front end of the car in most cases and serves as a combined water tank and cooler. It is composed of an upper and lower portion joined together by a series of pipes which may be round and provided

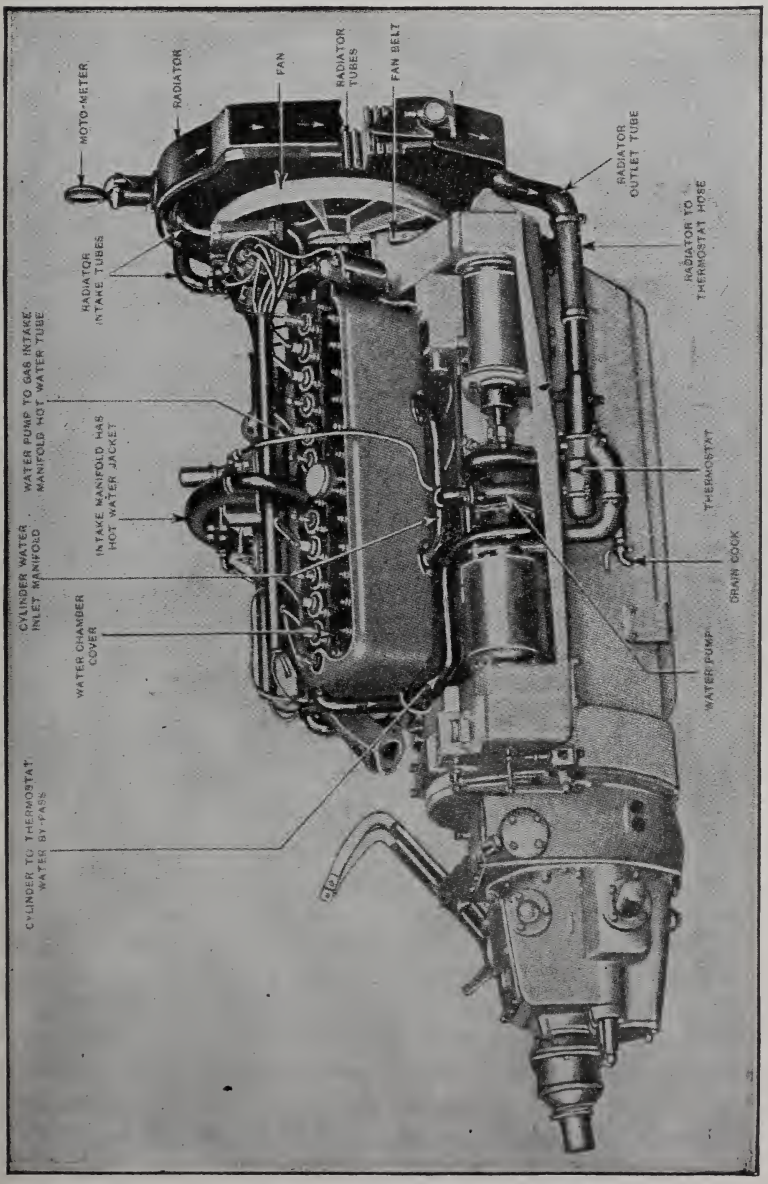


Fig. 444.—Outlining Water Circulation System of Packard Twin-Six Power Plant.

with a series of fins to radiate the heat, or which may be flat in order to have the water pass through in thin sheets and cool it more easily. Cellular or honeycomb coolers are composed of a large number of bent

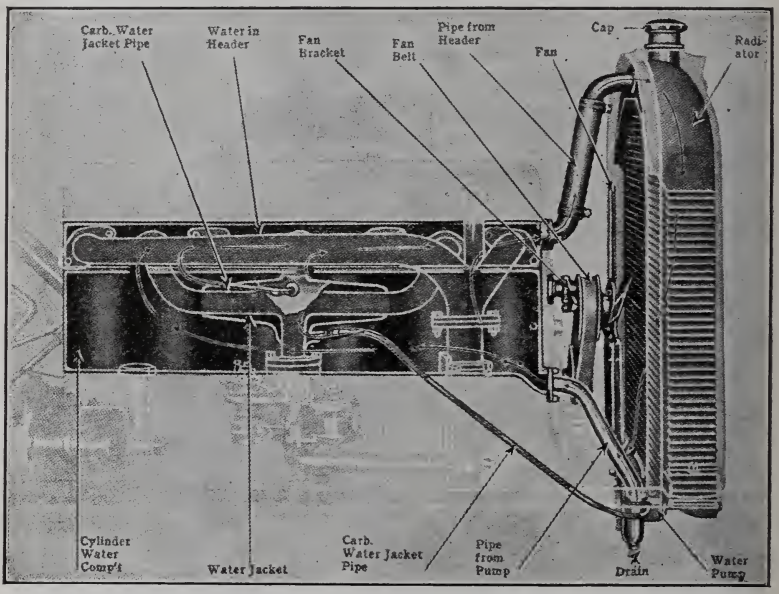


Fig. 445.—Showing Water-Cooling System of the Marmon Engine.

tubes which will expose a large area of surface to the cooling influence of the air draught forced through the radiator either by the forward movement of the vehicle or by some type of fan. The cellular and

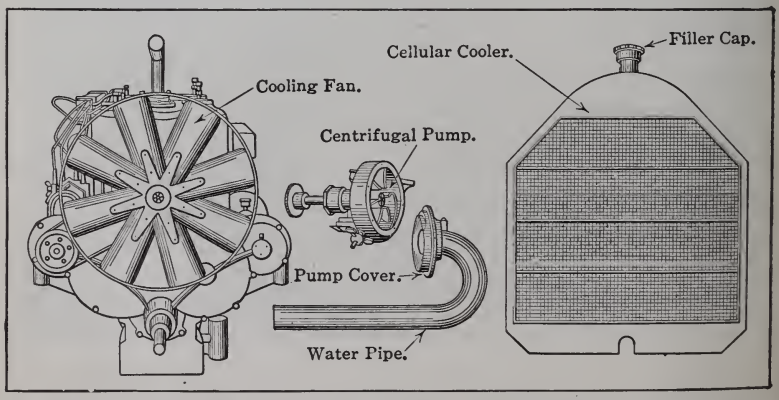


Fig. 446.—Elements of Typical Cooling Group, Defining Construction of Centrifugal Pump, Cooling Fan and Cellular Radiator.

flat tube types have almost entirely displaced the flange tube radiators which were formerly popular because they cool the water more effectively, and may be made lighter than the tubular radiator could be for engines of the same capacity. The various types of radiator tubes are shown at Fig. 447.

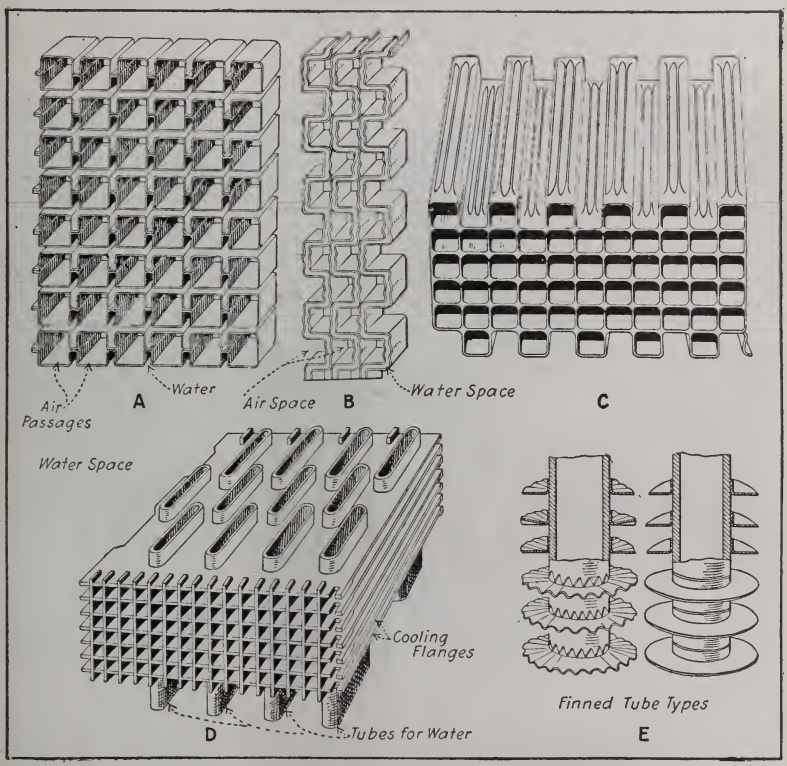


Fig. 447.—Various Types of Water-Cooling Tubes Used in Radiator Construction. A, B and C—Honeycomb Sections. D—Flat Tubes with Flanges. E—Finned Round-Tube Types Used in Truck Radiators.

Cooling Action of Radiator.—The water is drawn from the lower header of the radiator by the pump and is forced through a manifold to the lower portion of the water jackets of the cylinder. It becomes heated as it passes around the cylinder walls and combustion chambers and the hot water passes out of the top of the water jacket to the upper portion of the radiator. Here it is divided in thin streams and directed against comparatively cool metal which abstracts the heat from the water. As it becomes cooler it falls to the bottom of the radiator because its weight increases as the temperature becomes

lower. By the time it reaches the lower tank of the radiator it has been cooled sufficiently so that it may be again passed around the cylinders of the motor. In most cooling systems, especially those employing cellular type coolers, it is necessary to use a cooling fan to draw currents of air through the interstices of the cooler.

Water-Circulating Pumps.—The pumps used differ in design. The form shown at Fig. 448 and at Fig. 449, A, is known as the "cen-

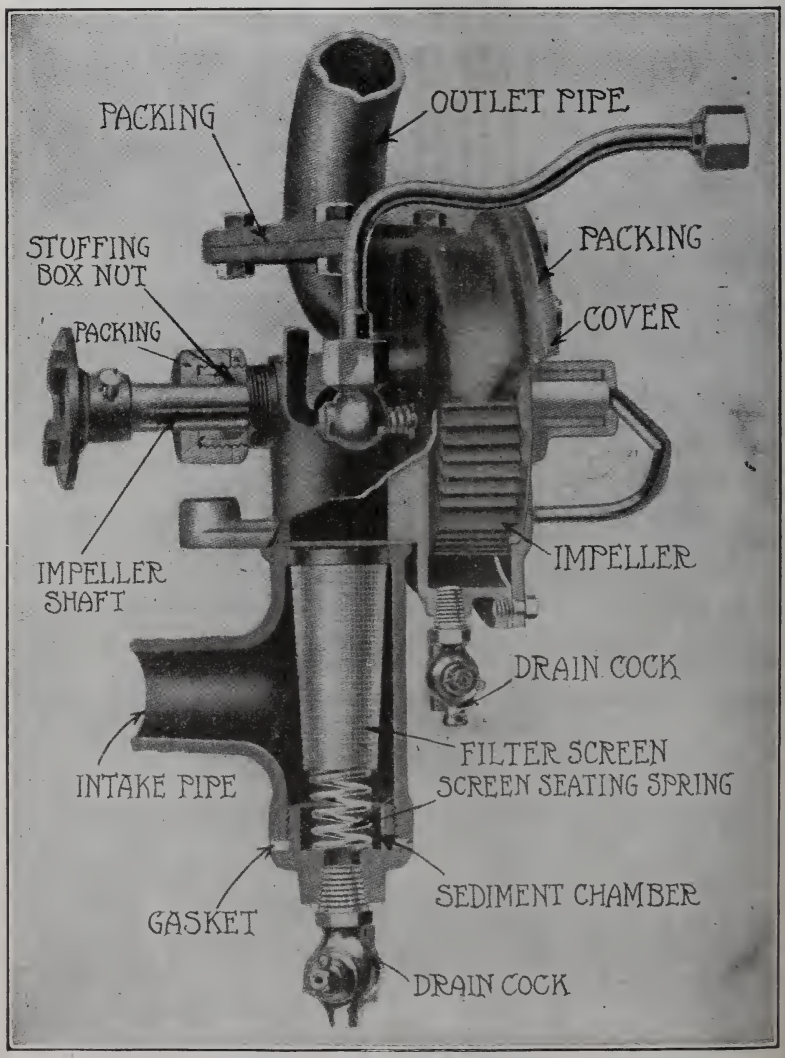


Fig. 448.—Part Sectional View of Packard Centrifugal Water Pump.

trifugal type" because a rotary impeller of paddle-wheel form throws water which it receives at a central point toward the outside and thus causes it to maintain a definite rate of circulation. The pump may be a separate appliance, as shown at Figs. 444 and 446, or it may be incorporated in part of the water jacket, as depicted at Fig. 449, A, or as part of the engine, as in the system shown at Fig. 445. The centrifugal pump is not as positive as the gear form shown at Fig. 449, B, and some manufacturers prefer the latter because of the

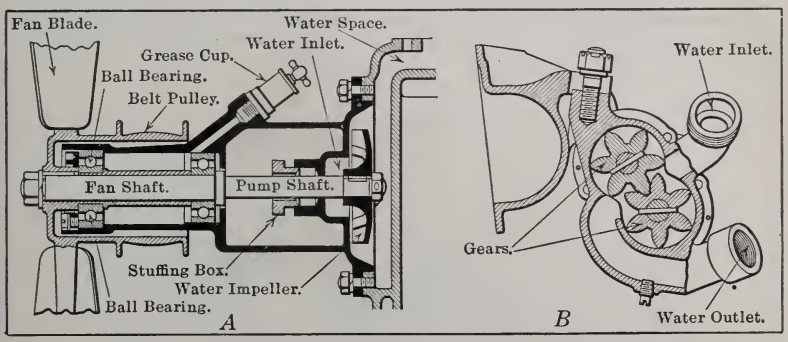


Fig. 449.—Two Forms of Water Circulating Pumps Representing Current Practice. A—Cooling Fan and Water Pump Driven from Common Source by Single Belt with Pump Impeller Placed Directly in Water Jacket. B—Gear Circulating Pump.

positive pumping features. They are very simple in form, consisting of a suitable cast body in which a pair of spur pinions having large teeth are carried. One of these gears is driven by suitable means and as it turns the other member they maintain a flow of water around the outside portion of the pump. The flow of liquid through the pump body is clearly shown at Fig. 450. The pump should always be installed in series with the water pipe which conveys the cool liquid from the lower compartment of the radiator to the coolest portion of the water jacket.

Water Circulation by Natural System.—Some engineers contend that the rapid water circulation obtained by using a pump may cool the cylinders too much, and that the temperature of the engine may be reduced so much that the efficiency will be lessened. For this reason there is a growing tendency to use the natural method of water circulation as the cooling liquid is supplied to the cylinder jackets just below the boiling point, and the water issues from the jacket at the top of the cylinder after it has absorbed sufficient heat to raise it just about to the boiling point.

The cooling system depicted at Fig. 451 is one that has demonstrated its worth conclusively in practice and is somewhat simpler than the forms in which a pump is used to maintain circulation. With this method, the fact that water becomes lighter as its temperature becomes higher is taken advantage of in securing circulation around the cylinders. The top of the water jacket of the block cast cylinders is attached to the center of the radiator, while the pipe leading from the bottom of that member is connected to a

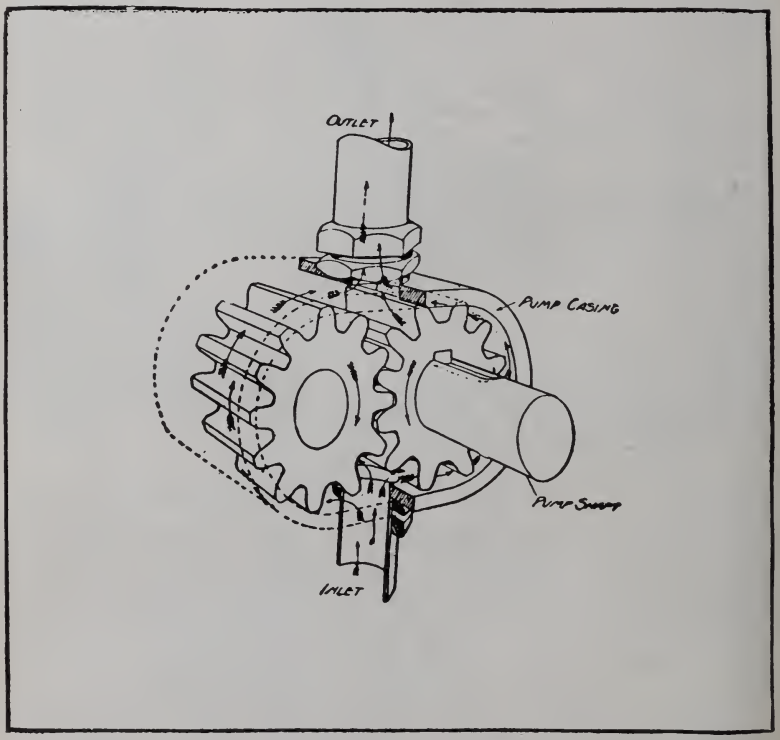


Fig. 450.—Diagram Outlining Action of Typical Gear Pump.

manifold which supplies cool water to the bottom of the cylinder jackets. With such a system it is imperative that the radiator be carried at such a height that the cool water will flow to the water spaces around the cylinder by gravity.

As the water becomes heated by contact with the hot cylinder and combustion-chamber walls it rises to the top of the water jackets, flows to the cooler, where enough of the heat is absorbed to cause it to become sensibly greater in weight. As the water becomes cooler, it

falls to the bottom of the radiator and it is again supplied to the water jacket. The circulation is entirely automatic and continues as long as there is a difference in temperature between the liquid in the water spaces of the engine and that in the cooler. The circulation becomes brisker as the engine becomes hotter and thus the temperature of the cylinders is kept more nearly to a fixed point. With the thermosyphon system the cooling liquid is nearly always at its boiling point, whereas if the circulation is maintained by a pump the engine will become cooler at high speed and will heat up more at low speed.

Radiator Location.—There are two methods of applying the thermosyphon system in a practical manner, the most common being that

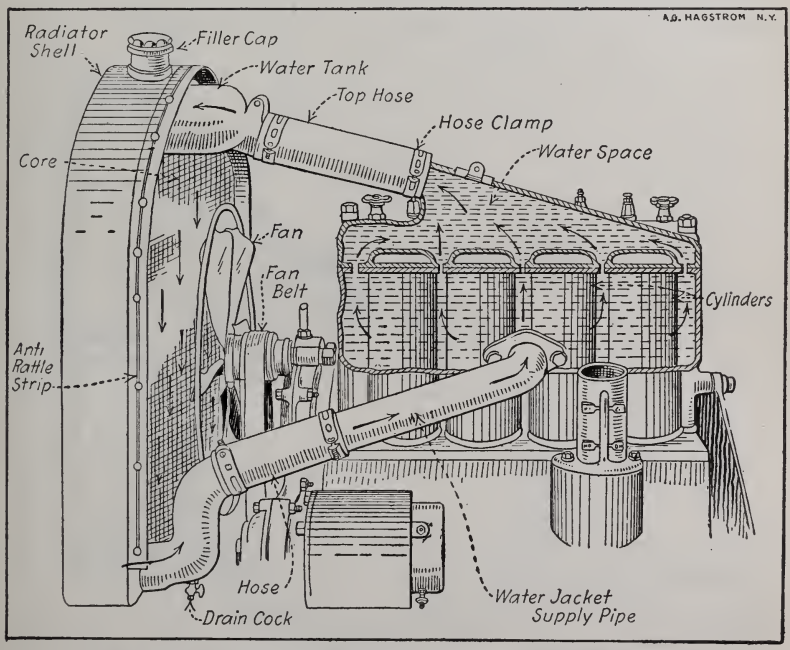


Fig. 451.—The Overland Thermo-Syphon Cooling System.

outlined at Fig. 451. Here the radiator is carried at the front end of the car and a fan driven from the crank shaft by belt connection is used to draw the air through the radiator. The other system, which is illustrated at Fig. 452, is one that was introduced on the Renault (French) automobile. In this the radiator is mounted just forward of the dashboard instead of at the front of the frame. The air draught through the radiator is produced by the suction effect

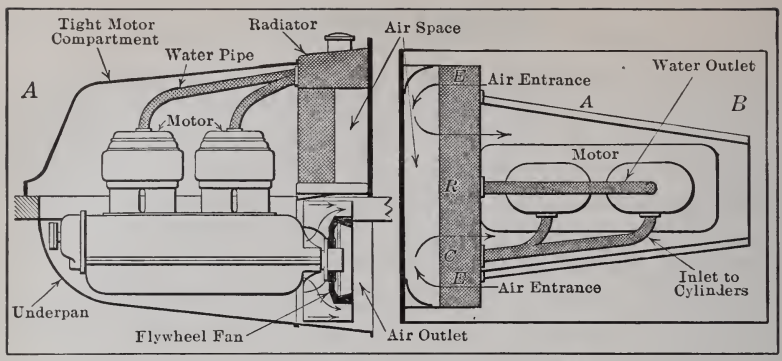


Fig. 452.—Renault Natural Circulation System, in which Radiator is Placed in Back of Engine Instead of in Front, as is Conventional Practice. A—How Fly-Wheel Fan Insures Air Circulation Through Radiator. B—Plan View Depicting Flow of Air Currents Through Cooler.

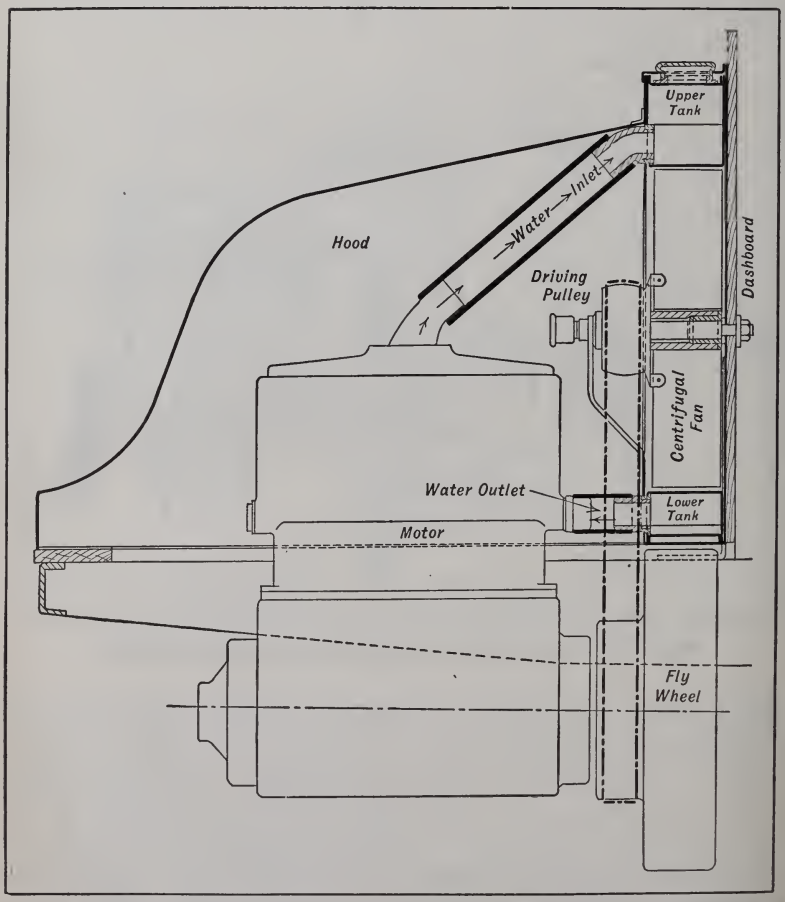


Fig. 453.—Thermo-Syphon Cooling System, Employing Radiator Placed Back of Motor.

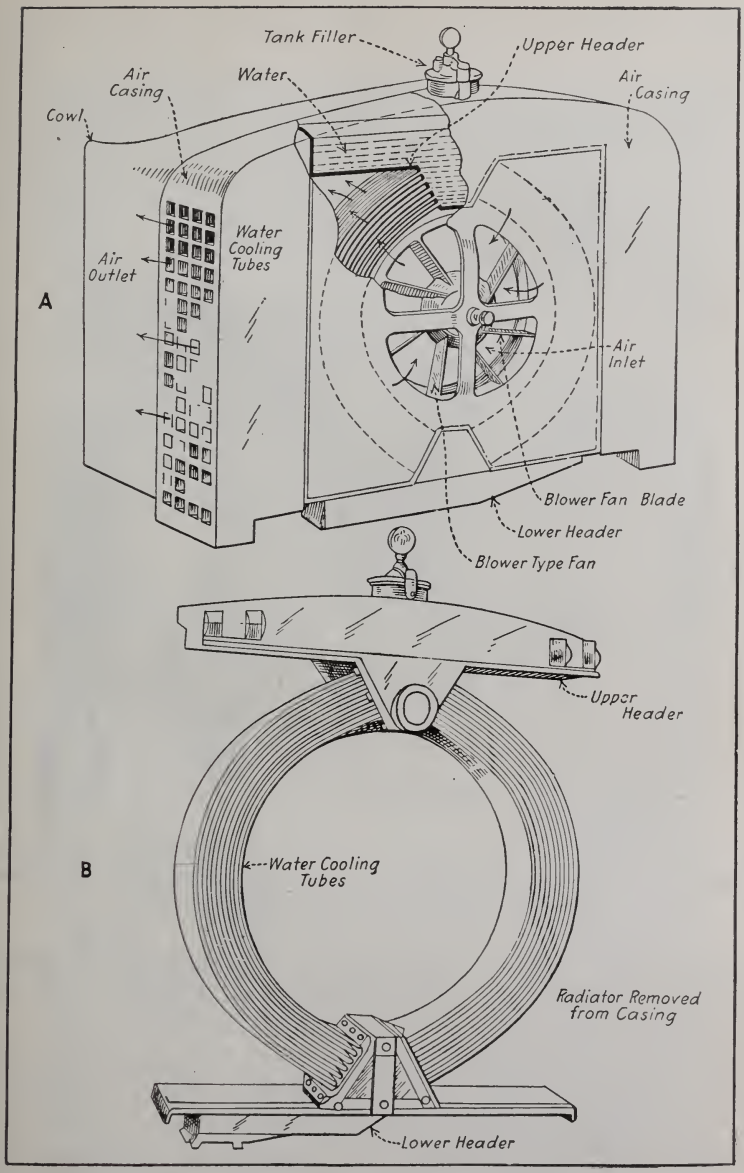


Fig. 454.—A Solderless Radiator for Motor Trucks. A—Showing Blower Type Air-Circulating Fan. B—The Radiator Tubes and Water Headers Removed from Air Casing.

of a fan member which is incorporated with the fly wheel. A modification of this system is shown at Figs. 453 and 454.

When a radiator is mounted at the front end of a frame, it is one of the most vulnerable portions of the motor-car mechanism, and as they are delicately constructed they may be easily damaged in collision. When installed as shown at Figs. 453 and 454, they are protected by the heavier construction of the cylinders and other portions of the motor and are not liable to be damaged. Then again, in the system shown at Fig. 452, as the fan is incorporated with the fly wheel and

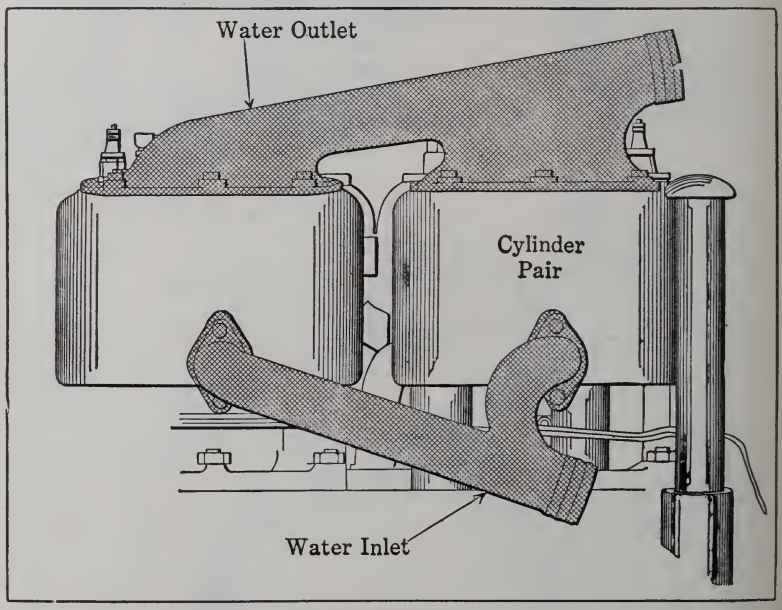


Fig. 455.—Showing Large Water Manifolds Designed to Secure Positive Circulation by Natural or Thermal Displacement.

driven directly by the crank shaft of the motor, there is no possibility of failure of this member, such as might be possible when it is driven by a belt connection from the front end of the engine.

With the thermosyphon or natural system of cooling more water must be carried than with the pump maintained circulation methods. The water spaces around the cylinders should be larger, the inlet and discharge water manifolds should have greater capacity, and be free from sharp corners which might impede the flow. The radiator must also carry more water than the form used in connection with the pump because of the brisker pump circulation which maintains the engine temperature to a lower point. The large piping which experience has shown necessary when cylinders are cast in pairs is clearly shown in Fig. 455.

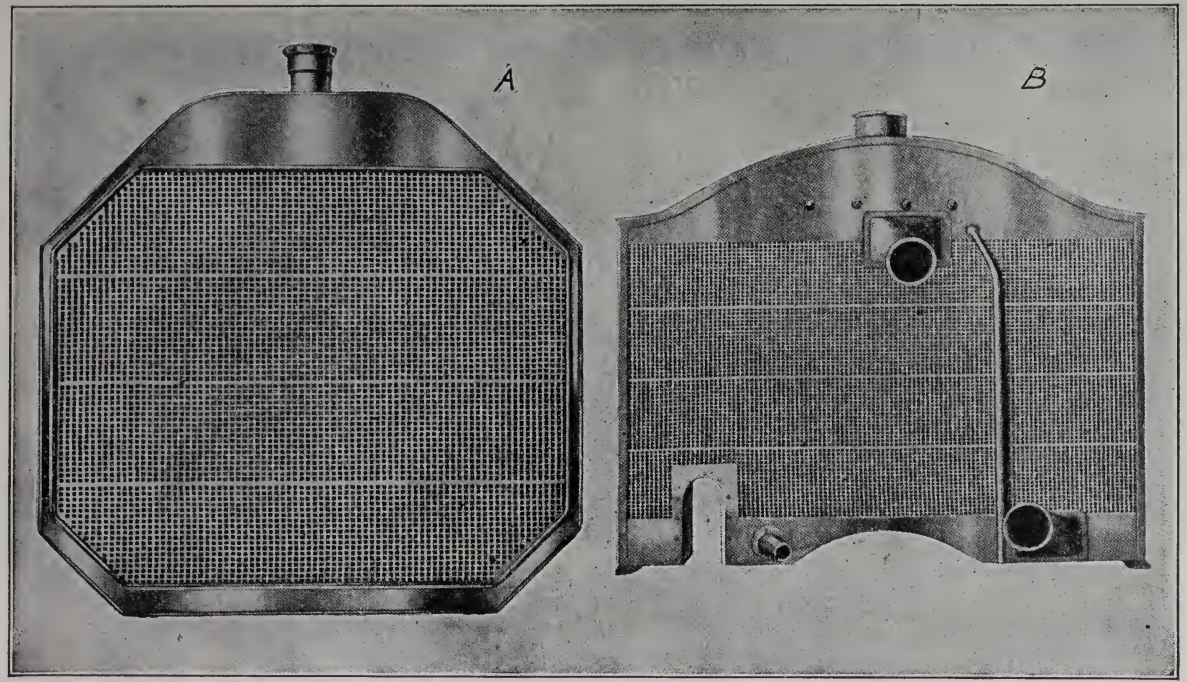


Fig. 456.—Typical Radiator Forms. A—Type Used at Front of Car. B—Cooler Construction when Placed in Back of Engine.

Cooling-Fan Construction.—The form of fan which is generally placed behind the radiator with either system of water cooling and which is often used in the simple air-cooling systems as well, is shown in part section at Fig. 457, A. The hub is usually a cast-aluminum

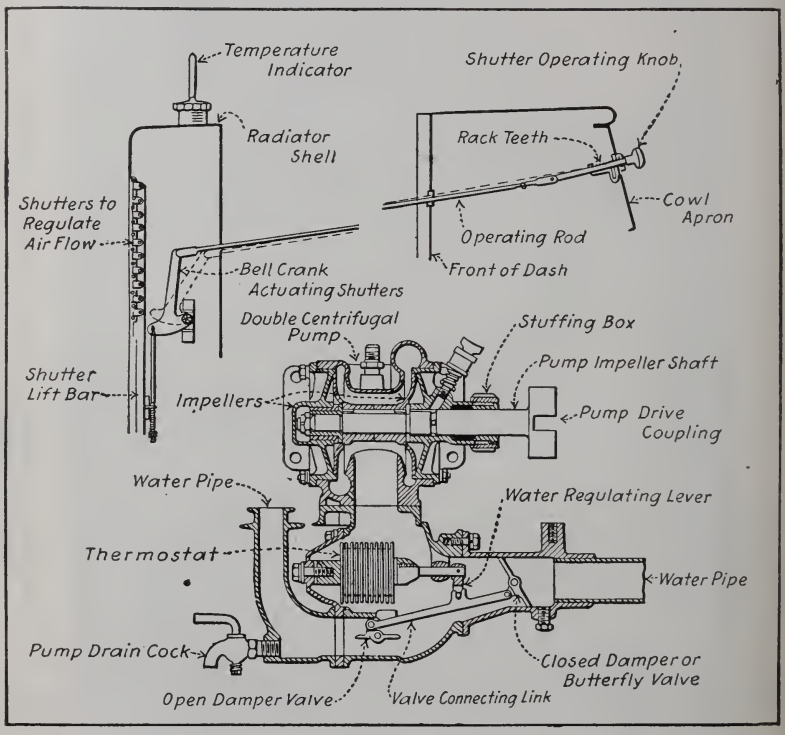


Fig. 457.—Recent Improvements in Cooling Systems. At Top—Shutter to Regulate Temperature of Water in Cold Weather. Below—Thermostatic Regulator to Keep Water at Most Efficient Operating Temperature.

member which has a series of projecting spokes to which the fan blades are riveted. The blades are inclined at the proper angle to draw air through the radiator and force it to the rear of the motor compartment. As a fan requires but little power, they are usually driven by small leather belts and as they operate at speeds two or three hundred per cent greater than that of the motor crank shaft they are mounted on ball bearings in order that they may turn with as little friction as possible. The fan spindle is usually supported by some form of movable bracket which can be adjusted so that the fan belt may be maintained at a constant degree of tension.

Radiator With Shutters.—In order to remove the necessity for using padded covers, etc., on the radiators of Hudson cars, the company has just brought out a device which acts as a radiator shutter and which is included in the regular equipment. The new device is operated from the dash by the driver and permits him, by means of a simple plunger, to govern the amount of air that comes in contact with the radiating surface and hence puts the temperature of the cooling fluid under his control. As will be seen from the illustration at Fig. A, 457, the device acts very much as a shutter with a series of vanes which open and close in accordance with the movement of the controlling device on the dash. In summer the mechanism need not be detached, as it does not cut down materially the area of the radiator when it is full open, so that in warm weather it is simply left untouched. In order that the device will be complete, it is necessary for the driver to know the temperature of the cooling water accurately enough to determine whether the shutter is open or closed to the correct degree. This part of the equipment is provided by a Moto-Meter, or special thermometer, mounted in its customary position on the radiator cap.

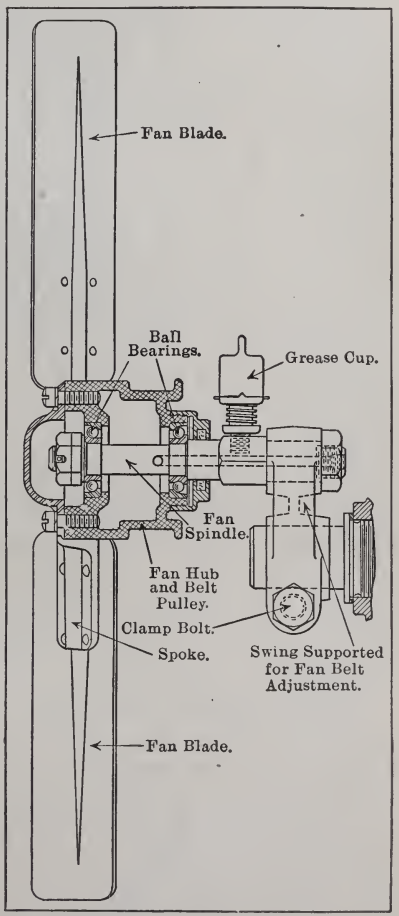


Fig. 457A.—Typical Ball-Bearing Hub-Cooling Fan Designed to Draw Air Through Radiator.

The device is particularly valuable in warming the car in very cold weather, as the air can be entirely shut off from the radiator until the water temperature reaches its efficient degree, which, in the case of the Hudson, is stated to be 130 degrees Fahrenheit. The shutter vanes then can be opened to the desired amount by simply operating the pull rod on the dash. From a maintenance standpoint, the device is very simple,

as there is nothing to it except the shutter and the rod and bell-crank operating mechanism. There is no need for any adjustments on it, and none are provided for. The installation is simple and is made possible by using a longer radiator shell, which not only houses the radiator but also the shutter. This device may be secured to fit other cars also.

Thermostatic Temperature Regulators.—The natural circulation or thermo-syphon system of cooling is becoming more and more popular, as it is now found on about 35 per cent of 1917 passenger-car models. In those cars where high efficiency is sought, and especially in types fitted with 8- and 12-cylinder engines, quite elaborate thermostatic control devices are provided to regulate the temperature of the water and prevent such rapid circulation that the cylinders will be unduly cooled. A device of this character is clearly shown at Fig. 457. The thermostatic element controls shutter valves so that when the water passing through the device is too cold, the valves shut it off from the radiator. When it becomes heated to a dangerous temperature the valves are opened by the extension of the thermostatic element and the water allowed to circulate through the entire cooling system. It would seem to the writer that the thermo-syphon system could be used and give all of the advantages obtained by the more complicated systems. The water will not circulate very fast until the engine is thoroughly warmed up and the hotter the water gets the more rapidly it circulates. When one considers that the angular placing of the cylinders in twin-fours and twin-sixes makes for almost ideal thermo-syphon cooling, it is hard to understand why its advantages are not more generally appreciated.

Radiator Construction.—Most radiators are now of the separate core and steel shell type, shown at Fig. 458, A, which are more easily repaired than the integral construction, shown at Fig. 456. The cores are almost all of the cellular or honeycomb type on pleasure cars, though the flat and round flanged tube types are very popular in motor truck practice. The heavy cast shells with cooling flanges cast integrally, as shown at Fig. 458, B, are the most popular for trucks. Improved methods of radiator suspension by using springs are now followed to minimize danger of the vibration, inevitable in trucks running on solid tires, causing the joints to leak. The effort is made to have the cooling sections or cores easily removable for repairs in all modern radiators, and in some truck radiators it is possible to plug up several leaking tubes (because of the removable top and bottom headers, which makes them accessible) without materially reducing the cooling efficiency.

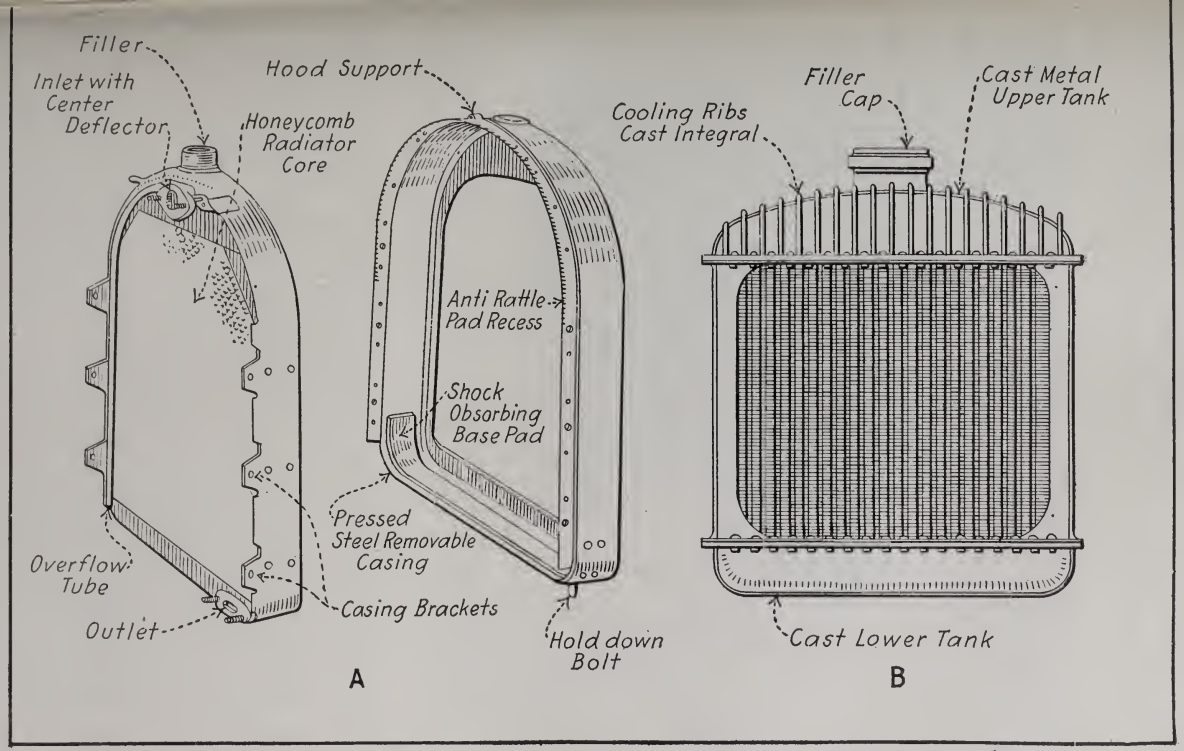


Fig. 458.—How Radiators Differ in Construction. A—Modern Pleasure Car Type Having Removable Honeycomb Core and Pressed Steel Exterior Shell. B—Motor Truck Type with Cast Metal Headers and Easily Removable Tubes.

Solderless Radiator for Trucks.—The usual form of radiator used on motor trucks is built up of innumerable small-bore tubes soldered together and to the sheet metal containing case. As practically all motor trucks are supported on wheels equipped with solid rubber tires considerable vibration is produced that cannot be entirely offset by flexible radiator suspensions. A radiator of new design, which is used on several late models of American trucks and in which no solder is used to speak of, is illustrated at Fig. 454. A large number of semi-circular sections of flat copper tubes are expanded into plates at the ends which are in turn attached to top and bottom headers by means of bolts or an equivalent mechanical fastener. The tubes expand readily as they become heated and do not stress the joints. The top and bottom tanks are cast of aluminum alloy. The upper header is formed so that it acts as a basis for the radiator cowl, while the lower one is made of such a form that it may be used as a frame to support the radiator. Instead of being placed at the front of the engine, as is the usual practice, this radiator is mounted at the back of the engine and just ahead of the dash. A blower type, centrally placed fan draws air from both front and rear and discharges it through suitable air outlets at the sides of the air casings. This radiator is not only an efficient one, but is very easily repaired and has been found to withstand the vibration much better than the more intricate honeycomb type.

Direct Air-Cooling Methods.—The earliest known method of cooling the cylinder of gas engines was by means of a current of air passed through a jacket which confined it close to the cylinder walls and was used by Daimler on his first gas engine. The gasoline engine of that time was not as efficient as the later form, and other conditions which materialized made it desirable to cool the engine by water. Even as gasoline engines became more and more perfected there has always existed a prejudice against air cooling, though many forms of engines have been used, both in stationary and automobile, as well as in motorcycle and aircraft applications where the air-cooling method has proven to be very practical.

The simplest system of air cooling is that in which the cylinders are provided with a series of flanges which increase the effective radiating surface against which an air current from a fan is directed to absorb the heat. This increase in the available radiating surface of an air-cooled cylinder is necessary because air does not absorb heat as readily as water and therefore more surface must be provided that the excess heat be absorbed sufficiently fast to prevent distortion of the cylinders. Air-cooling systems are based on a law formulated

by Newton, which is: "The rate for cooling for a body in a uniform current of air is directly proportional to the speed of the air current and the amount of radiating surface exposed to the cooling effect." A simple four-cylinder power plant in which cooling is obtained by air blast against the flanges of the cylinders is depicted at Fig. 459, and

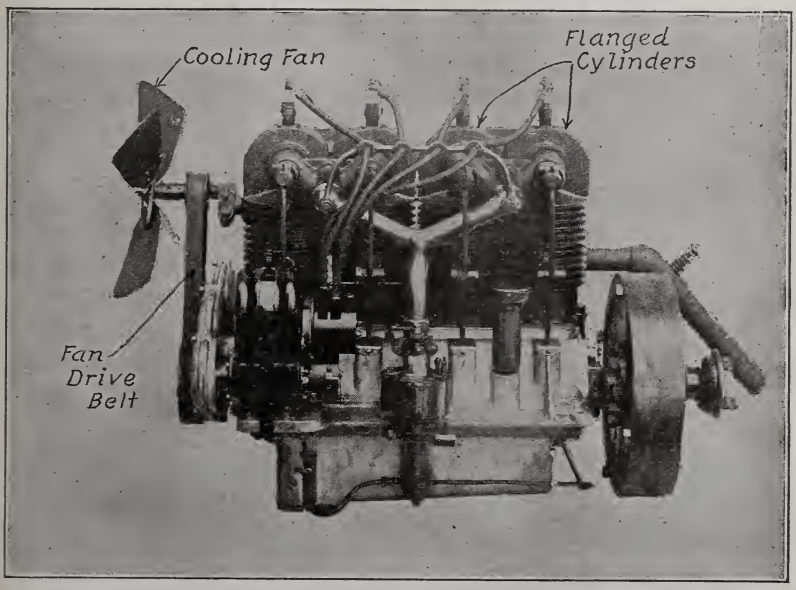


Fig. 459.—Air-Cooling System Employed in Simple Four-Cylinder Motor Depends Upon Air Draught from Fan to Circulate Around Flanges on Cylinders and Absorb Excess Heat.

views of a cylinder and detachable head construction also adapted to be cooled by air are shown at Fig. 460.

There are certain considerations which must be taken into account in designing an air-cooled engine, which are often overlooked in those forms cooled by water. Large valves must be provided to insure rapid expulsion of the flaming exhaust gas and also to admit promptly the fresh cool mixture from the carburetor. The valves of air-cooled engines are usually placed in the cylinder head in order to eliminate any pockets or sharp passages which would impede the flow of gas or retain some of the products of combustion and their heat. When high power is desired multiple-cylinder engines should be used, as there is a certain limit to the size of a successful air-cooled cylinder. Much better results are secured from those having small cubical contents because the heat from small quantities of gas will be more quickly carried off than from greater amounts. All successful engines

of the automobile type which have been air cooled have been of the multiple-cylinder type and the use of single cylinders is confined to power plants of less than five horse power, such as used in motorcycle construction or small stationary engines of not more than three horse power.

An air-cooled engine of the simple type must be placed in a chassis in such a way that there will be a positive circulation of air around it all the time that it is in operation. This air current may be produced by a fan at the front end of the motor, by natural draught when a car is in motion, or by a suction or blower fan in the fly wheel. Greater care is required in lubrication of the air-cooled cylinders and only the best quality of oil should be used to insure satisfactory oiling.

The combustion chambers must be proportioned so that distribution of metal is as uniform as possible in order to prevent uneven expansion during increase in temperature and uneven contraction when the cylinder is cooled. It is essential that the inside walls of the combustion chamber be as smooth as possible because any sharp angle or projection may absorb sufficient heat to remain incandescent

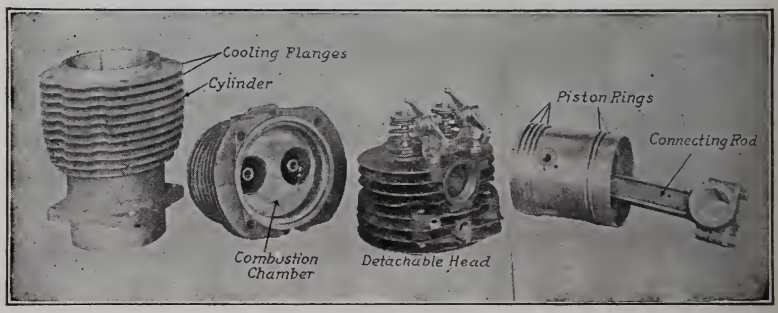


Fig. 460.—Parts of Air-Cooled Cylinder Showing Method of Seating Valves Directly in Detachable Cylinder Head and Use of Large Flanges on Both Cylinder and Head Member to Increase Effective Radiating Surface.

and cause trouble by igniting the mixture before the proper time. The best grades of cast iron should be used in the cylinder and piston and the machine work must be done very accurately so the piston will operate with minimum friction in the cylinder.

Utility of Auxiliary Exhaust Valves.—As an example of the care taken in disposing of the exhaust gases in order to obtain practical air cooling the illustration at Fig. 461 is presented. This is a section through the bottom of one of the early Franklin power plants and shows the auxiliary exhaust valve which is furnished as an adjunct to the regular member in the cylinder head. The auxiliary exhaust

valve opens just as soon as the full force of the explosion has been spent and the greater portion, or 70%, of the flaming gases is discharged through the port in the bottom of the cylinder. But 30% of the exhaust gases remain to be discharged through the regular exhaust member in the cylinder head and this will not heat the walls of the cylinder nearly as much as the larger quantity of hot gas would. That the auxiliary exhaust valve is of considerable value is conceded

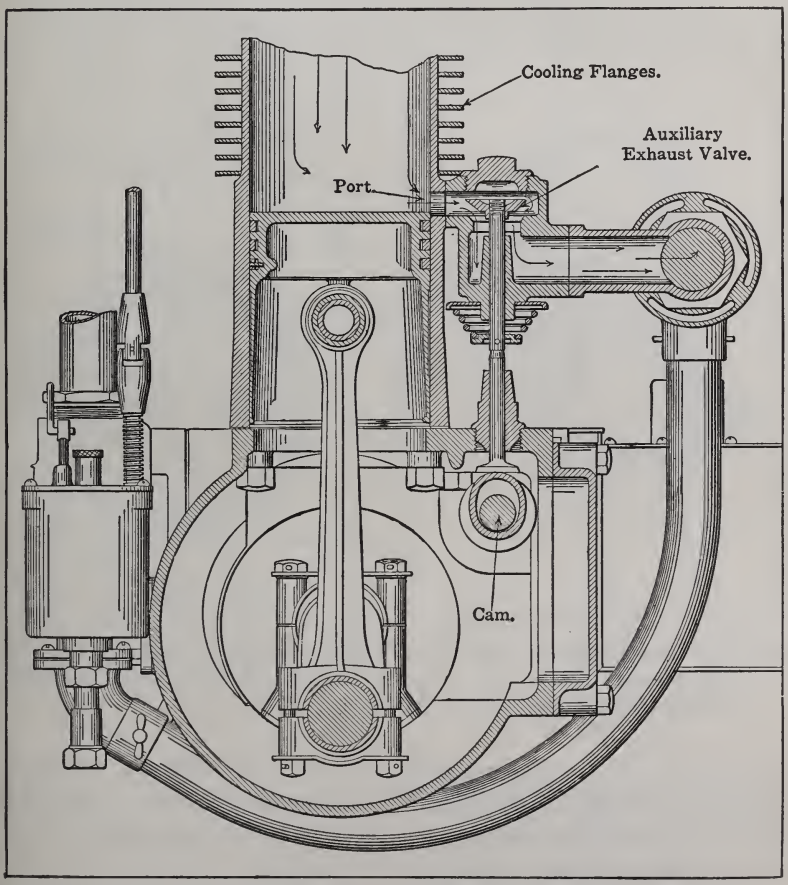


Fig. 461.—Section of Lower Portion of Early Franklin Air-Cooled Engine Showing Auxiliary Exhaust Valve.

by many engineers unless exceptional care is taken in the method of cooling employed. The earlier Franklin engine, which used the auxiliary exhaust valves, was cooled by an air blast from a fan at the front end, which was directed against horizontal flanges applied to the

cylinders, but on later models the auxiliary valve has been dispensed with because the more positive system of cooling now used makes its use unnecessary and of course simplifies the motor construction by its elimination.

One of the important considerations in connection with air cooling is that the air blast be confined as close to the cylinders as possible and a more energetic flow of air is needed than with water-cooling systems. The ordinary form of fan is considered entirely adequate for water-cooled engines, but engineers who favor air cooling at the present time use blower forms such as shown at Fig. 462, B, which

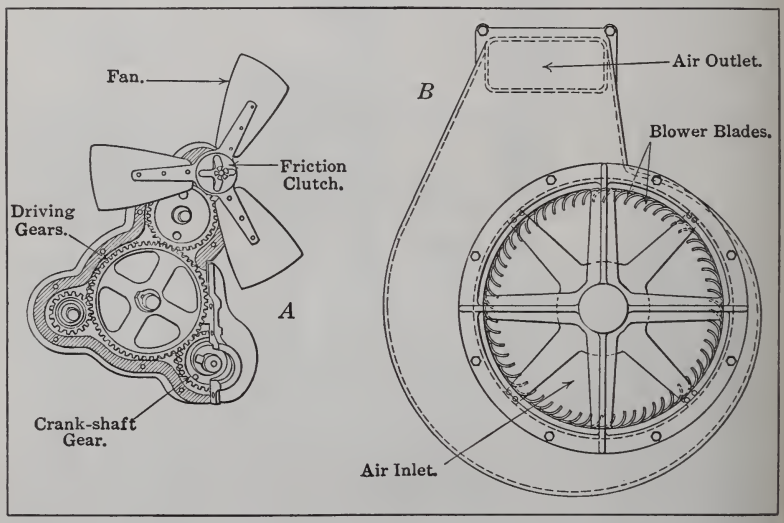


Fig. 462.—Two Forms of Positive Air Fans Used in Air-Cooling Systems. A—Gear-Driven, Three-Blade Fan. B—Blower Member Used on Renault Air-Jacketed Cylinder Aviation Motor.

will furnish larger quantities of air than the simple fan would and which also direct it to the cylinders in a positive manner by enclosing them in air jackets which are attached to a manifold member to which the discharge opening of the blower is coupled.

Air-Cooled Two-Cycle Engine.—The discussion of air cooling so far has considered only the adaptability to the four-stroke motor and many believe that it is not possible to cool two-cycle engines by this method because the great heat generated in engines of this type is thought to make the use of water cooling imperative. As the two-cycle motor has an explosion in each cylinder, every revolution of the crank shaft, and has no strokes devoted exclusively to scavenging, it

is true the cylinder walls will heat up more. Several forms of two-cycle engines have been evolved, however, in which positive cooling has been obtained by providing the cylinders with cooling ribs. One of these, which was used in the Chase light truck, is depicted in section at Fig. 463. It will be noted that the exhaust ports are large and that the transfer port for the passage of the gas from the crank case to the cylinder is proportioned so that it will have a minimum resistance to the gas flow.

Blower-Cooled Engines.—Two engines of relatively modern development which utilize positive air-cooling methods are shown at Figs. 464 and 465. The system of cooling is practically the same in both instances, except in the methods employed of creating the air blast. In the Franklin system the cylinders are provided with vertical ribs, or flanges, and are encased by jackets which form part of a sheet-metal casing that covers the entire lower portion of the power plant. The fly wheel is provided with a series of curved blower blades and as it turns it creates a partial vacuum in the compartment formed by the motor-base casing and the air-tight underpan. The strong suction created draws air in from the front end of the bonnet and down through the cylinder jackets. The air currents pass over the flanges at high velocity, and as there is a large amount of exposed surface the excess heat is promptly disposed of and absorbed by the air passing around the cylinders which is ejected from the motor-base compartment by the action of the blower fly wheel. As the fan is part of the balance member and is driven direct from the engine crank shaft there can be no failure of the driving means and a positive air draught must be induced around the cylinders as soon as the motor is started. The velocity of the air currents

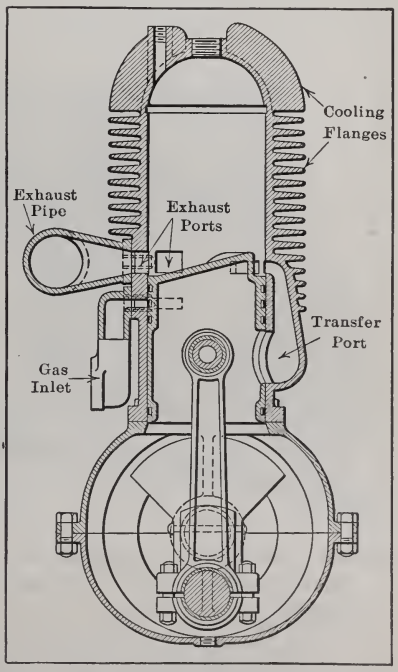


Fig. 463.—Sectional View of Chase Two-Cycle Engine, a Two-Stroke Form Successfully Cooled by Air Flanges Cast Integral with the Cylinder.

increase directly as the motor speed augments, and positive cooling is obtained under all conditions. This system has been used very successfully for a period of seven years and is unchanged in essentials at the present day. The only change on the 1917 models is the use of a Renault-type hood instead of the cylindrical form shown.

In the cooling system which was used in the early Kelly trucks and which was adapted in the Renault air-cooled aviation motor, the method of cooling is different in detail but practically the same in principle as that previously described. An air blower is mounted at the front end of the motor and the strong current of air it produces is conveyed to an air pipe at the top of the cylinders, to which the

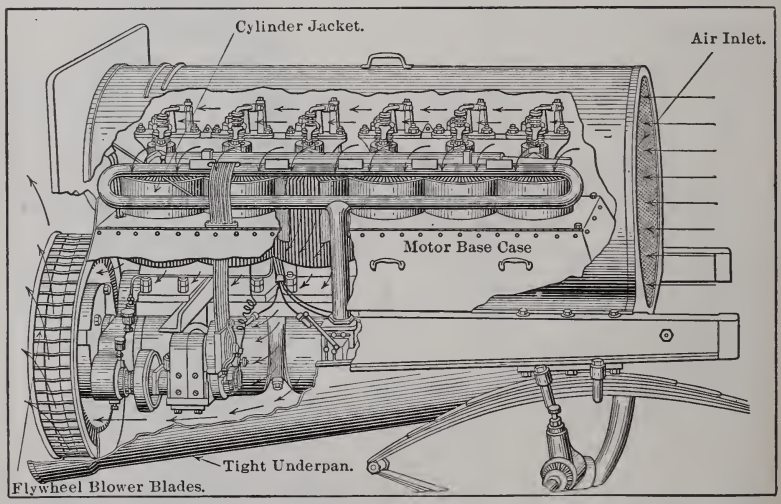


Fig. 464.—Positive Air-Cooling Method Used on Franklin Automobiles, in which Air Currents are Drawn Through Cylinder Jackets by Fly-Wheel Fan Suction.

jackets surrounding them are attached. The cylinder heads are provided with a series of vertical flanges, but the cylinder-wall area is increased by using a large number of spines which are cast integral with the cylinder. The air blower forces a blast of air into the air pipe above the cylinders at considerable pressure, and the only way it can escape is by passing around the heated portion of the cylinder before it is discharged through the bottom of the air jacket. As the blower speed increases with engine speed the value of the air current becomes greater when an augmented cooling effect is desired.

Among the advantages stated for air cooling by its few remaining adherents the greatest is the elimination of cooling water, which is a

factor of some moment. In the temperate zone, where the majority of automobiles are used, the weather conditions change in a very few weeks from the warm summer to the extreme cold of winter, and when water-cooled systems are employed it is necessary to add some chemical substance to the water to prevent it from freezing. The substances commonly employed are glycerine, wood alcohol, or a saturated solution of calcium chloride. Alcohol has the disadvantage in that it vaporizes readily and must be often renewed. Glycerine affects the rubber house, while the calcium chloride solution crystallizes and deposits salt in the radiator and water pipes.

Obviously the elimination of water and the use of air cooling will provide a system that will be fully as effective during the extreme

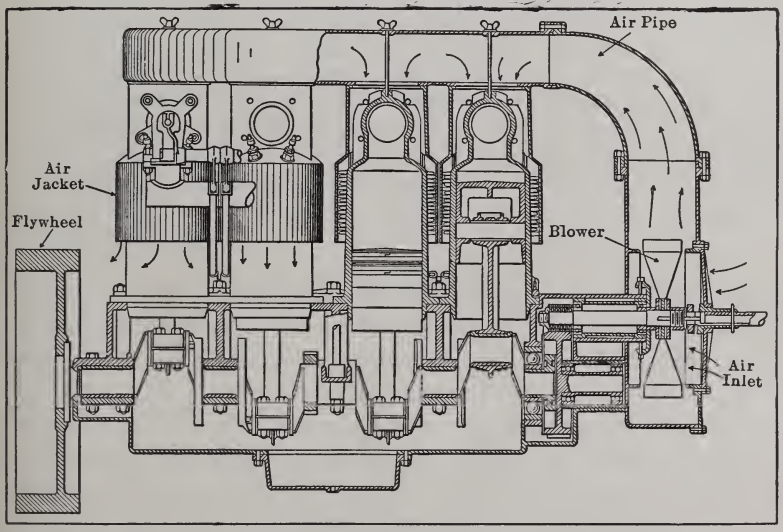


Fig. 465.—Air-Jacketed Engine Used in Early Kelly Trucks Cooled by Air Currents Directed Over Cylinders by Positive Air-Blower System.

cold weather as it is during the more favorable summer season. It would seem that air-cooling methods could be applied to advantage in commercial vehicle power plants which must be capable of efficient service under widely varying conditions. One of the disadvantages of an air-cooling method, as stated by those who do not favor this system, is that engines cooled by air cannot be operated for extended periods under overloads or at very high speed without heating up to such a point that premature ignition of the charge may result. The water-cooling systems, at the other hand, maintain the temperature of the engine more nearly constant than is possible with an air-cooled

motor, and an engine cooled by water can be operated under conditions of inferior lubrication or poor mixture adjustment that would seriously interfere with proper and efficient cooling by air. As special care is said to be needed in driving an air-cooled car to obtain satisfactory results and because of the greater difficulty which obtains in providing proper lubrication and fuel mixtures which will not produce undue heating, the air-cooled system has but few adherents at the present time and all well-known automobiles, with but one exception, are provided with water-cooled power plants. The air-cooling system is universally employed on motorcycle engines, however.

CHAPTER IX

CLUTCHES AND CHANGED SPEED GEARING

Utility of Clutch and Gearset Defined—Why Clutch is Necessary—Clutch Forms and Their Requirements—How Friction Clutches Transmit Power—Materials Employed to Increase Friction—Forms of Cone Clutches—How Leather Facing is Attached—Securing Easy Engagement—Three- and Five-Plate Clutches—Features of Multiple Disk Clutches—Why Change Speed Gearing is Necessary—Face Friction Gearing—Planetary Gearing—Individual Clutch Transmission—Gearbox Using Silent Chains—How Sliding Gearsets Operate—Progressive Shift—Selective Gear Shift—Four Speed Gearboxes—Change Speed Gear Installation—Unit Power Plant—Combined with Countershaft—Transmission Gear for Four-Wheel Drive—Gas-Electric Systems—Hoadley System—Couple Gear System—Entz Electric Transmission—Magnetic Centrifugal Clutch System—Vulcan Electric Gearshift.

One of the important functions making for efficient operation of the gasoline motor car is the method of power transmission employed. While power plant efficiency is an important factor and one that should be conserved to the utmost, it is well to remember that the actual power of the car is not the rated power of the engine but the amount of energy exerted at the point of contact between the traction members and the ground. A 60 H. P. car in which there is a 30% loss in power transmission is not as powerful as a vehicle of but 45 H. P. which delivers the power to the rear wheels with but 10% loss. Under the conditions stated the rear wheels of the lower-powered car would actually receive more useful effort than the driving members of the high-powered vehicle, and the energy is supplied with less stress on the various parts and with a lower fuel consumption.

The attention of mechanical engineers had been directed to the efficient transmission of power long before the motor car was commercially practical. As a result many ingenious systems which had been applied in standard mechanical work and for driving the machine tools of manufacturing establishments have been readapted for use in motor-car propulsion. One who has studied the subject can easily trace the evolution from the crude forms of a decade ago

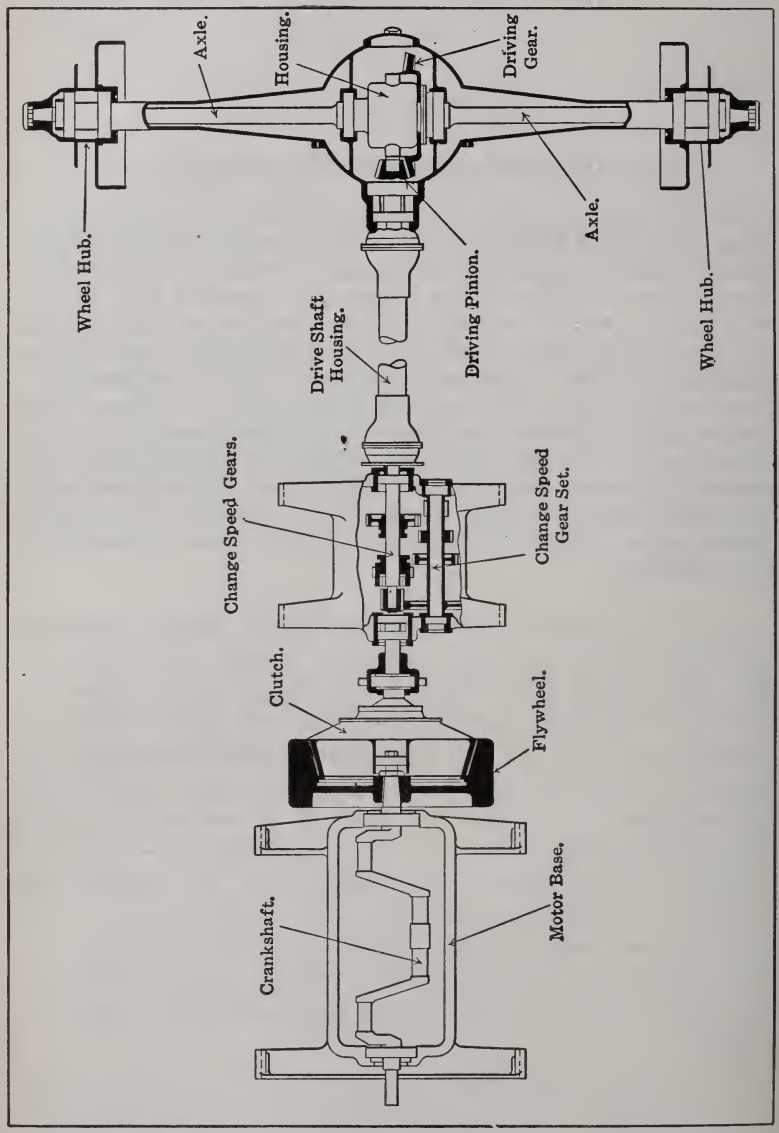


Fig. 466.—Plan of Components of Power Transmission System of Gasoline Automobile, Depicting Relation of Clutches, Gearset and Driving Gears.

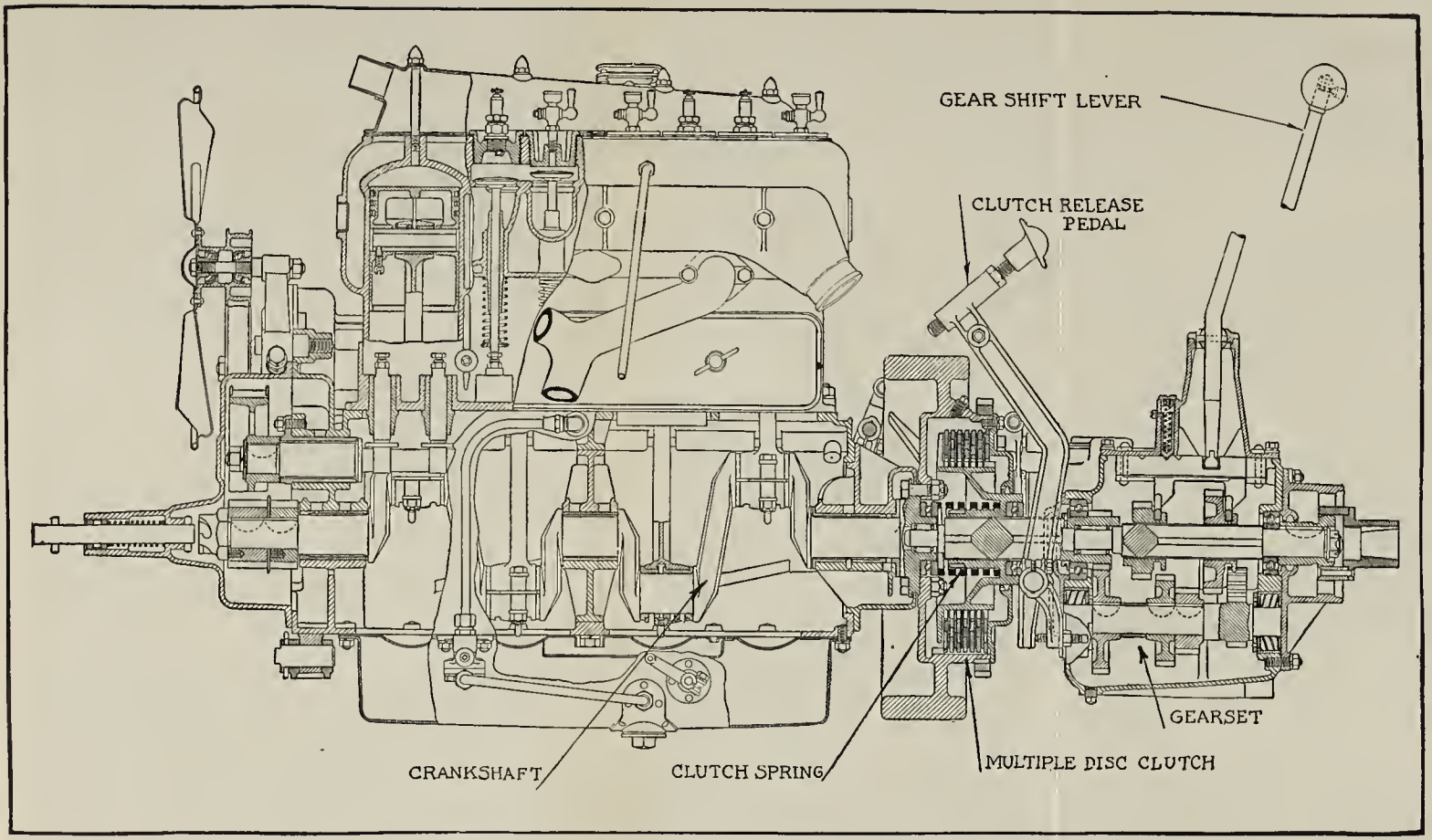


Fig. 467—Complete Power Plant Showing Relation of Clutch and Gearset to Power Generating Unit.

to the perfected types used in modern automobiles. The problem of power transmission in motor cars was one that was not easily solved, and much experimenting was necessary before the perfected forms of the present day were evolved.

A simple power-transmission group such as employed in the modern gasoline automobile is depicted in Fig. 466. In this the power is applied to the crank shaft of the motor and from thence it is delivered to the motor fly wheel which forms the female member of a friction clutch. The male member of the clutch is coupled to the change-speed gearing and this in turn is joined to the driving pinion in the rear axle by a length of shaft. The driving pinion delivers its power to a bevel-driving gear which is carried by the differential casing in the rear axle housing. From the differential gear independent shafts or axles drive the rear wheel hubs. A more complete power plant and gearset assembly at Fig. 467 shows clearly the relation between crank-shaft clutch and change-speed gearing. The method of power transmission employed on the Ford car is outlined at Fig. 468. This illustration is especially valuable, as it shows all important parts of the most popular automobile chassis in the world.

The function of the clutch is to permit the engine to be run independently of the transmission gearing when desired. The engine can drive the car only when one of the sets of gears in the gearset and the clutch are engaged simultaneously. For example, if the clutch is out or released, even if the gears were in mesh in the change-speed device, the rear wheels would not be turned until the clutch cone was allowed to engage the female member formed in the fly-wheel rim. At the other hand, when the parts are as shown with the clutch in engagement and the speed gears out of mesh the engine can still be revolved without turning the rear wheels.

Why Clutch is Necessary.—In order to secure a better understanding of the general requirements of clutching devices it will be well to consider the conditions which make their use imperative when a motor car is propelled by a hydrocarbon motor. If a steam engine or an electric motor are installed as prime movers it is not necessary to include any clutching device or gearset between them and the driving wheels, and these members may be driven directly from the power plant if desired. With either of the forms mentioned the power is obtained from a separate source which may be uncoupled from the motor by the simple movement of a throttle valve or switch lever. Steam and electric motors are also capable of delivering power in excess of their rating and are more flexible than internal combustion power plants.

If steam is the motive agent it is generated and contained in a special device known as a boiler, and the amount of power delivered by the engine to which the boiler is connected will vary with the amount of steam admitted and its pressure. If the steam supply is interrupted entirely the engine and the car which it drives are brought to a stop. When it is desired to start again a simple movement of the throttle-valve lever will permit the steam to flow from the boiler to the engine cylinders again and the vehicle is easily set in motion. If it is desired to reverse the car the steam flow is reversed by a simple mechanical movement and the engine will run in the opposite direction to that which obtains when the car is driven in a forward direction.

If an electric motor drives a vehicle the electrical energy is secured from a group of storage batteries. When these are fully charged varying amounts of electric current may be drawn from them and allowed to flow through the windings of the field or armature of the motor and different ratios of power or speed obtained. The vehicle is easily started by completing the circuit between the motor and the source of current and stopped by interrupting the supply of electrical energy. As the flow of electricity can be reversed easily by a switch the car may be driven backward or forward at will, and as the speed may be easily varied by changing the value of the current strength there is no need of speed changing or reversing gears.

When a gasoline engine is fitted, conditions are radically different than with either a steam or electric power plant. The power developed depends upon the number of explosions per unit time and the energy augments directly as the number of explosions and revolutions of the crank shaft increase. It is not possible to start a gasoline engine when under load because the power is obtained by the combustion of fuel directly in the cylinders, and as there is no external source of power to draw from it is obvious that the energy derived depends upon the rapidity with which the explosions follow each other. It has been demonstrated that a certain cycle of operation is necessary to secure gasoline-engine action and it is imperative that the engine revolves freely until it attains sufficient speed to supply the torque or power needed to overcome the resistance that tends to prevent motion of the car before it can be employed in driving the vehicle.

Then, again, it is very desirable that the vehicle be started or stopped independently of the engine. With a steam or electric motor the vehicle may be started just as soon as the driving power is ad-

mitted to the prime mover; but with a gasoline engine it is customary to interpose some device between the engine and driving wheels which make it possible to couple the engine to the wheels or driving gearing and disconnect it at will. The simplest method of doing this is by means of some form of clutching device which will lock the driving shaft to the crank shaft of the engine.

Clutch Forms and Their Requirements.—Clutch forms that have been applied to automobile propulsion are usually of the frictional type, though some have been devised which depend upon hydraulic, pneumatic, or magnetic energy. Those which utilize the driving properties of frictional adhesion are most common and have proven to be the most satisfactory in practical application. The most important requirement in considering clutch forms is that such devices must be capable of transmitting the maximum power of the engines to which they are fitted without any power loss due to slipping. Such a clutch must be easy to operate and but minimum exertion should be required of the operator. When the clutch takes hold the engine power should be transmitted to the gearset and driving means in a gradual and uniform manner, or the resulting shock may seriously injure the mechanism. When released it is imperative that the two portions of the clutch disengage positively so that there will be no continued rotation of the parts after the clutch is disengaged.

The design should be carefully considered with a view of providing as much friction surface as possible to prevent excessive slipping and loss of power. It is very desirable to have a clutch that will be absolutely silent whether engaged or disengaged. If the clutch parts are located in an accessible manner it may be easily removed for inspection, cleaning, or repairs. It is desirable that adjustment be provided, so a certain amount of wear can be compensated for without expensive replacement. A simple, substantial design with but few operating parts is more to be desired than a more complex device which may have a few minor advantages, but which is more likely to cause trouble.

The friction clutch in its various efficient types is the one that more nearly realizes the requirements of the ideal clutch. As a result this form is now universally recognized by automobile designers, and all standard gasoline automobiles utilize some form of friction clutch. These devices are capable of transmitting any amount of power if properly proportioned, and permit of gradual engagement and positive disconnection. Most friction clutches are simple in form, easily understood, and may be kept in adjustment and repair without difficulty.

How Friction Clutches Transmit Power.—To illustrate the transmission of power by the frictional adhesion of substances with each other we can assume a simple case of two metal disks or plates in contact, the pressure existing between the surfaces being due to the weight of one member bearing upon the other. If the disks are not too heavy, it will be found comparatively easy to turn one upon the other, but if weights are added to the upper member a more decided resistance will be felt which will increase directly as the weight on the top disk and consequently the pressure between the disks increases. It may be possible to add enough weight so it will be practically impossible to move one plate without turning the other. It is patent that if one of these plates was mounted rigidly on the engine shaft and one applied to the transmission shaft so that it had a certain amount of axial freedom and pressure of contact was maintained by a spring instead of weights, a combination capable of transmitting power would be obtained. The spring pressure applied to one disk would force it against the other and one shaft could not turn without producing a corresponding movement of the other.

Materials Employed to Increase Frictional Adhesion.—The main object of engineers in designing a clutch is to increase the amount of friction adhesion existing between the parts as much as possible. The transmitting efficiency of the clutch will vary with the coefficient of friction between the surfaces and the more the friction between them the more suitable the clutch will be for transmitting power. A metal usually forms one frictional surface in all forms of clutches, and some types have been designed and used successfully in which all friction surfaces are metals.

The materials of a metallic nature commonly used are cast iron, aluminum and bronze castings, and sheet steel and bronze, usually in the form of thin-stamped disks. The nonmetallic frictional materials generally used are leather, asbestos fabrics, textile beltings, and cork. Leather is the best lining or facing for clutches where the frictional area is large. When used it must be kept properly lubricated and soft, as if it becomes dry it will engage very suddenly and clutch action will be harsh. At the other hand, care must be taken not to supply too much lubricant or the coefficient of friction will be reduced to a low point and the surfaces will slip. Oak-tanned leather is generally used because it has good wearing qualities, is a very resilient material, and possesses a very satisfactory degree of frictional adhesion when pressed against a cast-iron member. Asbestos fabrics are being applied in many forms of dry plate clutches and have been used to some extent in facing the male member of cone

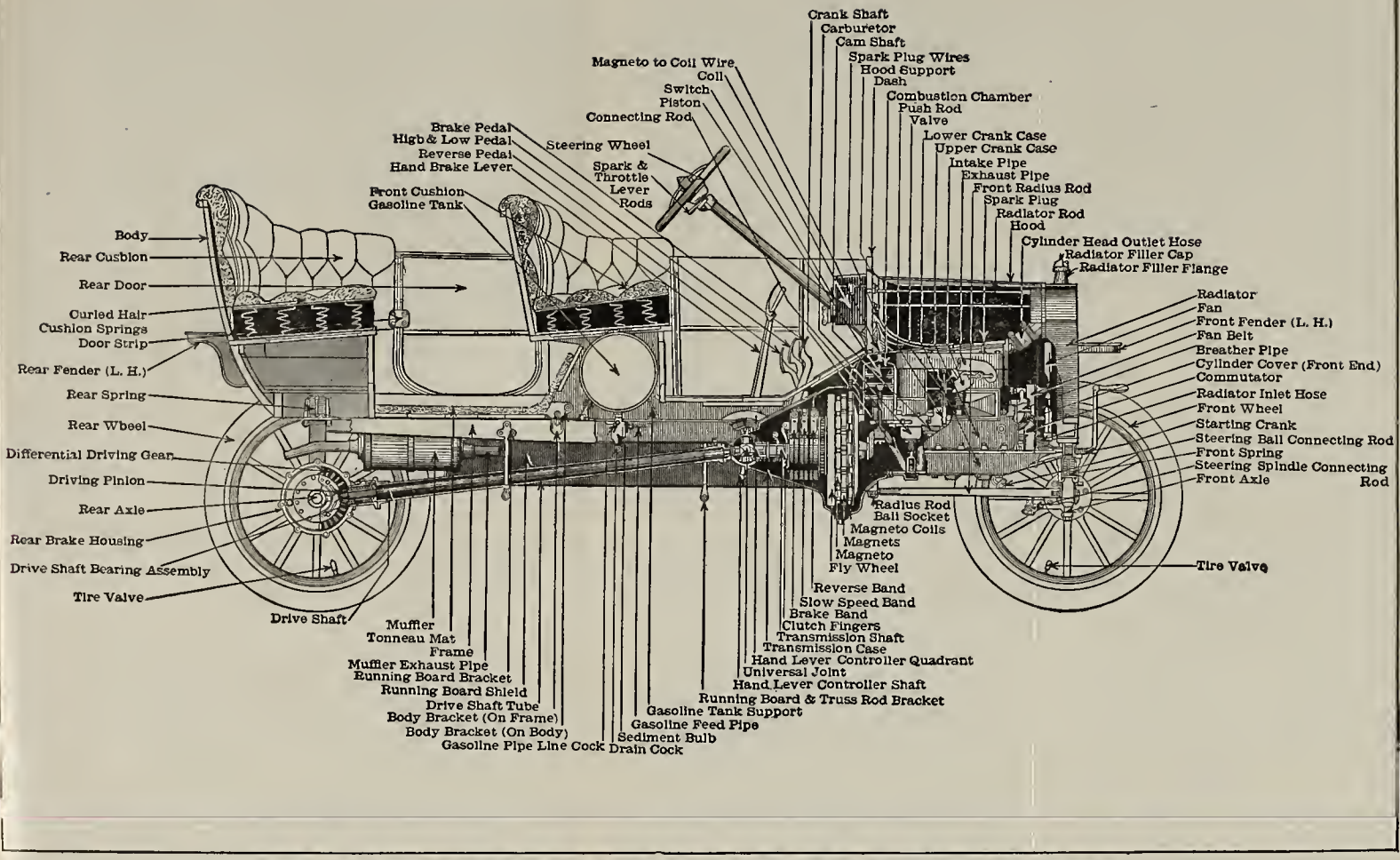


Fig. 468—Side Sectional View of the Ford Model T Motor Car, the Most Widely Used Automobile in the World.

clutches. These are not as elastic as leather and unless some auxiliary-relieving member is employed they will grip suddenly and undesirable harsh clutch action obtain.

When cork is used it is inserted in the metal surface in suitable holes which are machined to receive the inserts. Cork possesses peculiar qualities which make it very suitable for use in a clutch. It has perhaps the highest coefficient of friction of any of the materials employed, is not materially affected by either excessive lubrication or lack of it, and possesses very desirable wearing qualities. A clutch fitted with cork inserts will engage gradually and power will be transmitted to the rear wheels without shock or jar. It is the lightest and most elastic of the solids. In application cork must be used as an insert, because it is too brittle to be used in sheet form with any degree of success.

When applied to a clutch the cork always works alone at low or medium pressures and at high pressures the other surfaces become engaged. This is given as the reason for the excellent wearing qualities of such combination surfaces, and when corks form a relatively large proportion of one of the contact surfaces they prevent cutting, no matter whether there is lubricant present or not. Then again, in the presence of a lubricant, which would obviously cause slippage between plain metallic or other surfaces, the corks so largely increase the total frictional adhesion that slippage is almost impossible.

Opinions vary among designers regarding the most suitable materials to use, though the selection of frictional material depends in most cases upon the type of clutch used. The large majority who favor the cone clutch employ a leather and cast iron combination and in many cases cork inserts are also employed. Metal-to-metal surfaces are the rule in multiple-disk or plate clutches of small diameter, though as a general thing when a lesser number of plates of large diameter are used cork inserts or an asbestos fabric facing are invariably provided on one set of plates.

Forms of Cone Clutches Outlined.—A simple and efficient form of cone clutch is shown at Figs. 469 and 470, A. This consists of three main parts, the female member, which is machined integral with the fly wheel, a corresponding male member, which fits into it, and a spring to maintain contact between the surfaces. The fly wheel is attached to a flange forged integral with the end of the crank shaft by suitable screws. The male member is a truncated cone of metal faced with leather. The female member may be machined integral with the fly wheel, as shown at Fig. 470, A, or it may be applied to the fly-wheel rim by means of bolts, as outlined at Fig. 471.

Experience has demonstrated that cast iron and leather make a very good wearing combination, and the tendency to use cork inserts to prevent harsh engagement is growing at the present time. Plain metal-to-metal surfaces are not suitable with this form because they would grip too suddenly and would soon slip if there was a thin film of oil between the surfaces. It will be noted that in either case

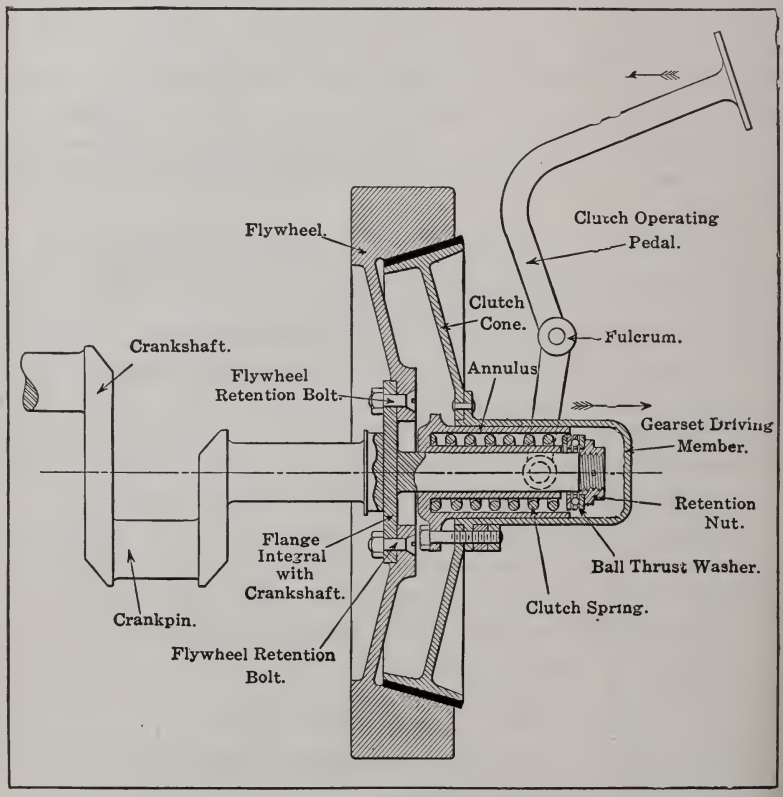


Fig. 469.—Sectional View of Cone Clutch Having Female Member Formed Integral with Fly-Wheel Rim.

frictional contact between the clutch cone and fly-wheel rim is maintained by the use of a coil spring which is backed by a ball-thrust bearing in order to relieve the operating mechanism of any torque strain when the clutch is disengaged.

In the cone clutch shown at Fig. 469, the male member is carried by a hub portion to which it is bolted, concentric with an annulus which bears on the crank-shaft extension. One end of the spring

bears against the closed end of the annulus while the other end is held by the ball-thrust washer and nut screwed on to the end of the crank shaft. The spring pressure in this case keeps the cone seated by pushing it directly toward the crank shaft. When it is desired

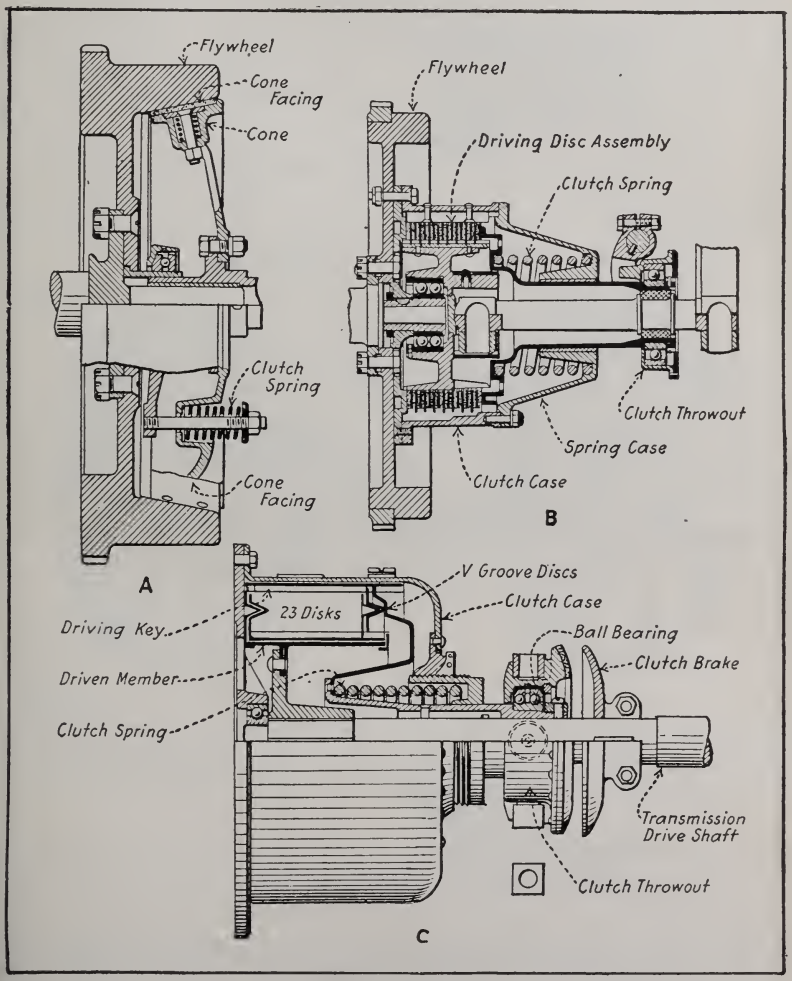


Fig. 470.—Diagrams Showing Different Clutch Types. A—Simple Cone Clutch. B—Multiple Dry-Plate Type. C—Hele-Shaw Multiple-Disk Type.

to release the clutch the operating pedal is depressed in such a manner that it swings on the fulcrum point and moves the clutch cone and the annulus member by which it is supported back so the clutch cone is pulled away from the fly wheel and the spring compressed. Some

form of Oldham coupling or sliding joint is carried by the gearset driving member and is attached to the shaft extending from the gear case. When the spring pressure forces the clutch cone into engagement with the fly wheel, the assembly turns as a unit and the gear-

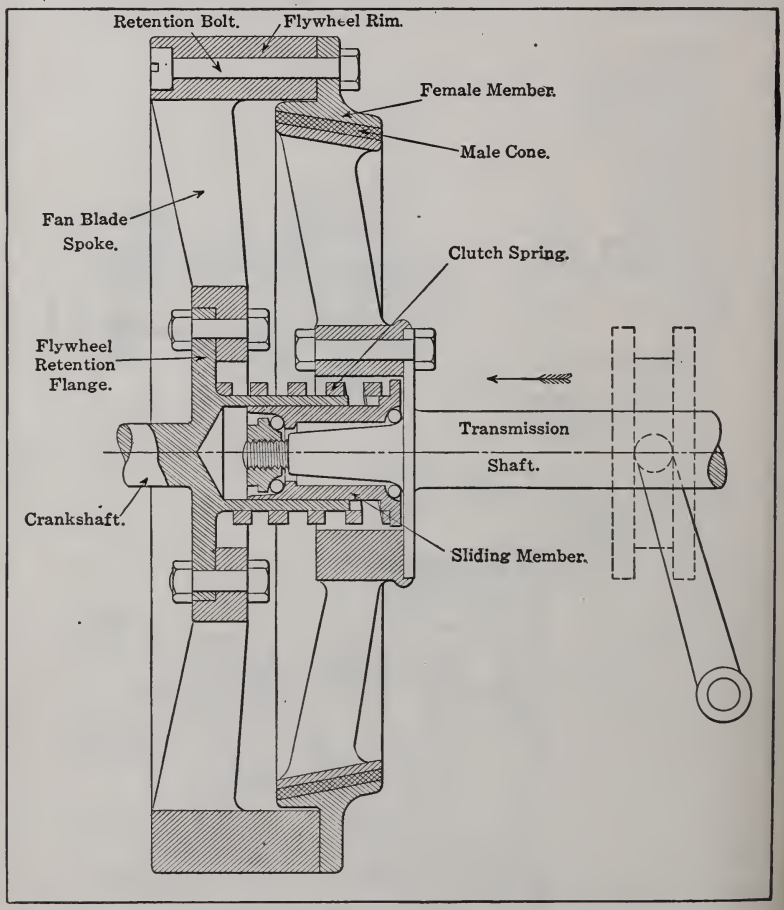


Fig. 471.—Cone-Clutch Design with Female Member, a Separate Casting Bolted to Fly-Wheel Rim.

set is driven by the engine crank shaft through the medium of the clutch and the gearset driving member which is attached to the clutch cone. When the cone is pulled away from the fly wheel the annulus which carries the gearset driving member remains stationary and the crank-shaft extension revolves in it.

The clutch outlined at Fig. 471 differs from that previously shown in that the cone is inverted and the spring pressure is employed to push the cone away from the fly wheel to engage it. The cone is carried at one end of the transmission shaft and revolves idly when it is pushed toward the fly wheel so that it is not in contact with the female member. In the cone clutch previously described the female member was machined in the fly-wheel rim. In that outlined at Fig. 471 the female member is a separate casting bolted to the fly-wheel rim.

How Leather Facing is Attached.—Typical designs of clutch cones and methods of fastening the friction facings to the cone castings or stampings are shown at Fig. 472. In that shown at A a combination

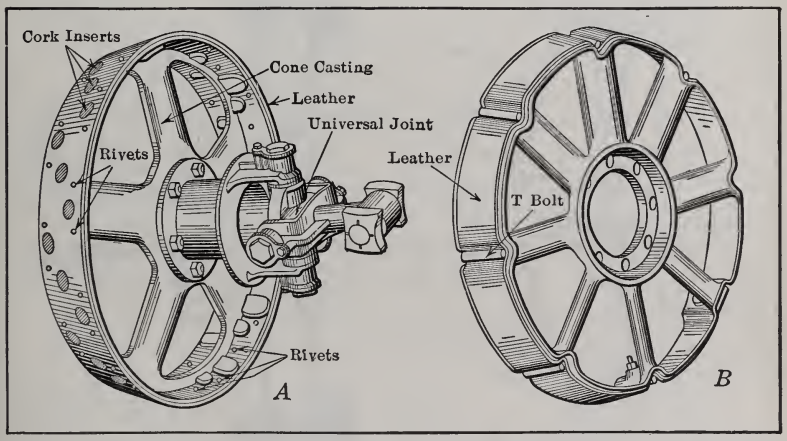


Fig. 472.—Typical Cone-Clutch Male Members, Showing Methods of Attaching Leather Facing to Cone Casting. A—Leather Facing Held with Rivets; Note Cork Inserts. B—White Cone Clutch with Facing Held by T Bolts.

of leather facing and cork inserts is employed. The leather is secured to the cast aluminum cone by means of rivets and the cork inserts are forced into recesses cast into the cone member. At B the practical method of retaining the leather facing of clutches employed on White automobiles is illustrated. When the leather facing is riveted to the cone rim considerable labor is involved in removing it after it has worn to such a point that replacement is necessary because the large number of rivets must be driven out before the leather can be removed. The leather band which forms the friction facing of the cone at B is held by a number of T head bolts which pass through the cone rim and which seat into longitudinal grooves cast into the periphery of the cone member. These are of sufficient depth to prevent the heads of

the bolts rubbing against the female member of the clutch and only the leather facing acts as a driving surface. When the leather becomes worn it is a comparatively simple matter to remove the T bolts and put a new leather band in place.

On some cone clutches of European design the endeavor has been made to use metal-to-metal surfaces by housing the cone in an oil-tight casing so that it worked in a bath of lubricant. The lower co-efficient of friction existing between lubricated surfaces is compensated for by increasing the spring pressure. Such a clutch is shown in section at Fig. 473, A. The clutch case is formed of two members,

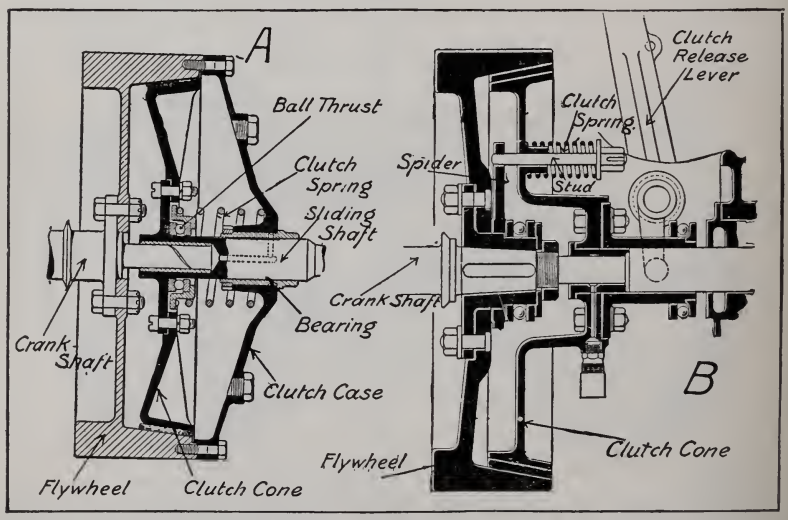


Fig. 473.—Cone Clutches of English Design. A—Metal to Metal Surfaces in Oil-Tight Case. B—Method of Holding Parts in Contact with Adjustable Springs.

one of these being the fly wheel, which is attached to the crank-shaft flange by bolts, the other is a cast casing, which is bolted to the fly-wheel rim on its face. The clutch cone is attached to a sliding shaft which telescopes on to the projecting end of the crank-shaft extension and which slides through an oil-tight bearing carried by the clutch case which is bolted to the fly-wheel rim. The spring thrust is taken at one end by the clutch casing and bears against a ball-thrust washer which seats against the flange to which the clutch cone is attached. The female member is machined in the fly wheel and does not differ from conventional forms.

Another form of English derivation is shown at Fig. 473, B, this

differing from those previously described only in the method of applying the spring pressure. A three-arm spider carries three studs spaced at 120 degrees which also pass through bosses on the clutch cone. The spider is kept in place by a ball-thrust bearing retained on the fly-wheel hub by a clamping nut screwed on a thread cut at the end of the fly-wheel-retaining member which serves to keep the fly wheel in place, as well as forming a backing for the thrust bearing. The studs which project through the clutch cone have nuts threaded on the outer ends, and a spring is mounted outside of each clutch cone boss in such a way that it presses against the nut on the end of the stud and presses the cone into engagement with the fly wheel. The drive is interrupted by pulling the cone out of engagement in the usual manner.

One of the disadvantages of the cone clutch, unless it is exceptionally well designed, is that it is likely to engage harshly if the leather facing becomes charred or hard from any other cause. When cork inserts are used in connection with the leather, a more gradual engagement is secured, even when the leather is dry, than would be possible without their use. Some designers have sought to secure easy engagement by using a number of auxiliary friction pads attached to the cone periphery, while others have been satisfied to use springs under the clutch leather which would raise it at a number of points around the periphery of the clutch cone. The object of this is to have a limited area of the leather surface engage the female member before the full spring pressure is exerted to bring the entire frictional surface in contact.

The clutch shown at Fig. 474, which has been used on Columbia automobiles, is a conical type having a number of auxiliary friction pads extending through the periphery of the cone and projecting slightly above its surface. These are kept in place by auxiliary springs of the coil type. When the clutch cone is first engaged these friction shoes will engage the surface of the female member at a number of points and then when full spring pressure is exerted it will overcome the resistance of the small radial springs and the friction blocks will be depressed so they will be flush with the surface of the male member which then takes the drive. In the Overland cone clutch, which is shown at Fig. 470, A, small spring-backed plungers are placed under the leather facing to secure gradual engagement.

The cone clutch is one of the most popular forms and has received general application, and its simple construction enables the motorist to easily understand its action. As there are but few parts there is

but little liability of the cone clutch giving trouble if the leather surface is kept in proper condition. The chief disadvantage advanced against cone clutches is that they are more bulky than other forms of equal capacity. The large size of the members of a cone clutch tend to make it "spin" after it is disengaged. The natural tendency of a body in motion is to continue in motion until stopped by some external force, which property is known as "inertia."

If two wheels of the same weight are set in motion by the expenditure of equal amounts of energy the one that has the weight carried nearer the rim or which is larger in diameter will revolve the longest.

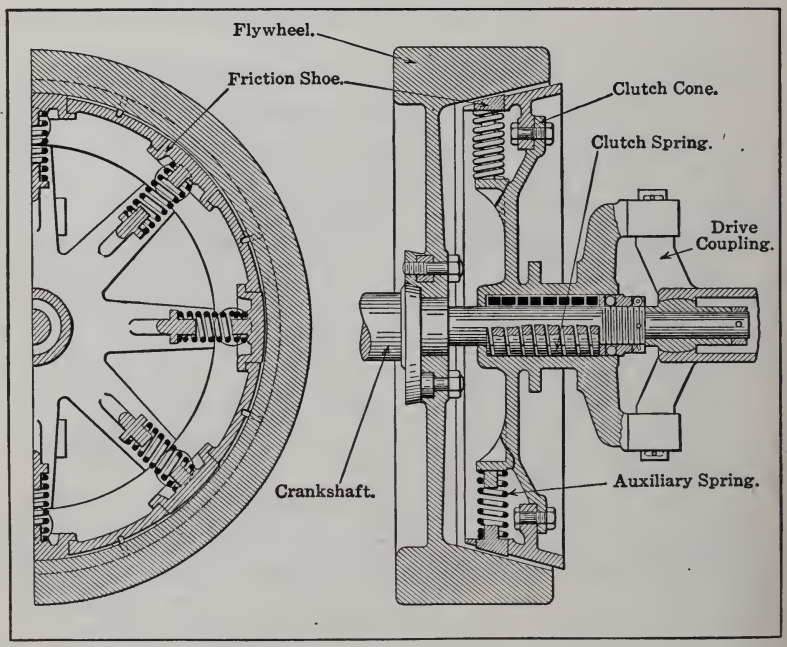


Fig. 474.—Cone Clutch Employing Friction Shoes to Grip Fly-Wheel Before Cone is Fully Engaged and Designed to Secure Gradual Application of Power.

The male member of a cone clutch, when released, will have a tendency to continue to revolve even when the driving pressure is relieved. When sliding gearsets are employed to obtain the various speed ratios it is imperative that the engine be entirely disconnected from the main shaft of the change-speed gearing before any attempt is made to shift the gears. If the sliding members are moved without first disconnecting the shafts from the engine it would be very diffi-

cult to engage them and it might result in stripping the teeth from the gears.

The average cone clutch is of large diameter if much power is to be transmitted because the two surfaces in contact are comparatively narrow. When the clutch is released considerable energy has been stored in the rim of the cone and its tendency is to keep revolving and carry the shaft of the gearset to which it is attached at the same speed. In some cases it is difficult to shift the gears until the motion of the shaft ceases and it is either necessary to wait until the momentum of the clutch cone becomes less or to apply some form of brake which will stop the cone from rotating. Such brakes are usually interconnected with the foot pedal and act only when the clutch is fully disengaged. A brake of this nature is shown in the disk clutch design at Fig. 470, C. The clutch brake disk attached to the driven shaft comes in contact with the fixed member on the non-rotatable clutch throwout housing and prevents any tendency of the clutch-driven member group to rotate after its frictional contact with driving plates is broken.

Cone-clutch efficiency depends on a number of factors, chief among which is the angle of the cone. The greater the angle the more spring pressure required because the wedging effect of a large angle is not as pronounced as when more gradual tapers are employed. Most cone clutches have the cone tapering at an angle of 12½ degrees and it is not considered good design to use a lesser angle because the wedging effect may make it extremely difficult to release the clutch. At the other hand, angles much greater than 15 degrees make it necessary to use excessive spring pressure to maintain proper frictional adhesion between the parts.

Three- and Five-Plate Clutches.—A number of cars are provided with clutches composed of three or more plates of large diameter instead of the use of two cone members. It is claimed that these forms make for very easy engagement and that they will give a very prompt releasing action when the surfaces are separated. The usual construction is to use two driving members which are carried around by the fly wheel which clamp against a central-driven member which drives the gearset shaft. These clutches are very effective, but one of the chief disadvantages is the same as that advanced against the cone clutch and that is the inertia of the driven member when released. When these clutches are fitted it is desirable that they be provided with some form of a brake to bring them to a stop as soon as disengaged.

A three-plate clutch which has been used successfully on Knox

automobiles is shown at Fig. 475. In this construction the clutch springs are spaced at equal distances around the periphery of the fly wheel and bear against a pressure plate which is carried around by studs placed just outside the springs. Two driving plates are provided and these clamp a single-driven member attached to a revolving sleeve to which the gearset driving shaft is keyed. The pressure of the springs against the pressure plate holds the driven plate firmly against

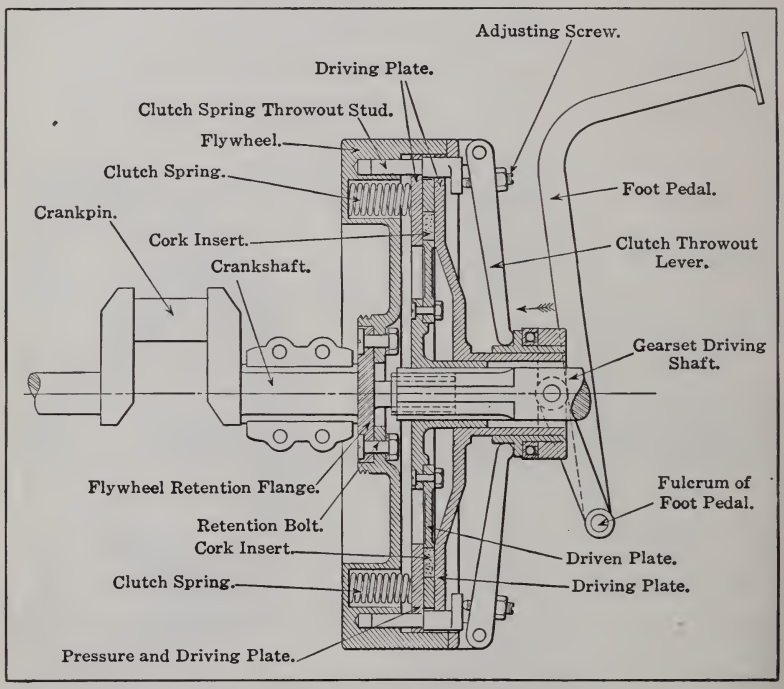


Fig. 475.—Three-Plate Clutch Utilized on Knox Motor Cars Uses Central-Driven Plate Studded with Cork Inserts.

the outside driving plate. When it is desired to release the clutch the pedal is depressed and it pushes the clutch throw-out levers toward the fly wheel so the clutch spring throw-out studs push the pressure plate away from the driven plate and allow it to revolve independent of the clutch. The clutch throw-out studs perform a double duty in that they also act as driving members for the two driving plates. The driven plate is provided with a large number of cork inserts to increase its frictional adhesion.

Another form of three-plate clutch in which there are two driven plates and one driving member is shown at Fig. 476. The driving

plate is carried around by a number of studs spaced around the fly-wheel-rim face. The driven member nearest the fly wheel carries a number of arms to which small bell cranks are fulcrumed. These arms also act as a support for the outer driven plate. The clutch spring bears against a sliding member which forces the ends of the bell crank to which it is connected by a series of toggle links outwardly, and clamps the driving plate firmly between the inner and

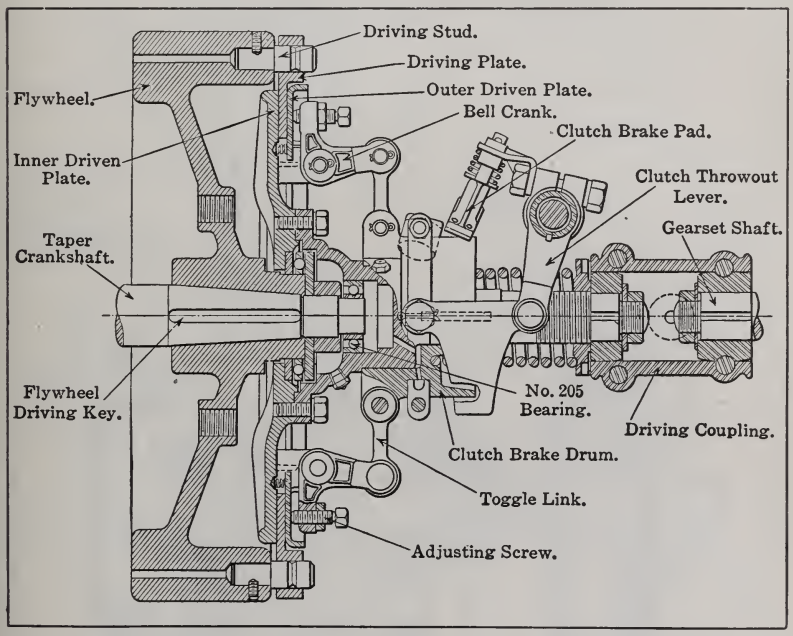


Fig. 476.—Three-Plate Clutch Equipped with Friction Brake to Arrest Motion of Driven Member when Clutch is Released.

outer driven plates. When the clutch spring is depressed the bell cranks drop back and the pressure between the driving plate and the faces of the driven members is relieved. When this condition exists the driving plate turns with the fly wheel but does not produce movement of the driven members to which the gearset shaft is attached by a semi-universal driving coupling. When the clutch throw-out lever is moved away from the fly wheel to release the clutch it brings a small brake pad in contact with a drum carried by the driven member and stops its rotation. When the parts are as shown in illustration, the driving plate is firmly clamped between the driven members and the power of the engine is being transmitted directly to

the gearset shaft. A very popular type of three-plate clutch, known as the Borg & Beck, is shown at Fig. 477. The spring pressure is compounded by an ingenious combination of bell crank levers carrying rolls which slide on a wedge-shaped driving plate, the latter still further increasing the pressure upon the asbestos fabric-faced driven

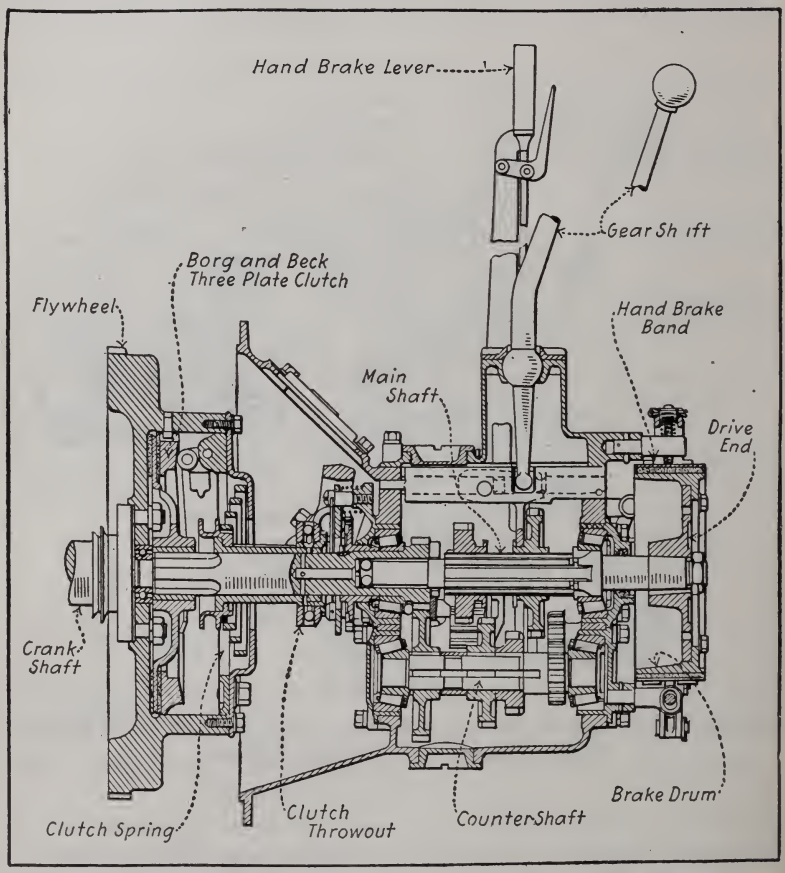


Fig. 477.—Typical Gearset and Clutch Assembly, Showing Borg & Beck Three-Plate Clutch and Three-Speed Sliding Gear Selective Gearset.

disk because of the wedging action due to the gradual angle of the inclined plane on which the roll acts. The clutch is shown mounted with a three-speed gearbox of the latest type.

In order to obtain more driving surface some designers have used five plates instead of three. A five-plate clutch which operates on the same general principle as the three-plate type previously de-

scribed is shown at Fig. 478. In this, two driving plates are carried by studs set into the fly-wheel face and the three driven members are kept in engagement by means of bell cranks and toggle-link action. The reason that five disks are used instead of three is that the aug-

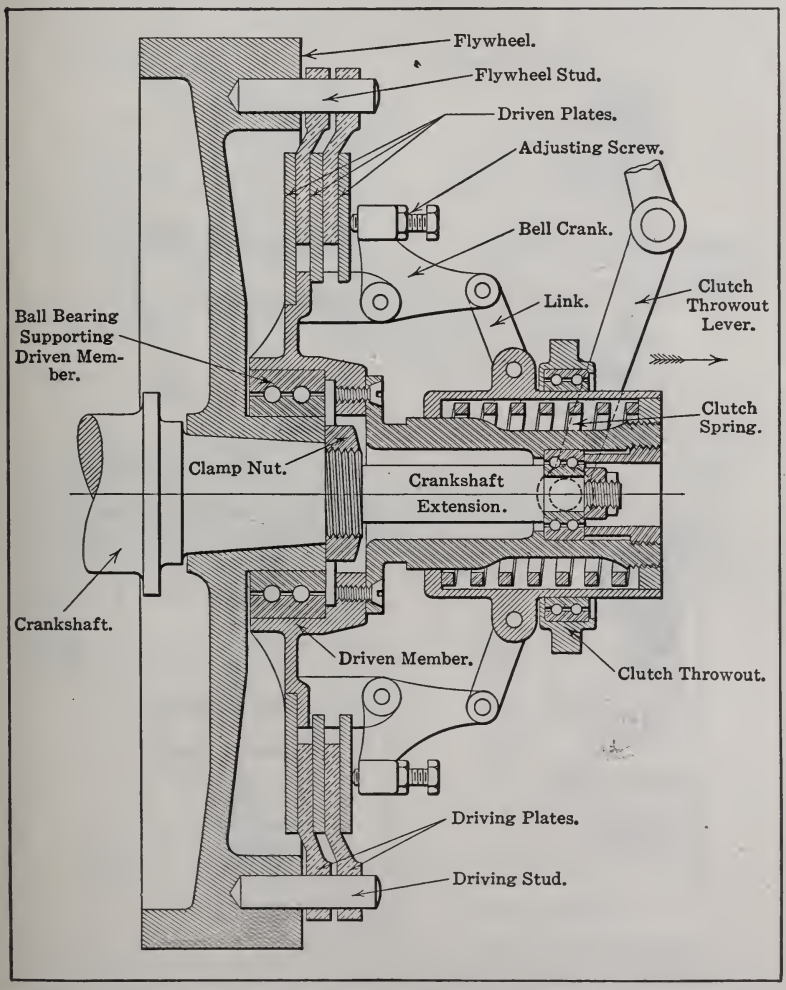


Fig. 478.—Five-Plate Clutch, which Employs Two Driving Members Attached to Fly-Wheel and Three Driven Plates.

mented surface makes it possible to reduce the spring pressure to some extent and makes for easier operation when it is desired to disengage the clutch. When the driving contact between the clutch plates is interrupted the member to which the gearset shaft is

attached is kept stationary and the fly-wheel hub and crank-shaft extension revolve freely because anti-friction bearings of the ball type are interposed between the members.

Features of Multiple-Disk Clutches.—Power transmission by plates is sometimes accomplished by using a large number of small diameter

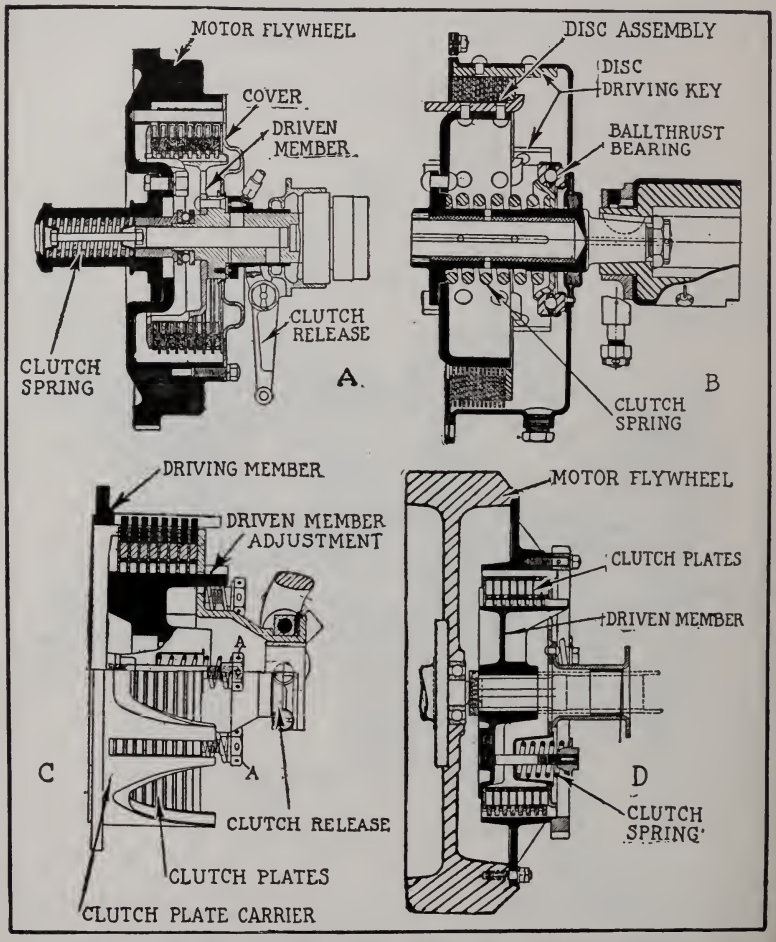


Fig. 479.—Group Showing Multiple Plate Clutches Used Successfully on Modern Automobiles.

disks instead of the smaller number of large plates. The multiple-disk type offers several advantages not found in other forms, as it is the most compact form of clutch. The required contact area is obtained by using a multiplicity of comparatively small surfaces in

preference to two large ones as is the case with the cone clutch or the greater number possible when three- or five-plate clutches are employed.

The type of multiple-disk clutch that was most widely employed consisted of a number of soft steel disks which sometimes alternated with others of different material, such as phosphor bronze.

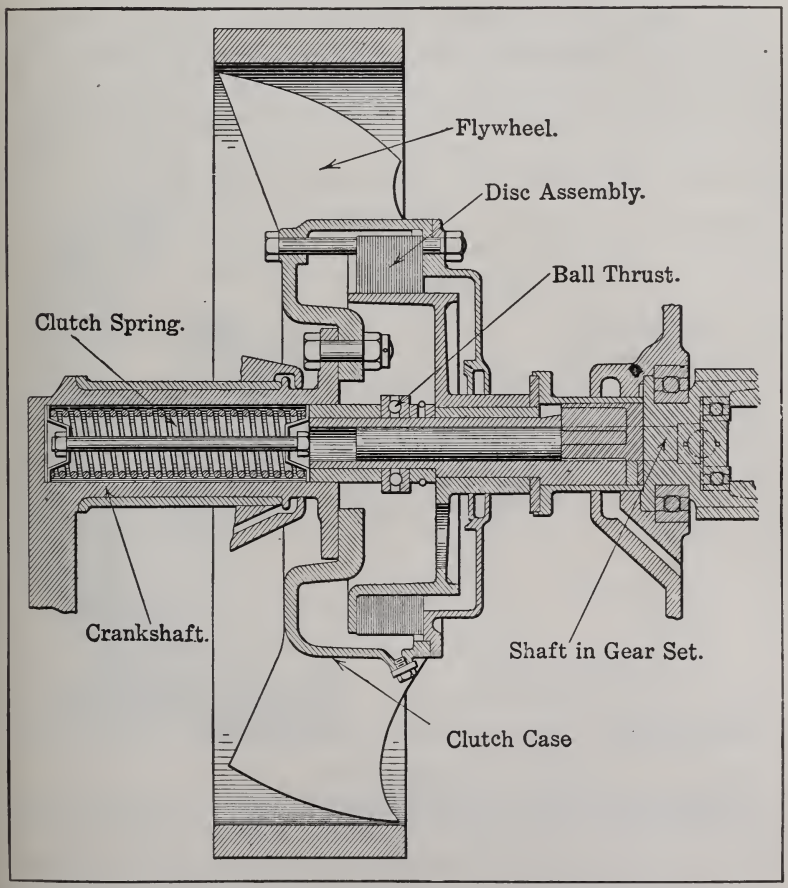


Fig. 480.—Typical Multiple-Disk Clutch Assembly Used on Early Hudson Cars.

One set of these disks is driven by the engine while the remaining plates are attached to a floating member to which the transmission shaft is joined. Pressure is usually obtained from a coil spring which acts against one of the disks, which in turn acts upon the neighboring one. It is common practice to house a clutch of this type in an oil-tight case, which insures that the members will always

be kept in an oil bath. Oil performs the dual function of securing easy engagement by interposing a cushion between the metal elements and also to prevent wear because of its value as a lubricant. This type of clutch has been practically relegated to the background, and the dry plate type of the designs shown at Fig. 479, C and D, is now the preferred construction. The multiple disk in oil type, as shown at Fig. 479, B, is not used as much as it used to be.

As multiple-disk clutches are usually of small diameter, the inertia of the driven member is small compared to that of a cone or large plate type, and the spinning tendency is reduced. The spring pressure is usually sufficient to squeeze the oil from the plate as soon as

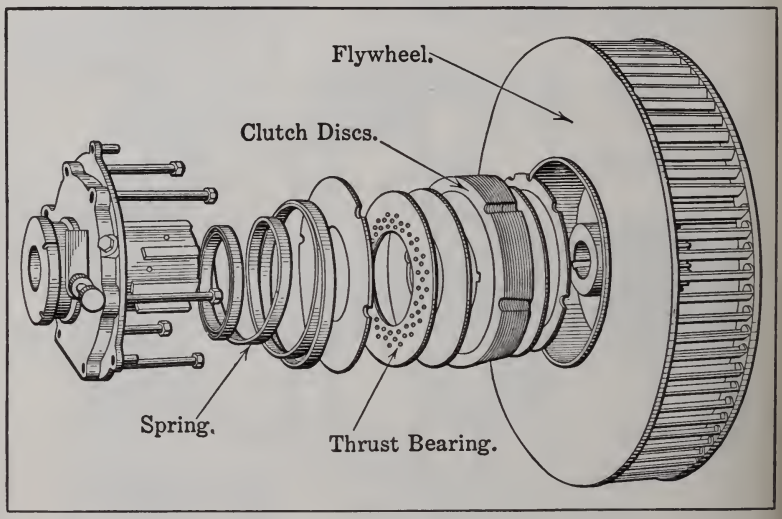


Fig. 481.—Multiple-Disk Clutch Utilized in Franklin Automobiles is Housed in Blower Fly-Wheel. Parts are Shown Separated to Make Construction Clear.

engagement is fully made and a metal-to-metal contact then obtains. The fact that the lubricant is gradually forced out and that there will be a certain amount of slipping as long as any of the lubricant remains means that the power will be applied in a gradual manner even if the clutch is carelessly operated.

While a multiple-disk clutch does not have a tendency to spin because of inertia, the plates may sometimes refuse to disengage because of a partial vacuum existing between them, produced when the oil film was forced out. This sometimes causes the plates to adhere together. This trouble is rare in well-designed clutches and is seldom present unless poor lubricating oil is used between the plates.

This drag and consequent trouble in shifting gears is more apt to occur on forms which employ flat-stamped plates without spring tongues to separate them when the spring pressure is relieved. Multiple-disk clutches are sometimes provided with plates having cork inserts, while others have a number of the disks faced with some friction material such as the asbestos-wire fabric and are designed to run dry instead of in an oil bath.

A typical multiple-disk clutch is shown at Fig. 480. In this member the clutch case is cast integral with the fly wheel and forms the fly-wheel hub. A series of disks are carried by a driving drum and are kept in engagement with those carried around by the fly wheel by means of pressure derived from a coil spring which is let into a bored-out recess at the end of the crank shaft. The clutch depicted is intended to run in oil and a number of the plates are provided with cork inserts. The multiple-disk clutch depicted at Fig. 481 is that used on Franklin cars, and is a form in which all

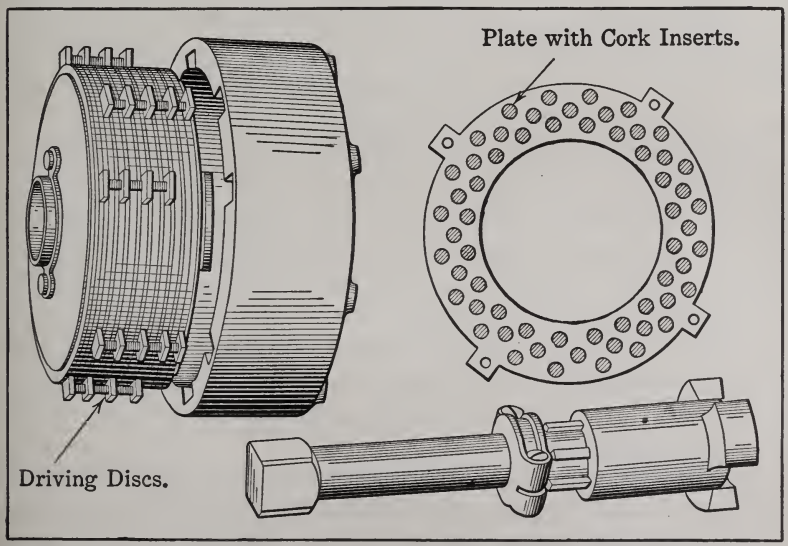


Fig. 482.—Clutch Using Multiple Plates Studded with Cork Inserts Acting Against Plain Metal Plates.

metal plates running in oil are used. That depicted at Fig. 482 is used on Premier cars and one set of plates is provided with a large number of cork inserts to promote easy engagement, positive drive, and prompt release.

While the clutch forms described are the most common, a few

cars have been provided with internal expanding band clutches or external constricting band forms. The internal member consists of a steel band or shoe faced with leather or other frictional material or provided with cork inserts which expand against the inner periphery of a drum integral with the fly wheel. The band is expanded by spring pressure which spreads the driven member either by toggle linkage or a right and left hand quick-acting screw.

Planetary gearsets employ external constricting bands to stop rotation of the gear drums, but these should properly be considered under the head of brakes rather than clutches. The disadvantage of either internal or external band clutches is that they are very hard forms to balance and the internal expanding band is especially susceptible to the influence of wear and oil between the surfaces. The external band provides a very gradual clutching action, but owing to the difficulty in balancing it because of the unsymmetrical operating mechanism usually employed, it has not been used to any extent in this country. With the forms described no difficulties are present as relates to balancing, and as the band forms have no apparent advantages when compared to the better developed cone and plate types there seems to be no reason for further development of forms which are good in theory but hard to apply in a practical manner.

Why Change-Speed Gearing is Necessary.—Those who are familiar with steam or electricity as sources of power for motor vehicles may not understand the necessity for the change-speed gearing which is such an essential component of the automobile propelled by internal combustion motors. In explaining the reason for the use of the clutch it has been demonstrated that steam or electric motors were very flexible and that their speed and consequently the power derived from them could be varied directly by regulating the amount of energy supplied from the steam boiler or the electric battery, as the case might be.

If, for example, we compare the steam motor with the explosive engine it will be evident that the power is produced in the former by the pressure of steam admitted to the cylinders as well as the quantity and the speed of rotation. When the engine is running slowly and a certain amount of power is needed more steam can be supplied the cylinders and practically the same power obtained as though the steam pressure was reduced and the engine speed increased. The internal combustion motor is flexible to a certain degree, providing that it is operating under conditions which are favorable to accelerating the motor speed by admitting more gas to the cylinders. There is an arbitrary limit, however, to the power

capacity or the mean effective pressure of the explosion, and beyond a certain point it is not possible to increase the power by supplying vapor having a higher pressure as is possible with a steam engine.

In an explosive motor we can increase the power after the maximum throttle opening has been reached only by augmenting the number of revolutions. Whereas it is possible to gear a steam engine or an electric motor directly to the driving wheels, it is not possible to do this with a gasoline engine, and some form of gearing must be introduced between the motor and the driving wheels in order that the speed of one relative to the other may be changed as desired and the engine crank shaft turned at speeds best adapted to produce the power required, and to allow the rear wheels to turn at speeds dictated by the condition of the roads or the gradients on which the car is operated.

It is customary in all automobiles of the gasoline-burning type, where combustion takes place directly in the cylinders, to interpose change-speed gearing which will give two or more ratios of speed between the engine and the road wheels. As it is not possible to reverse the automobile engine utilized in conventional cars, it is necessary to add a set of gears to the gearset to give the wheels a reverse motion when it is desired to back the conveyance.

Many methods of varying the ratio of speed between the engine and traction members have been evolved, but few speed-changing mechanisms have survived. At the present time the majority of automobile makers employ sliding gear transmissions which are almost invariably of the selective type. One or two makes are fitted with simple face-friction gearing and but one maker provides two forward speeds and a reverse motion by using planetary gearing.

Face-Friction Gearing.—A form of gearing that now has few adherents, but which was popular because of its simple design and easy operation, employs two friction disks which are held together by sufficient pressure to cause one of these members to turn the other. This was one of the earliest forms of gearing used, and while it was abandoned for a time because of defects of a purely technical nature continual experiments made possible a combination of materials which gave satisfactory results in practice.

The rolling traction, or friction transmission, as it is commonly called in its simplest form, is shown at Fig. 483, A. It consists of two disks or plates, one faced with an aluminum-copper alloy driven by the engine and a wheel which is provided with a strawboard fiber driving ring mounted on a cross shaft at right angles to the crank shaft of the power plant. The cross shaft is journaled in anti-

friction bearings and the driven disk or plate can be moved axially so as to engage with different portions of the aluminum driving disk. The driving member is mounted on a sliding shaft which can be moved toward the driven member and held in contact by a definite amount of pressure or pulled away when it is desired to interrupt the drive. In this manner both clutching and speed-changing functions are combined in one simple mechanism.

The method by which various speed changes may be secured is demonstrated at Fig. 483, B. The driven member is shifted across

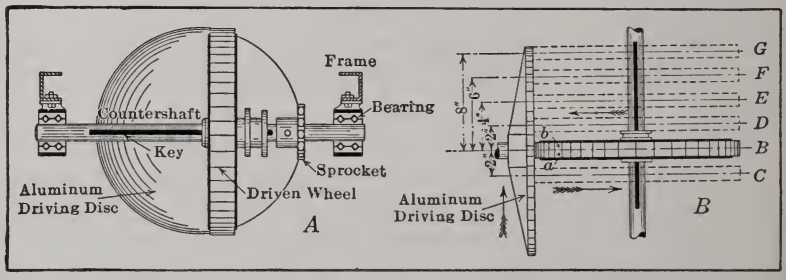


Fig. 483.—Outlining Action of Simple Face-Friction Gearing, which Combines Clutching and Speed-Changing Functions.

the face of the driving disk so it can engage different portions at varying distances from the center. As the wheel is moved from the center toward the outer periphery the speed ratios increase in proportion to the amount the disk is moved out. If the driven disk is moved over to the other side of the driving disk and past the central point a reverse motion will be obtained when driving contact is again established between the surfaces. To interrupt the drive the members are separated and when the faces are brought together the frictional adhesion permits one to drive the wheels.

Assume that both disks are sixteen inches in diameter and that the driven member has moved away from center until it engages a point having a mean radius of two inches from the center line. The disk would be moved from position B in which it is placed, as shown in illustration, to position indicated by the dotted rectangle D. In this case the driving effect would be just the same as though a four-inch diameter wheel was engaged with the sixteen-inch diameter driven member. This would give a low gear ratio because the engine would be turning at four times the speed of the driven member. If driving contact was again broken and the driven wheel moved along the shaft until it occupied the position indicated by the rectangle E,

the effect would be the same as though an eight-inch driving member was turning the sixteen-inch driven wheel. This would give a higher ratio than in the case previously described, as the engine shaft would only turn at twice the speed of the driven member.

If the driven member was moved so that it occupied position G, the highest speed would be obtained because the disks would be turning at equal speed as one sixteen-inch wheel would be turning another one of the same diameter. If the disk was moved back to the other side of center or from position B, to that shown by the rectangle C, the driven wheel would be turned at one-fourth the engine speed and in a reverse direction.

This form of gearing is not generally used for high-powered cars because the driving wheel must be of large diameter and very bulky to transmit the higher powers. The amount of energy it is possible to transmit efficiently depends upon the nature and size of the surfaces in contact and the amount of pressure which is exerted to bring the friction members together. When a friction transmission is used it is usually applied in connection with single- or double-chain drives to the rear wheels, though forms have been devised where driving by shaft and bevel gears is possible.

The application of a friction transmission to a shaft-drive chassis is shown at Fig. 484, A. In this the double-opposed motor is mounted so the crank shaft is at right angles to the frame side member while the cross shaft on which the driven disk slides is parallel with the frame side. The aluminum-alloy driving disk is attached directly to the fly wheel of the motor, while the fiber-faced friction wheel is carried on a countershaft so journaled that the entire shaft may be swung over and bring the driven disk in contact with the driving member. A shaft serves to connect the driven disk shaft to bevel gearing in the rear axle.

At Fig. 484, B, the method of installation when a double-chain drive is provided is shown, while at Fig. 485 the layout of a friction gearing employing single-chain drive is outlined. The relation of the parts to each other can be very easily understood by referring to the illustrations. In the system depicted at Fig. 485 the double-cylinder engine is placed in the frame in such a way that the crank shaft is parallel with the frame side member. The drive from the engine crank shaft is through a sliding coupling at one end of the shaft which carries the aluminum driving disk. This member is backed by a ball-thrust bearing which in turn forms part of a sliding sleeve or bushing connected to the small arm of a lever which is joined to the foot pedal. When the long arm of the lever is moved

in the direction of the arrow the sliding coupling is pushed in a reverse direction and the pressure exerted against the aluminum disk brings it in contact with the fiber-faced wheel on the countershaft. The driven wheel is moved along the countershaft by means of a long bell crank, the short end of which goes to the control lever while the long end is employed to swing the fiber-faced wheel along the countershaft. The drive from the countershaft is by means of chain and sprocket connection with a live rear axle.

In the form shown at Fig. 484, B, the rear axle is a stationary member and the wheels are driven independently by means of

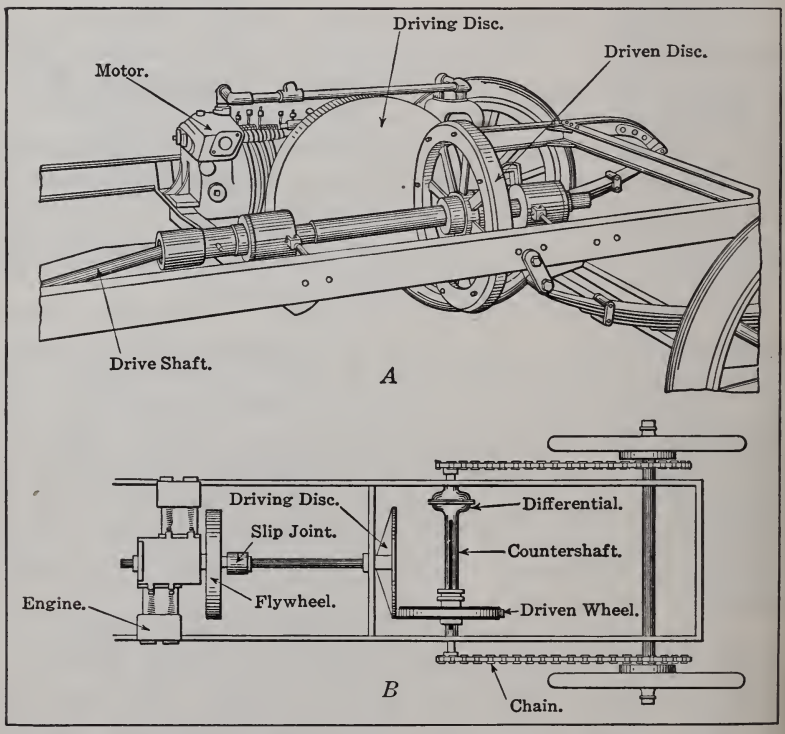


Fig. 484.—How Face-Friction Gearing is Installed in Motor Cars. A—Arranged for Shaft Drive. B—Power Transmitted to Wheels by Side Chains.

sprockets carried by the axle shafts of the compound countershaft, which is in reality a live axle mounted on the frame members and carrying the differential gear. As the power transmitted is directly proportional to the pressure maintaining contact between the surfaces it is imperative that the leverage employed to produce this pres-

sure be very substantial and rigid. Tests have demonstrated that the best combination of surfaces is a strawboard fiber driving ring against an aluminum or copper-alloy driving plate, and these are the materials commonly used.

This form of gearing has the advantage that it is easily handled by the novice and it is difficult to injure it by careless manipulation. The number of forward speeds provided are infinite, as the driven member may be moved across the driving face very gradually and engage driving circles which vary by small increments. The sur-

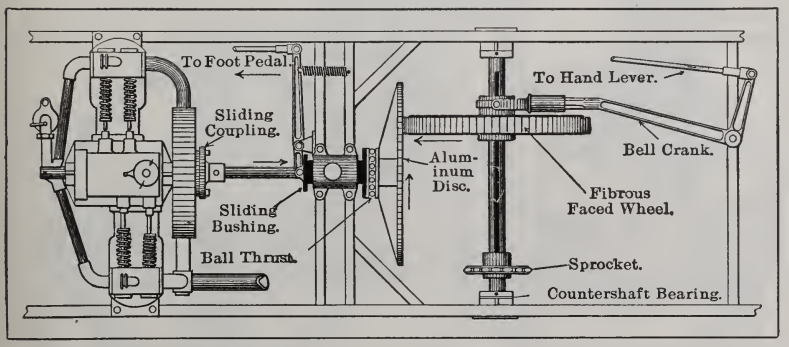


Fig. 485.—Disposition of Important Elements of Simple-Face Friction Gearing Adapted for Single-Chain Drive.

faces must be kept clean and free from grease or the gearing will slip, and for this reason this form is not so generally used as one might suppose, if its value was judged only by its simplicity and ease of operation.

How Planetary Gearing Operates.—The planetary or epicyclic transmission is an easily operated form of speed gear that has been very popular on small cars. This has many features of merit, it provides a positive drive, and as the gears are always in mesh these members cannot be injured by careless shifting. Individual clutches are used for each speed and as the operation of the clutch occurs at the same time that the desired speed is selected the various speed changes desired may be easily effected by manipulating a single lever if desired.

A typical planetary gearing of simple form which was formerly used on Oldsmobile cars, which were one of the earliest makes to be manufactured in large quantities, is outlined at Fig. 486. The gearing is carried in drums which are adapted to be revolved independently of each other or to be clamped by some form of clutch

which would cause them to revolve as a unit with the crank shaft. The drive is by single chain from a sprocket carried between the brake and reverse drum and the gearing was mounted on a crank-shaft extension which projected from the fly wheel of the motor. The drum nearest the fly wheel carries three pinions which mesh with an internal gear member secured to the sprocket and with a gear driven by the fly-wheel hub. The slow-speed drum is provided with

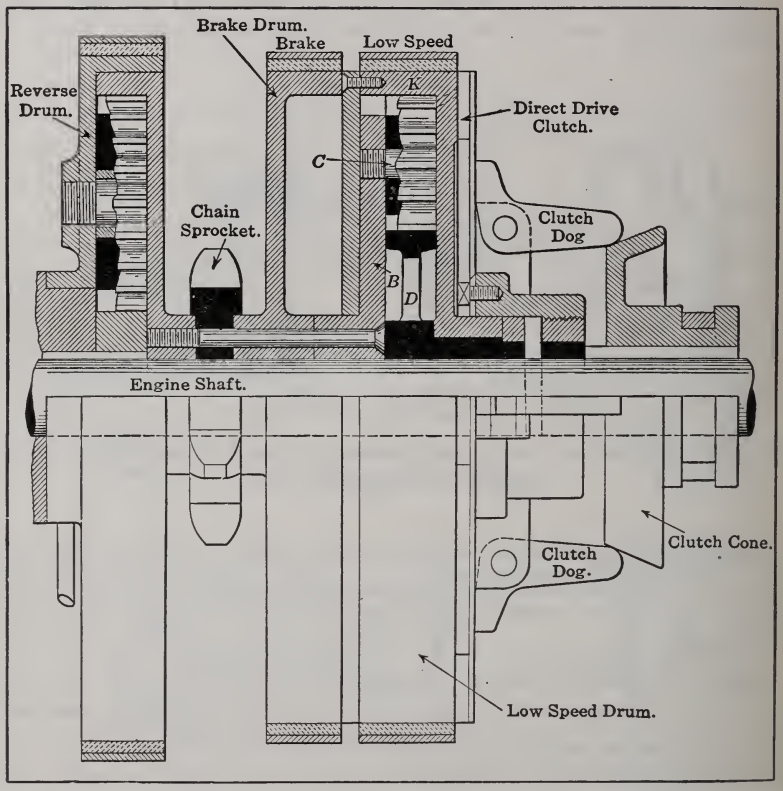


Fig. 486.—Sectional View of Simple Planetary Gearset Used in Early Automobile Design.

four pinions which are carried around by a disk which is also secured to the driving sprocket. In the reverse gear combination the disk that carried the pinions was provided with the brake member, while in the slow-speed gearing it was the internal gear which was held from turning when the slow-speed ratio was desired.

The master clutch, which provided the direct drive, consisted of four fingers provided with leather friction pads which were forced

against the face of the internal gear drum of the slow speed by means of clutch dogs expanded by a sliding cone. When the clutch cone was forced in so that the small bell cranks brought the friction pads in contact with the face of the slow-speed drum, the entire assembly was firmly locked to the crank shaft and a direct drive obtained as the sprocket turned at the same speed as the engine shaft.

The method by which the slow and reverse speeds may be obtained and the arrangement of the planetary gearing is clearly shown at Fig. 487. At A the slow-speed gearing is shown while the reverse gear

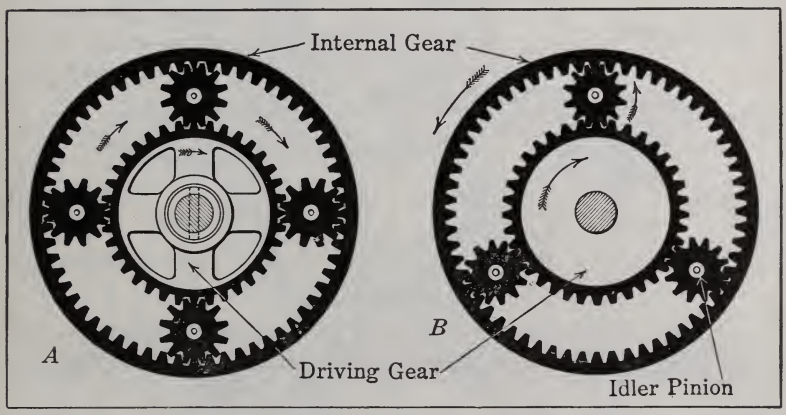


Fig. 487.—Demonstrating Action of Epicyclic Gearing. A—The Slow-Speed Gear Assembly. B—Gears and Pinions Used for Reverse Drive.

arrangement is outlined at B. The driving gear or center member in both cases is keyed to and turns with the crank shaft. With the combination shown at A, when the slow speed is desired the internal gear is kept from revolving by means of a constricting brake band which grips its outer periphery, and the small planetary pinions are forced to turn around on their supporting studs and carry the disk by which they are supported and which is attached to the driving sprocket in the same direction as the main driving gear, but at a slower speed. The gear reduction obtained depends upon the ratio of the driving and internal gear members.

When the reverse gearing is desired the mode of operation is different. The conditions are then as shown at B. In this case it is the disk carrying the pinion-supporting pins which is kept from rotating. The driving gear turns the idler pinions in a reverse direction, and these in turn cause the internal gear to which the

sprocket is fastened to turn in a direction opposite to that of crankshaft rotation and at considerably lower speed.

Other forms of planetary gearing have been evolved in which the internal gears have been eliminated and in which the gear ratios are provided by a train of spur gears. A gearset of this form is shown at Fig. 488, and as all parts are clearly indicated it will not

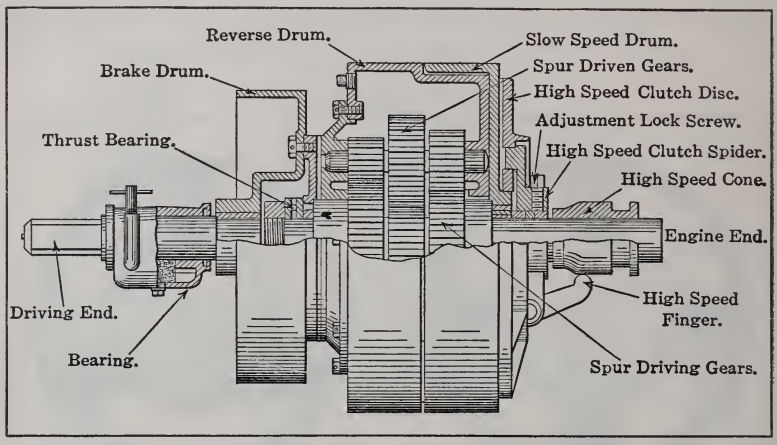


Fig. 488.—Planetary Gearing Utilizing Only Spur Gears Carried in Oil-Tight Case.

be necessary to describe its action in detail because it is very much the same as that of the form previously described. When the slow speed is desired a brake band is clamped around the slow-speed drum, and a similar member constricted around the reverse drum will give the reverse motion. The gearing is locked together by means of a face-friction clutch, which is pressed in contact with the slow-speed drum face by means of a high-speed locking cone and cone-operated dogs or bell cranks. The form shown is intended to work in connection with shaft drive, and a universal joint is attached to the squared driving end.

The planetary gearing shown at Figs. 489 and 490 is that used in Ford automobiles and its operation is similar to the forms previously described. In this mechanism, however, the master clutch which provides the direct drive is a multiple-disk form composed of steel disks, which are kept in permanent contact and proper driving relation by means of a heavy coiled spring. The low and reverse speeds are obtained in the conventional manner by tightening the external contracting clutch bands, which are shown between the gearing and disk clutch.

Planetary gearing has been very successful when properly designed and installed, and its chief disadvantage is that it is very difficult to provide more than two forward speeds and one reverse. For this reason it can only be adapted to light cars which have a surplus of power in the engine, or to light trucks where it is not so essential that a large number of speed ratios be provided as in touring cars. Such gearing is not efficient on low and reverse speeds as considerable

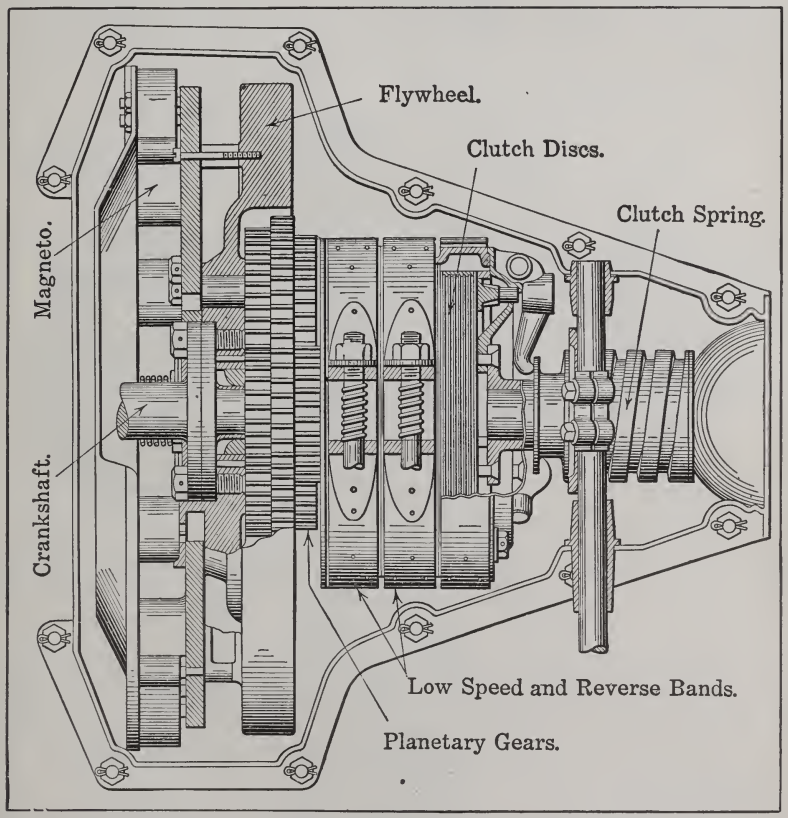


Fig. 489.—Two-Speed and Reverse Planetary Gear Employed on Ford Automobiles.

power is absorbed in friction, but when on the high speed or direct drive it is superior to any other form of change-speed gearing because the entire assembly is locked to the crank shaft, no gears are turning idly, and the weight of the gearing serves merely as an additional fly-wheel member. Considerable trouble was experienced with the early forms because it was difficult to keep oil in the case, but in mod-

ern forms special care has been taken in housing the reduction gears so these are constantly oiled, and both wear and noise, which were

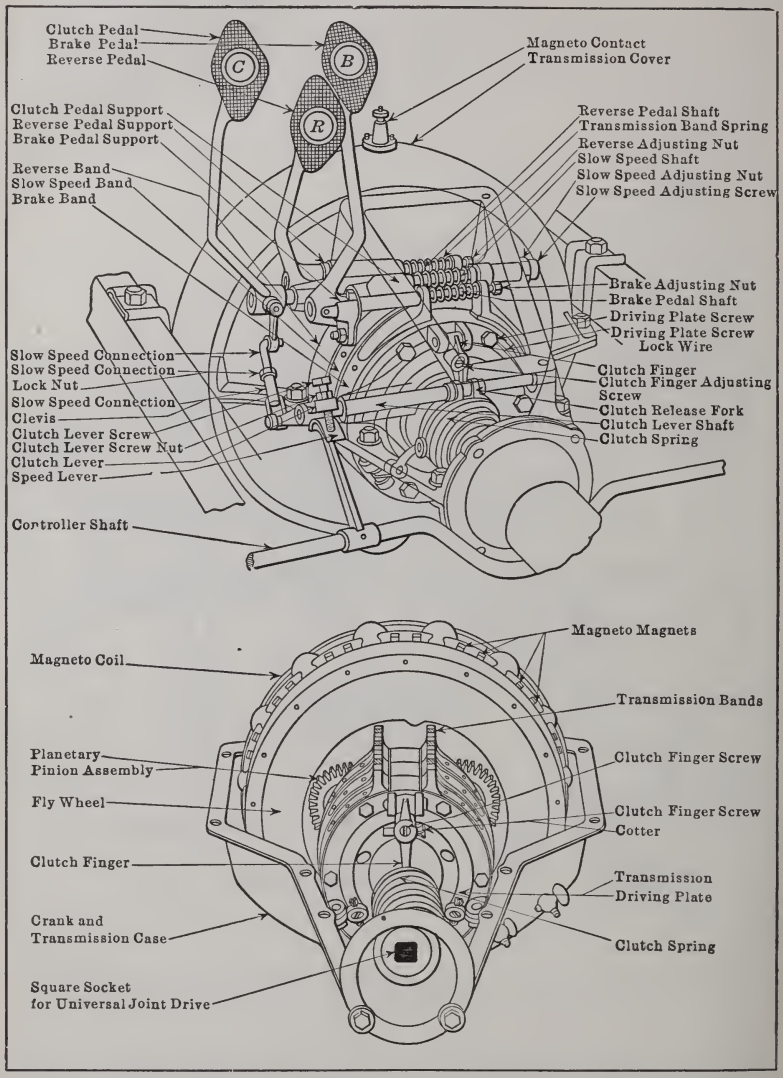


Fig. 490.—Illustrations Showing Method of Adjusting Clutch Bands of Ford Planetary Transmission.

formerly detrimental to the adoption of this form of gearing and which militated largely against its general use, have been eliminated.

However, the small three-speed sliding gearset is now almost universally used.

Individual Clutch Transmission.—A form of gearset which combines the good features of the planetary type in that the driving gears are always in mesh and which can be provided with any desired number of speed ratios is known as the individual clutch type. In gearsets of this form one set of gears is carried by the countershaft and is fixed thereto while another set of gears, with which these members mesh, revolve idly on the main driving shaft.

A transmission of this type which has been applied successfully in motor-truck design is shown at Fig. 491. In this the power is

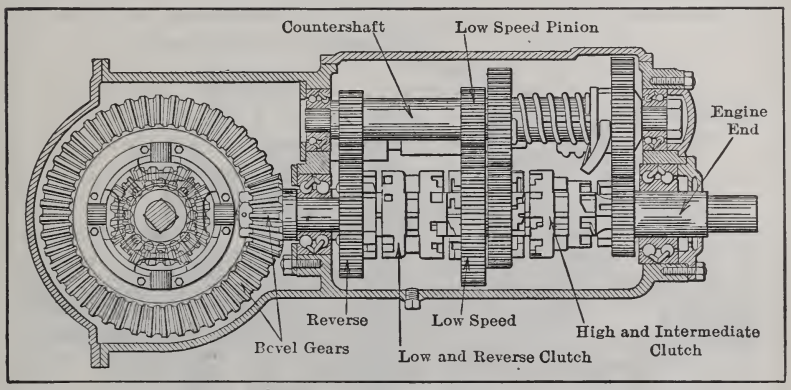


Fig. 491.—Part Sectional View of Cotta Individual Clutch Gearset Designed for Motor Truck Service.

delivered to a main shaft, which is supported on ball bearings and which carries a bevel pinion engaged with a bevel gear for driving the wheels at the rear end. The gears mounted on the main shaft are normally free to revolve independently from the shaft unless they are clutched to it by sliding positive jaw clutch members driven by the main shaft. Any desired speed ratio may be selected by engaging the gear desired by means of the clutch carried at its side, thus causing it to turn with the shaft.

When the clutches are placed as shown in illustration, the gears are neutral and the driving shaft turns without producing movement of the bevel driving gears. If it is desired to engage the low speed the low and reverse clutch member is moved toward the front end of the gearset until it clutches the low-speed gear to the main shaft. The power of the engine is then applied to the countershaft through the constant mesh gears at the extreme front end of the gearset

and as the main shaft is made in two pieces, the end of one member telescoping into the portion that carries the driving connection to the engine, the drive is back from the countershaft low-speed pinion to the big gear which has been clutched to the main shaft and which causes it to turn slower than the driving member attached to the engine.

To obtain a reverse ratio the low and reverse clutch is moved to the back end of the transmission and the reverse gear is locked to the main shaft. To obtain direct forward drive the high and intermediate clutch member is pushed forward until it engages the teeth on the side of the constant mesh gear. This operation locks both

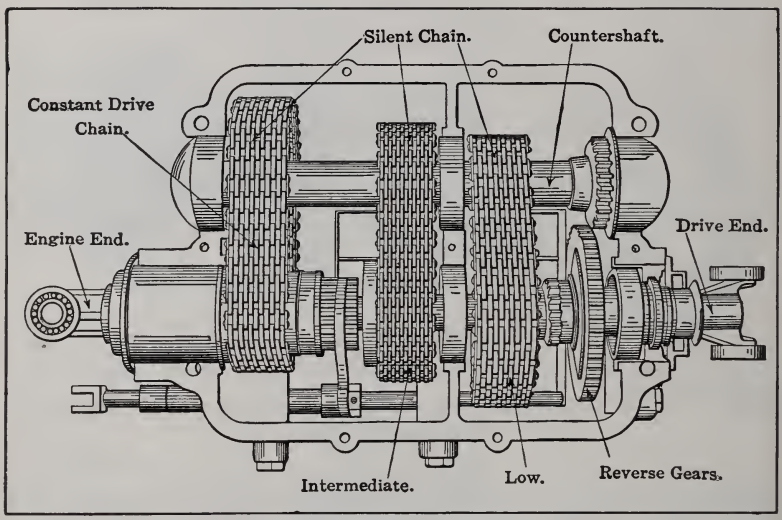


Fig. 492.—Individual Clutch Transmission Using Silent Chain Connection Between Main and Countershafts for Forward Speeds and Sliding Spur Gears for Reverse Action.

portions of the main shaft together and causes that part to which the bevel driving pinion is secured to turn at the same speed of rotation as the driving end which is joined to the engine. The clutches are arranged in such a manner that only one can be used at a time and in addition to the positive clutches carried in the gear case some form of master clutch, which is invariably of the friction type, must be provided between the power plant and the gearset.

There is a growing tendency to apply the silent chain to positive individual clutch types of transmissions instead of utilizing direct gear connection. The application of silent chains to a gear box is

shown at Fig. 492, and the sectional view which is shown at Fig. 493 makes the method of operation clear. The advantage of the silent chain when used in gear boxes of this character is that it provides a more silent drive than direct gear connection would. This is very valuable in the case of heavy, low-powered cars such as omnibuses and commercial vehicles, where the gearing is frequently used and where the vehicles are operated for the most part under traffic conditions which make noisy operation undesirable. The method of operation when silent chains are used is exactly the same as though the drive was by spur gearing.

Referring to the sectional view of the gear box given at Fig. 493, it will be seen that the power from the motor is delivered to a drive

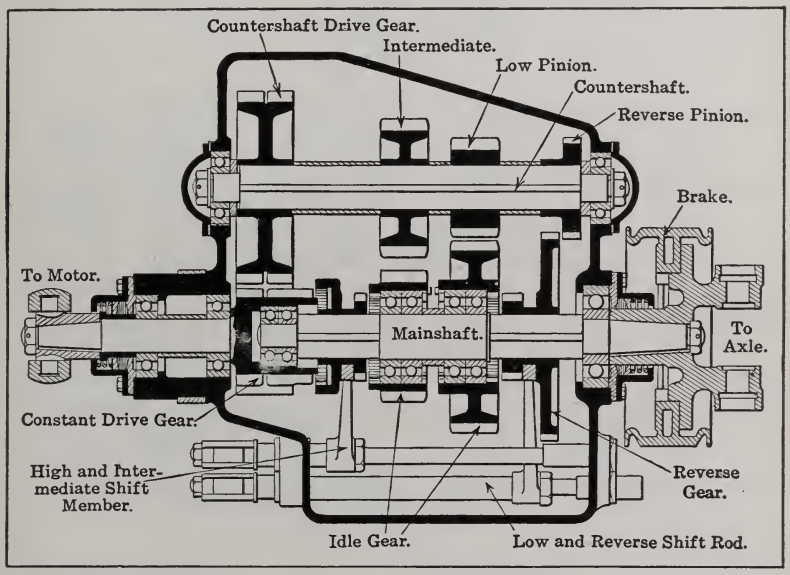


Fig. 493.—Sectional View of Individual Clutch Gearset with Silent Chains Removed to Show Arrangement of Gearing.

sprocket in the interior of which the end of the main shaft telescopes and which is supported by suitable ball bearings. The countershaft mounted above the main shaft carries four gears, three of which are adapted to use silent chains, while the smallest member is a clash gear of the conventional pattern, employed only to obtain reverse speed. It will be observed that two gear members are carried by ball bearings at the center of the main shaft in such a way that they revolve independently of that member unless they are clutched to it by the positive clutches keyed to the shaft.

To obtain the reverse drive the large reverse gear is moved back in such a way that it engages the reverse pinion on the countershaft. The drive in this case is from the motor to the constant drive gear, forming part of the main shaft which turns the countershaft drive gear by means of a silent chain which is not shown in this view but which can be very clearly seen at Fig. 492. The countershaft is turning in the same direction as the motor and the spur gears used at the back end of the gearset are employed to reverse the motion. When the low speed is desired the low and reverse shift member is moved in such a manner that the idle gear is clutched to the shaft. When this condition obtains the drive is from the

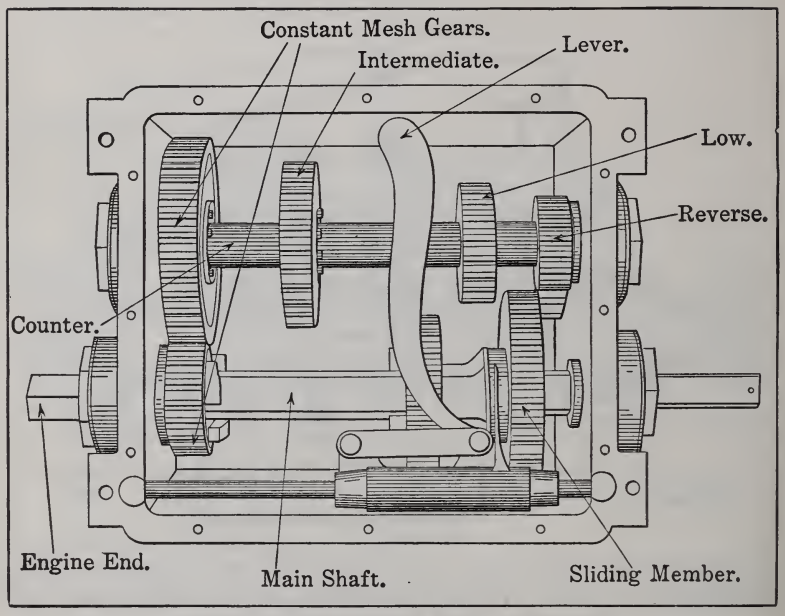


Fig. 494.—Arrangement of Gears in Progressive Shift Gearset.

motor through the constant drive gears and from the countershaft by the low-speed pinion and the big gear which has been clutched to the main shaft and which serves to drive the universal joint connected to the bevel gearing in the rear axle.

A movement of the high or intermediate shift member will give either of these speeds desired. The intermediate speed is obtained in exactly the same manner as the low speed except that the gear ratio is such that a higher ratio of drive is provided, while the high speed

or direct drive is obtained by locking the two sections of the main shaft together.

How Sliding Gearsets Operate.—The majority of change-speed gearsets which have been generally fitted to automobile service are

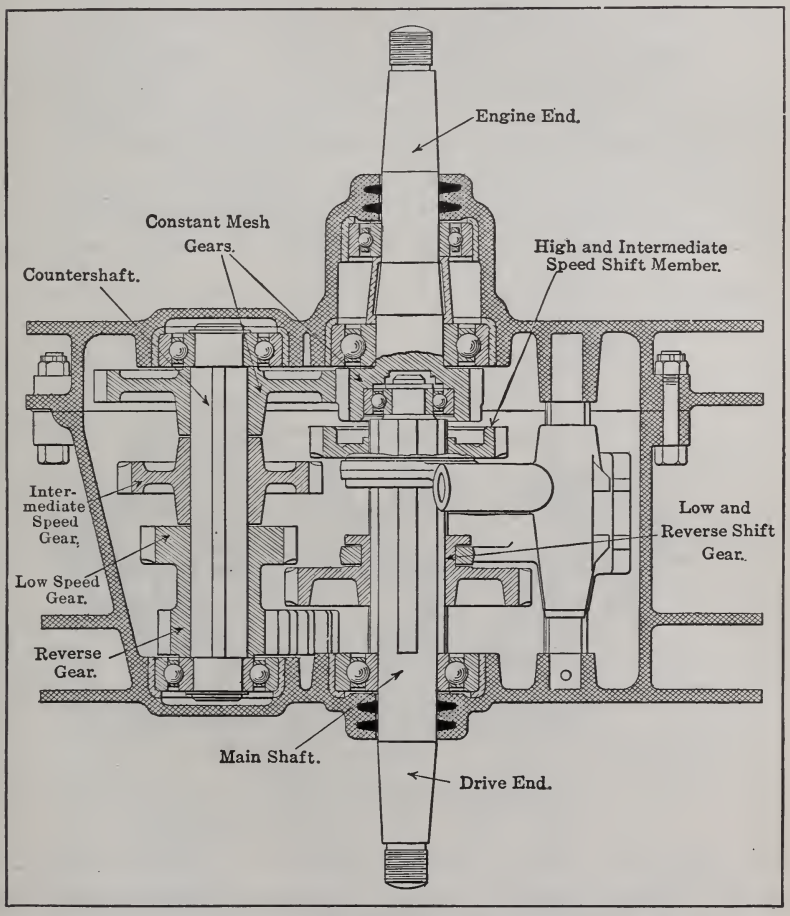


Fig. 495.—Showing Application of Two Shifting Members on Main Shaft of Selective Sliding-Gear Speed-Changing Mechanism.

forms of sliding gear arrangements and may be divided into two main classes. In progressive sliding gearsets but one member is employed for all speeds and this is shifted along from one extreme position to the other. In the selective system it is possible to go into any one of the speeds or gear ratios desired without passing into

other speeds and with but a limited movement of the shifting members.

The sliding gear system was one of the first to receive general application in early forms of motor vehicles and in its primitive condition it was but a modification of the back gearing used on certain classes of machine tools, such as lathes, drill presses, etc. One of the advantages of this type when compared to other gear transmissions is that it is possible to provide a greater number of speed changes and that there is a higher driving efficiency when on the lower ratios because but two pairs of gears are in mesh.

An example of a progressive sliding-gear transmission is depicted at Fig. 494, this providing three forward speed ratios and one reverse. The various speed ratios are secured by moving the sliding

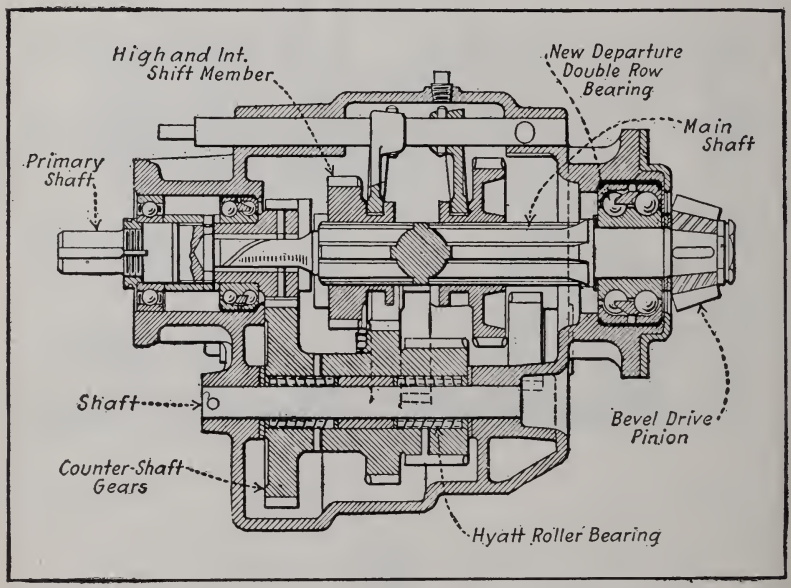


Fig. 496.—Sectional View of the Overland Three-Speed Selective Gearset to Be Mounted in Connection with Rear Axle.

member which is composed of two gears along the main shaft so that it engages successively the gears on the countershaft. When the sliding member is in the position shown, no gears are engaged and no power can be transmitted through the gearset. If the sliding member is moved toward the right so that it engages the small pinion under the reverse gear on the countershaft a reverse drive would be obtained. If the sliding member is shifted toward the left

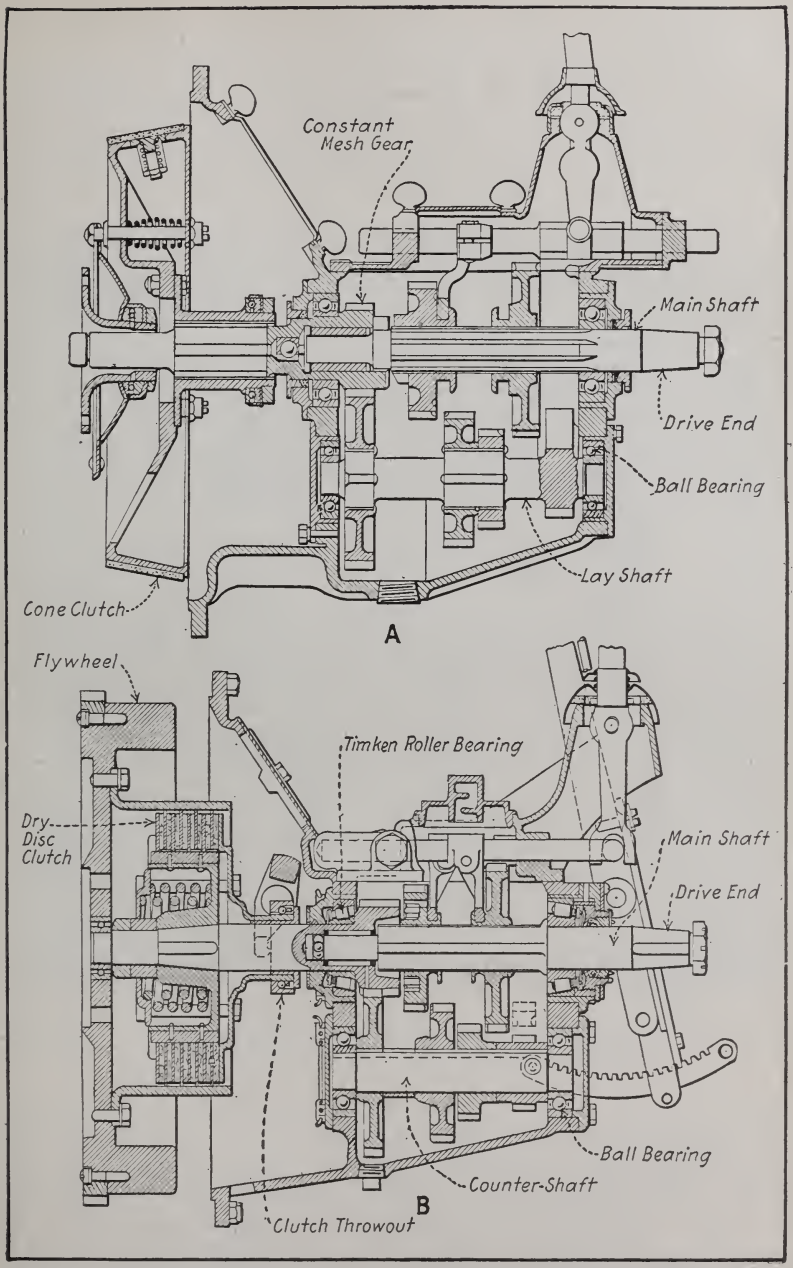


Fig. 497.—Typical Clutch and Gearset Assemblies Used in 1917 Cars.

until the large gear member engages with the low-speed gear on the countershaft the lowest forward drive ratio is obtained.

Continued movement of the sliding member toward the left will cause the small gear to engage with the intermediate pinion and produce a ratio of drive that will not be as fast as the direct connection but which is faster than the slow-speed ratio. When the

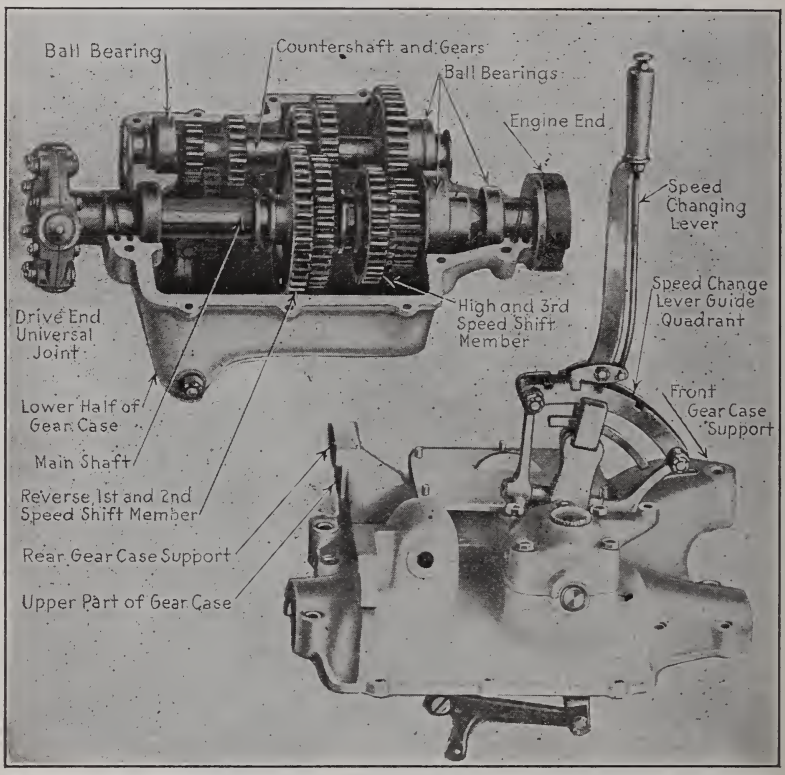


Fig. 497A.—Views Showing Construction of the White Gearset. Top Half of Case Removed to Show Gearing and Shafts.

sliding member is moved to the extreme left it serves to lock the two portions of the main shaft together and a direct drive is obtained. The power from the engine is first delivered to the constant mesh gear which normally drives the countershaft and which revolves around the main portion of the main shaft which telescopes into its interior.

If the design of this gearset be compared to those outlined at Figs. 496 and 497, it will be evident that in the latter two shifting

members are employed which have a smaller degree of movement than the single member of the progressive type. The reason that the selective system is generally preferred may be easily understood by referring to the comparison between the forms as shown at Fig. 497. In the progressive sliding gearset which is shown at A, the shifting member is shown engaged with the intermediate gear on the countershaft. If it is desired to pass into the reverse from this position the slow speed must be engaged before the reverse gear can be reached. The hand lever used to shift the gearing is moved back with one continuous movement. For instance, if the gearing be in the reverse position and it is desired to engage the direct drive it will be necessary to pass the one shifting member to the low speed, past the intermediate and from thence into the direct drive position.

With the selective gearset which is depicted at Fig. 498, B, the plurality of shifting members provided makes it possible to go

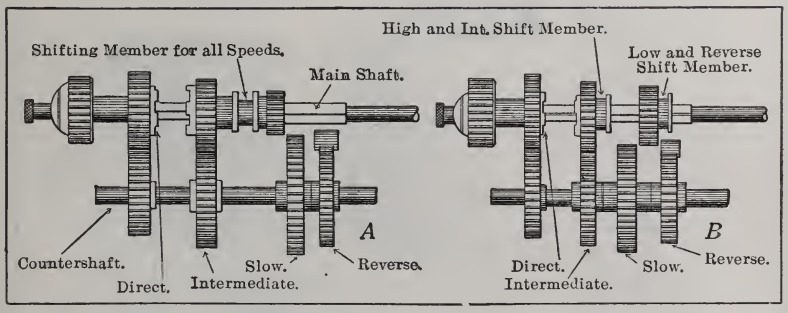


Fig. 498.—Comparing Progressive and Selective Gearset Action to Demonstrate Advantages of the Latter Form.

into any speed directly without passing through the others. For instance, the high and intermediate shift member is shown in the position at which the intermediate speed ratio is obtained. If it is desired to engage the high speed this member may be pushed directly into position so that the main shaft and the constant drive gear are locked together. If it is desired to go into reverse a simple movement of the operating or shifting member, which is guided by an H slot gated segment, will disengage the high speed and throw the other shift member into position by one simple movement.

One of the advantages of this method is that it is much easier to engage the gears and that the liability of injuring the gear teeth by injudicious shifting is not as great as in the progressive type. Another advantage of the selective system is that it permits a more

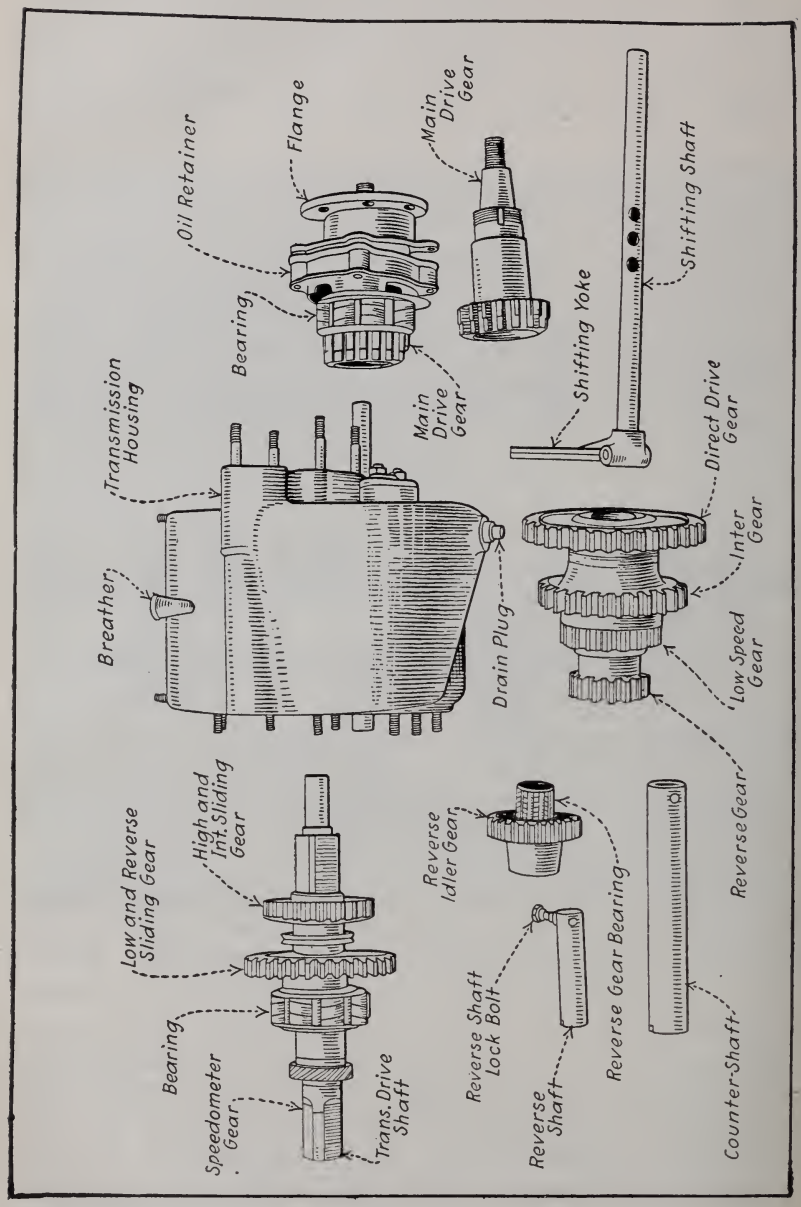


Fig. 499.—Showing Important Parts of the Marmon Three-Speed Gearbox.

compact construction and makes possible the use of shorter shafts which are stiffer than longer ones because the distance between points of support is not so great. Not only is the operation much easier but it is possible to obtain the varying speed ratios much more quickly than with the progressive system.

The usual number of gear ratios provided is three forward speeds and one reverse motion. On some of the heavier touring cars four forward speeds are provided, as in the White gearbox, shown at Fig. 498, and when this is done engineers differ as to whether the direct drive should be on the third or fourth ratio. When the direct drive is on the third ratio the fourth speed is obtained by gearing-up and the driving shaft revolves faster than the main shaft of the engine. When the fourth speed is a direct drive, as in the gearset shown at Fig. 500, the crank shaft and the driving shaft turn at the same

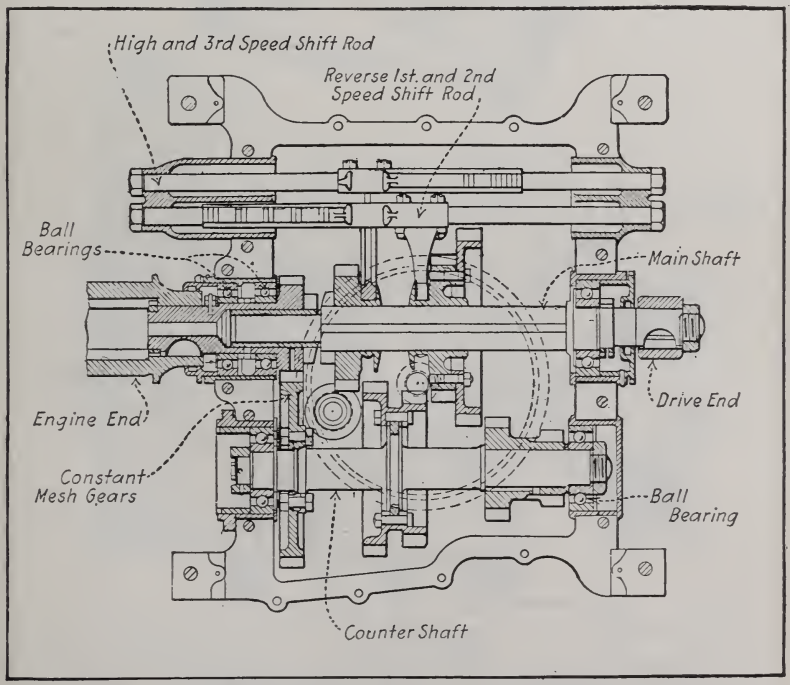


Fig. 500.—Plan View of the Locomobile Four-Speed Gearset, a Good Example of Modern Design.

speed. Two other gearboxes of the four-speed type are shown at Fig. 501. That at A is intended to be located in the frame independently of the engine; the outfit A B is designed for installation

as part of a unit power plant. Those who favor the former method contend that as most of the regular driving is done at a medium

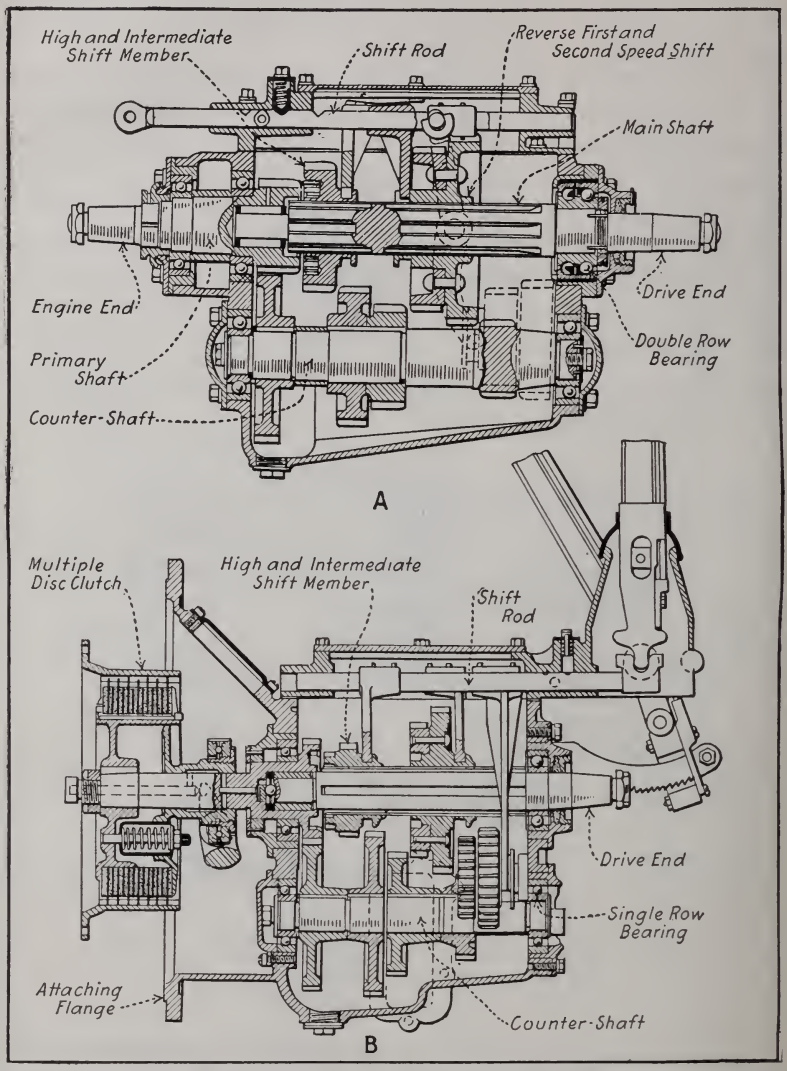


Fig. 501.—Types of Four-Speed Selective Gearsets. A—Type for Independent Placing in Frame. B—Combined with Multiple Dry-Plate Clutch.

rather than at an extreme high speed the direct drive on the third is preferable to a direct drive on the highest ratio. The geared-up fourth speed can be used only when conditions are exceptionally

favorable to high speed. If the highest speed was obtained by a direct drive the natural tendency of the motorist would be to use this most, but there would be many conditions where the ratio would be too high and one of the lower gears would have to be used. If the direct drive was obtained in the third ratio this would be employed the greater part of the time, and as there would be less wear on the gearing with the direct drive engaged it would be preferable to use this as much as possible.

The question of gear ratio to use depends entirely upon local conditions and before determining the ratios of the gearing in the speed-changing mechanisms it is imperative that a definite relation be es-

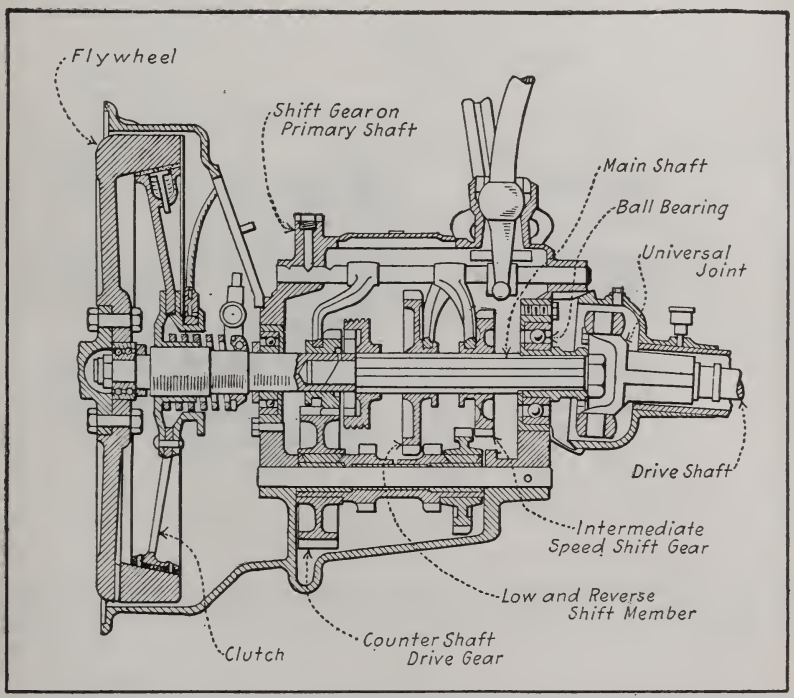


Fig. 502.—The Dodge Bros. Gearset Has Unique Feature of Having Idle Countershaft when Direct Drive Gear is Engaged.

tablished between the speed of the driving shaft and the road wheels. When heavy pleasure cars use engines of moderate power the gear reduction is usually three and one-half or four to one, this meaning that when the gearing is in the direct drive the engine crank shaft will turn three and a half or four times to one revolution of the

driving wheels. On cars where the margin of power is large and where high speeds are desired the ratio may be but two and one-half to one. If the car is geared too low, the engine must make a very high number of revolutions when on the highest speeds and use much more fuel than necessary. On the other hand, if the driving ratio is too high it will be necessary to change gears frequently because even moderate grades will make it imperative to use a lower ratio than that afforded by the direct drive. As there is considerable friction in the ordinary gearbox, even when the high speed is engaged, because of the constant rotation of the countershaft in its bearings,

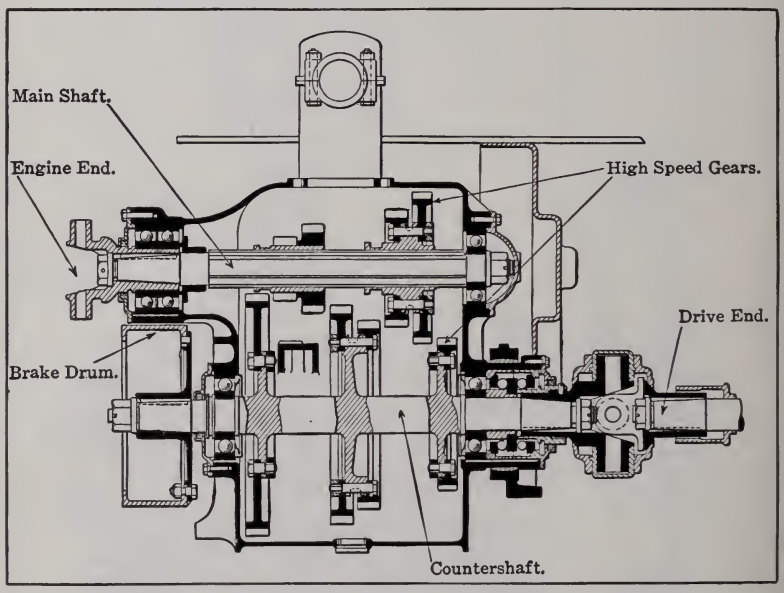


Fig. 503.—Four-Speed Selective Gearset of English Design, in which All Speeds are Obtained by Shifting Gears, No Direct Lock Being Provided for High Speed.

the gearbox of the Dodge Bros. car, which is shown at Fig. 502, incorporates an arrangement by which the gears corresponding to the constant mesh gears of the usual type gearbox are put out of engagement simultaneously with the clutching of the high speed. The principle of operation can be grasped easily by study of the illustration.

The body fitted to the car has a material bearing upon the gear ratios provided. The driving speed that would be entirely practical on a chassis fitted with a roadster body would be much too high if a limousine or coupé body was fitted to the same chassis. If the car

is to be operated in regions where the conditions are not favorable, such as hilly sections, or where the highways are poorly developed, a much lower final drive ratio must be provided than where the roads are good and conditions favorable to higher speeds. The speed ratios when the low gears are engaged will vary from ten to one to such extremes as twenty-five to one. The intermediate speed usually varies from five to one to ten to one, and a third ratio in a four-speed gearset may vary from three to one to six to one, and in some gearsets it may have a value of seven or eight to one. If the fourth

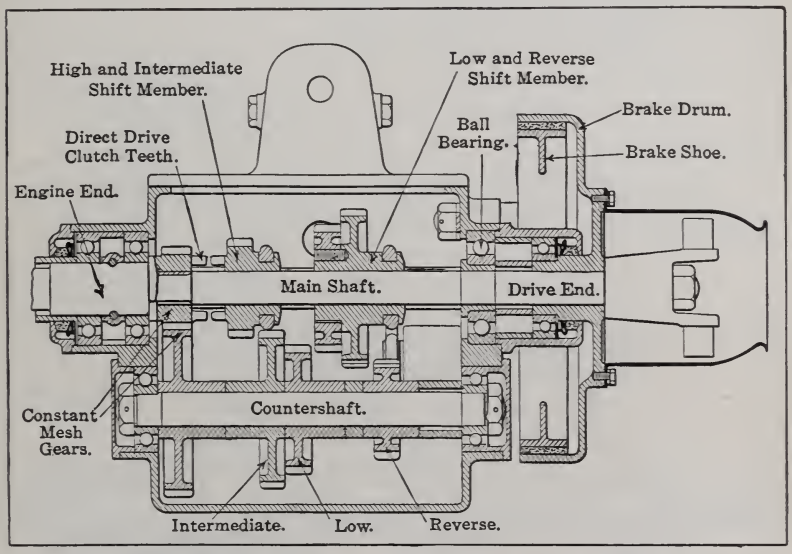


Fig. 504.—Arrangement of Gears and Shafts in Typical English Four-Speed Selective Gearbox.

speed is obtained by gearing-up one may get a ratio of drive as high as two to one, though when the direct drive is on the fourth speed it is seldom higher than three to one.

Most of the sliding gearsets have at least one of the speeds a direct drive, but some forms have been devised where the power is transmitted through gears at all ratios. A gearset of this type, which has been used in an English omnibus, is outlined at Fig. 503. This operates on the selective principle, but the drive at all speeds is through gears. Two shifting members are mounted on the main shaft. One of these carries two small gears; the other has two larger members. When the highest speed ratio is desired, the largest gear on the main shaft is engaged with the smallest member on the counter-

shaft and as these have an equal number of teeth the shafts will turn at the same speed. When the smallest member on the main shaft is engaged with the largest gear the slowest ratio is obtained. This method of gearset construction is seldom followed at the present time because of the constant grinding of the driving gears at all speeds, and a certain amount of noise will result no matter how carefully the gears are fitted. With those forms of gearsets in which the highest ratio is obtained by locking the two parts of the main shaft together there are no gears transmitting power except those in the rear axle, and the operation is much more silent. The gearset is more efficient because the power loss is reduced to that of but one set of driving gears (those in the rear axle), and as no gears in the gearset are under driving loads, there is no grinding or noise when on the direct drive. The utility of the construction shown at Fig. 502 can be readily understood.

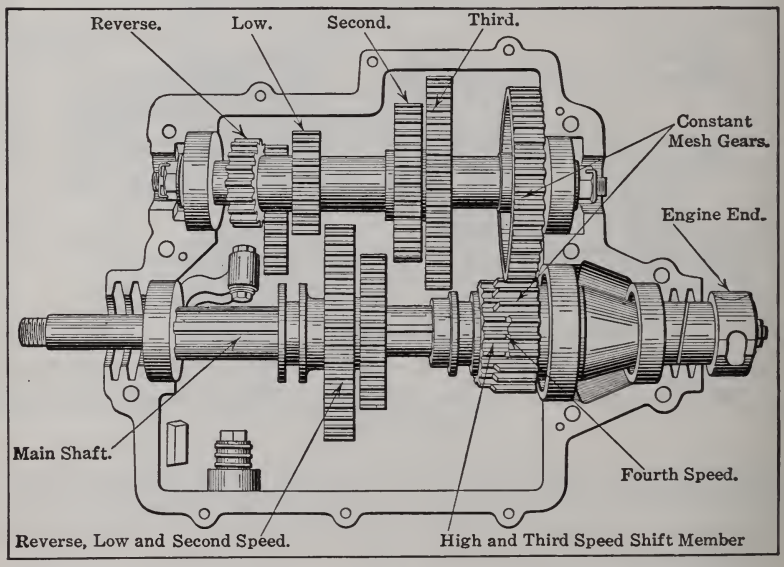


Fig. 505.—White Four-Speed Gearset Has Direct Drive on Highest Ratio.

A typical sliding gearset of the four-speed selective type is shown in section at Fig. 504, and at Fig. 505 a four-speed gearset in which direct drive is obtained on the fourth speed is outlined. In the former, two shifting members are mounted on the main shaft, one of these giving the high and intermediate ratios, while the other is employed for low and reverse speed. But two shifting members are utilized on the main shaft of the form shown at Fig. 505. One

of these acts progressively to give the reverse, low, and second-speed ratios, while the other gives the third and fourth speeds.

A four-speed gearset in which three shifting members are used and in which a geared-up drive is obtained on the fourth speed and a direct connection on third is shown at Fig. 506. In this the clutch

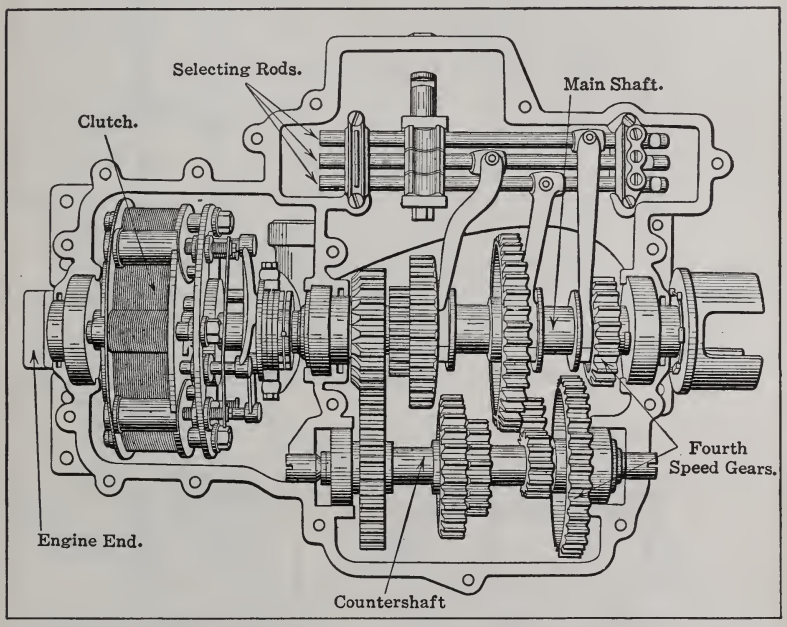


Fig. 506.—Winton Four-Speed Gearset Provides Direct Drive on Third Speed and Gears Up for Highest or Fourth Speed Ratio.

is mounted at the forward end of the gearset in a case of its own and is a multiple-disk type. The member shifted by the center selective rod gives the second and third speeds, while that moved by the inner rod gives the reverse and first speed. The geared-up drive or fourth speed is obtained by shifting the outer selective rod and bringing the smallest gear on the main shaft in mesh with the largest gear on the countershaft.

Change-Speed Gear Installation.—An important factor in gearset design is the method of locating it in the frame. The various systems of gearset mounting in common use are shown at Fig. 507. In that depicted at A the clutch and gearset form a unit with the power plant. The advantage of this method of mounting is that it makes a very compact power-generating and speed-changing unit and there will be no

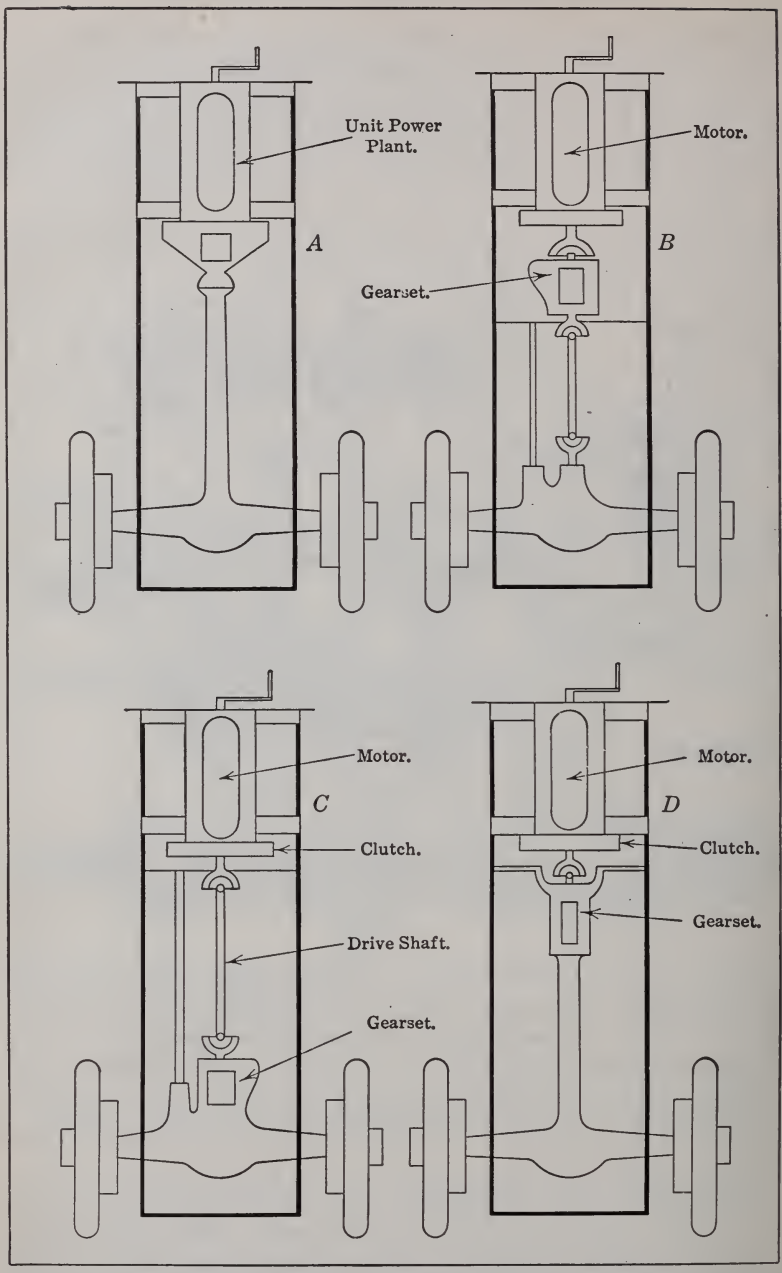


Fig. 507.—Conventional Methods of Installing Gearsets in Chassis. A—Combined with Engine to Form Unit Power Plant. B—Fitted as Individual Unit Back of Engine. C—Combined with Rear Axle. D—Mounted at Front End of Driving Shaft Housing.

liability of lost alignment between the engine and gearset. At B the gearset is a separate member installed back of the motor just under the front floor boards, and when mounted in this manner it may be attached directly to the main frame side members or to a subframe formed by cross members which have been provided for the purpose. In the design outlined at C the gearset is a unit with the rear axle, and the same argument in favor of mounting applies as when it forms part of the unit power plant except that in this case there is no possibility of lost alignment between the gearset and the driving gears. The method of installing which is fourth in popularity is shown at D. In this the gearset is carried at the front end of the driving shaft housing and is usually attached to the frame in such a manner that it will assist in taking braking and driving torque.

The methods of combining the gearset with the clutch case and power plant are shown at Figs. 508 and 509. In the former con-

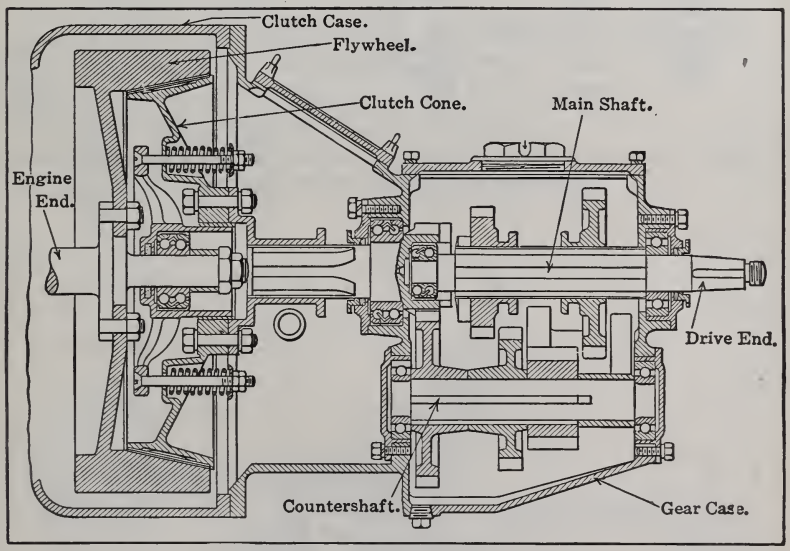


Fig. 508.—Clutch and Gearset Portion of Unit Power Plant, Showing Positive Alignment Between Clutch and Gearset Main Shaft.

struction the engine is shown detached for convenience, but the clutch case is a continuation of the engine bed. At Fig. 509 the gearset is shown detached from the power plant in order to demonstrate that the clutch may be easily reached when desired. When the parts shown are assembled to form a unit the flange at the front end of the gearset case is attached to that at the back end of the engine

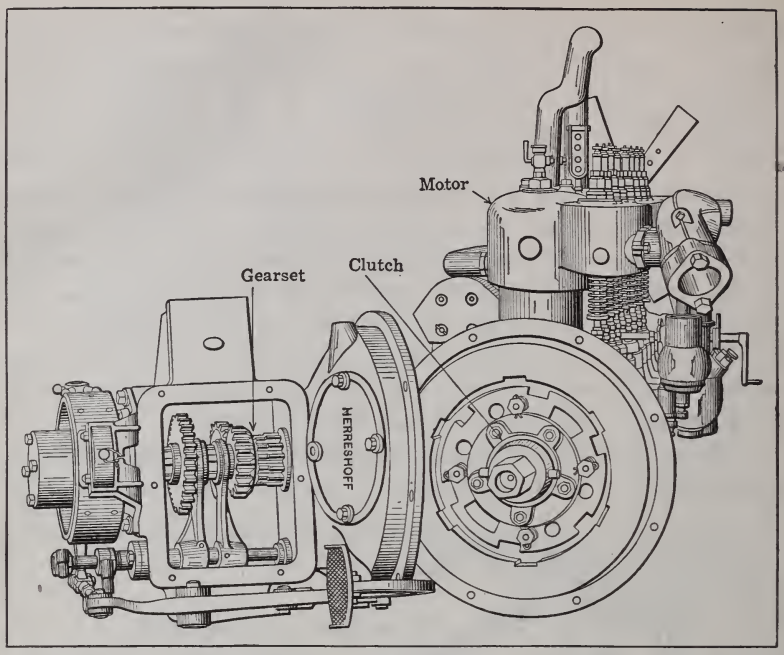


Fig. 509.—Unit Power Plant Partially Dismantled to Show Gearset Removed from Engine Base and Clutch Exposed.

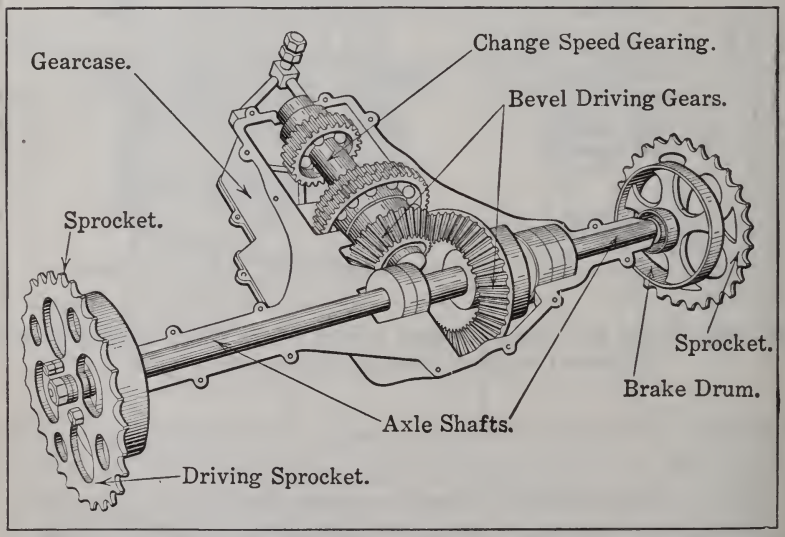


Fig. 510.—Change-Speed Gearing Combined with Countershaft for Side Chain Drive Truck Power Transmission.

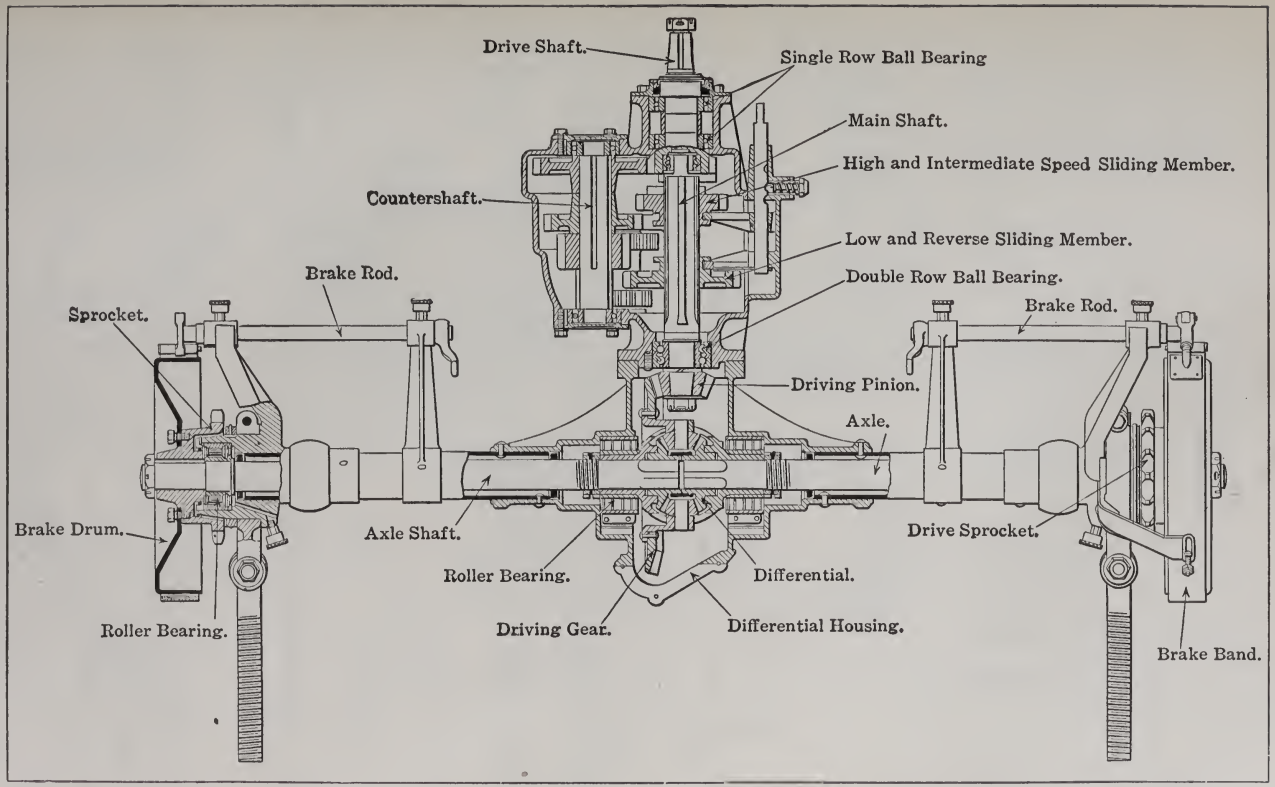


Fig. 511.—Countershaft and Three-Speed Selective Sliding Gearset Mounted as a Unit Insures Positive Alignment of Speed-Changing and Power-Transmitting Elements.

bed by means of bolts and the two then form a cover for the fly wheel and multiple-disk clutch which it carries.

When side-chain drive is provided, as is often the case in motor trucks, the gearset sometimes forms part of the countershaft assembly. One of these designs is shown at Fig. 510, this illustrating the general arrangement of parts, while more specific details of construction are outlined at Fig. 511. The construction is exactly the same as though the countershaft assembly was employed as a live rear axle with shaft drive. The only difference is that the ends of the live axle shaft are provided with driving sprockets instead of wheel hubs. At Fig. 511 the arrangement of the three-speed selective

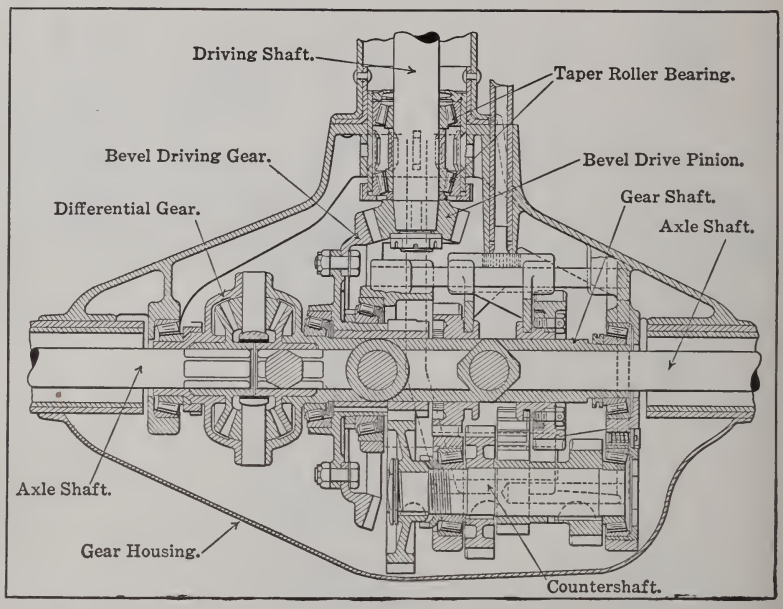


Fig. 512.—Unconventional Arrangement of Three-Speed Selective Sliding Gearset in Combination with Rear Axle.

gearset and the manner in which the bevel-driving gears mesh is clearly shown. The small driving pinion is attached directly to the main shaft extension and there is but little possibility of losing alignment under load. A gearset of this type used on Overland cars is shown at Fig. 496 detached from the axle. The shafts of the transmission gear are mounted on ball bearings while the differential and axles are mounted on roller bearings. The drive sprockets carry pressed steel brake drums to which large external constricting brake

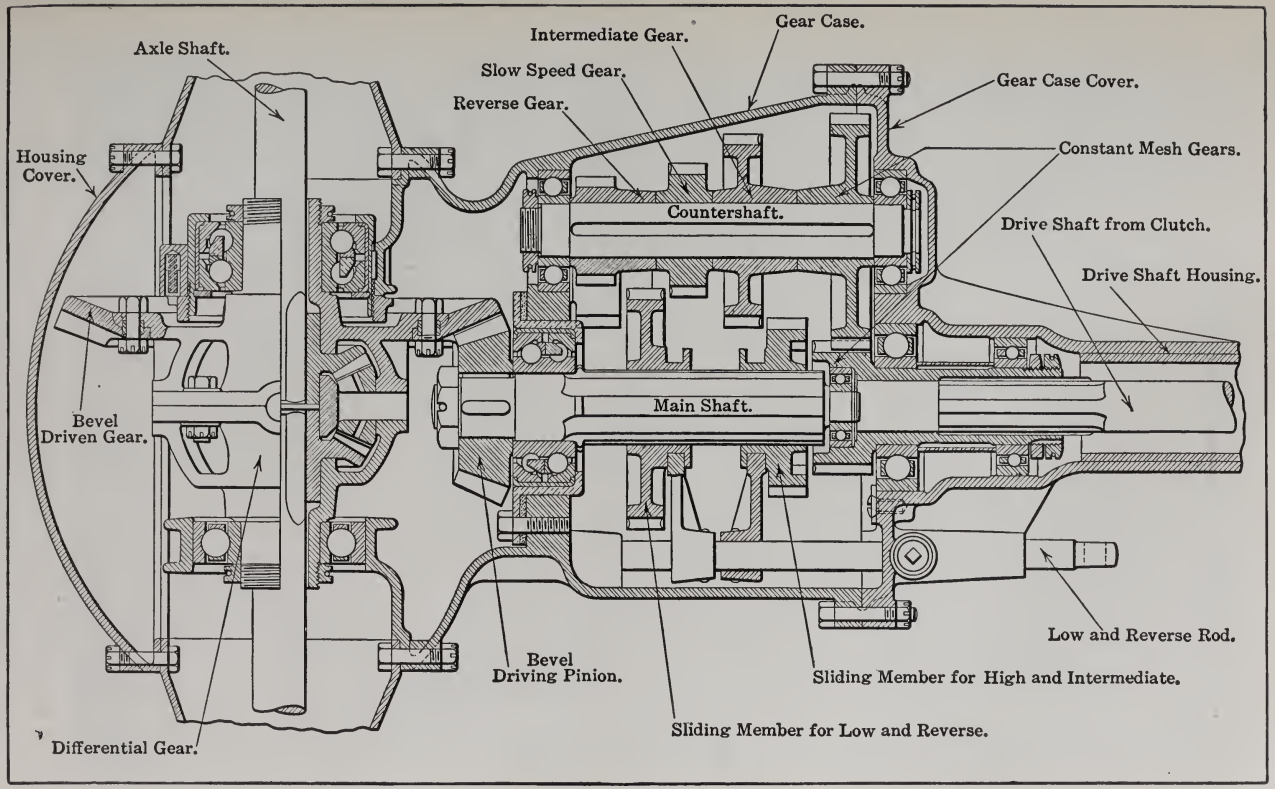


Fig. 513.—Usual Arrangement of Change Speed and Driving Gearing at Differential Housing of Live Rear Axle or Countershaft.

bands are applied. These serve as "running" or service brakes to arrest vehicle motion through the medium of the driving chains which connect the small sprockets with the larger members on the wheels.

An unconventional form of rear axle and gearset combination is shown at Fig. 512, while the conventional arrangement is depicted at Fig. 513. In the former the main shaft of the gearset is in the form of a quill or tube which surrounds one of the axle shafts and the countershaft is a separate member carried directly in back of the main shaft. When on the direct drive the high-speed shift member is moved toward the left and locks the differential gear case firmly to the quill, which acts as the main shaft. When the parts are locked together in this manner a direct drive is obtained. The lower speed ratios are obtained in the same manner as in any other selective transmission, the gears on the main shaft being moved to engage the corresponding members on the countershaft. The contention is made that this method of design makes for a more compact assembly as all parts are housed in one casing member.

Most engineers who favor combining the rear axle and the transmission use the construction outlined at Figs. 496 and 513. In these all parts are so clearly shown that the method of application should be sufficiently clear without lengthy description. The change-speed gearing is a conventional three-speed and reverse selective sliding gear type and the drive to the rear axle is by the usual bevel-gear connection. The various systems of driving and methods of manipulating the speed-change levers will be considered more fully in proper sequence.

Transmission Gear for Four-Wheel Drive.—When a four-wheel drive system is employed it is necessary to use a radically different form of gearset from that commonly employed in cars where a single drive shaft goes to a rear axle to which the tractive members are attached. A gearset of this type is clearly outlined at Fig. 514, and its actual application to a four-wheel drive chassis is shown at Fig. 515. The change-speed gearing is of the individual clutch type and provides three forward speeds and a reverse ratio by means of sliding jaw clutches which lock gears that are always in mesh with each other securely to the drive shaft. The main driving shaft is extended through a supplementary casing attached to that containing change-speed mechanism. A silent chain serves to transmit power from a suitable sprocket on the driving shaft to another member placed on the driven shaft below it. This driven shaft extends through the casing at both ends and the drive to the front and rear axles is by means of the usual propeller shafts and universal joints from the front and rear ends of the chain-reduction case respectively. In the

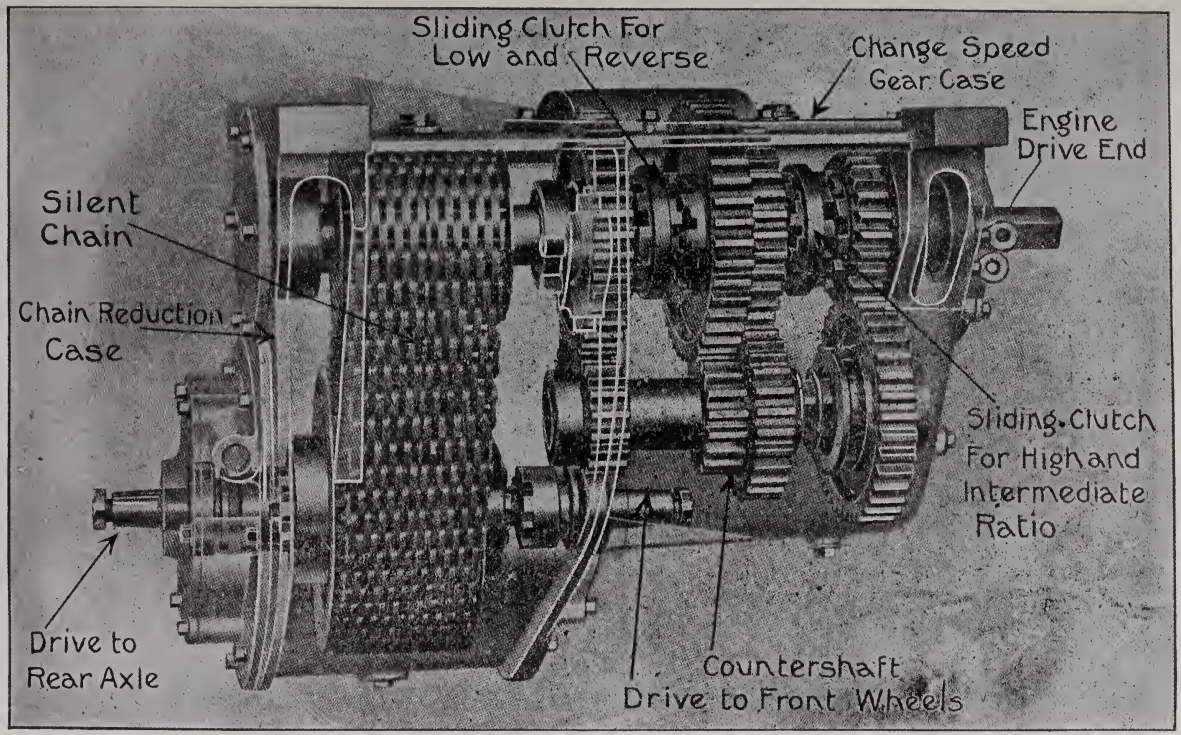

Sliding Clutch For Low and Reverse
Change Speed Gear Case
Engine Drive End
Silent Chain
Chain Reduction Case
Sliding Clutch For High and Intermediate Ratio
Drive to Rear Axle
Countershaft Drive to Front Wheels

Fig. 514.—Special Gearset with Integral Reduction Gearing for Four-Wheel Drive Truck.

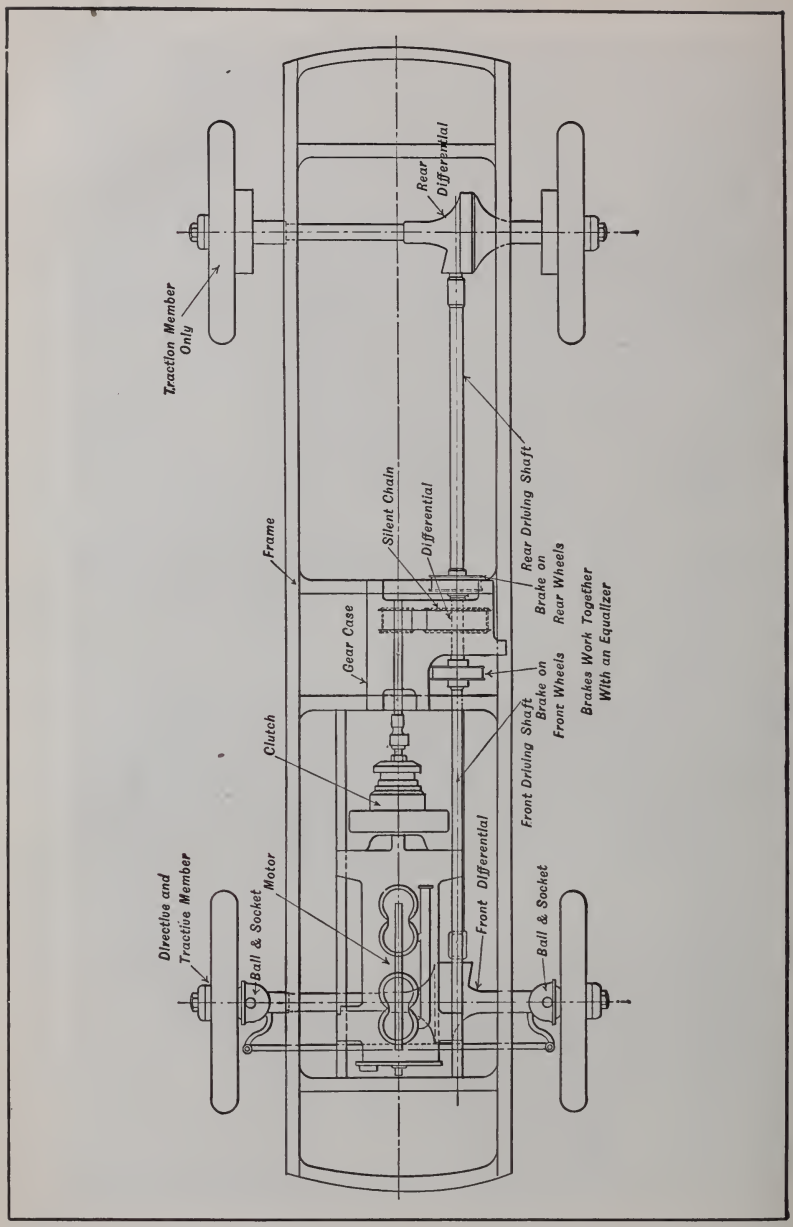


Fig. 515.—Plan View of Chassis of Four-Wheel Drive Truck, Showing Location of Gearbox.

chassis shown at Fig. 515, the axles are different. The rear axle is a conventional form and the wheels are utilized for tractive purposes only. The front axle is a special construction, in which the wheels are driven by ball and socket joints which permit of their inclination to steer the vehicle without interfering with the power-transmission functions.

Combination Gasoline-Electric Drive.—One of the great advantages of the electric automobile outside of its silence and smooth operation is the ease with which the speed and power may be controlled. On the true gasoline type it is necessary to shift gears in order to attain various speed changes, and unless this gear shifting is very carefully done it may be possible to damage the transmission and also to impose shocks on the entire mechanical structure, due to too sudden engagement of driving gearing or clutches. While this defect is not serious enough to be a disadvantage of moment, at the same time it is evident that the operator of a gasoline car must be very competent and thoroughly familiar with the manipulation of the speed-changing and clutch-control lever. The various speeds are obtained by a simple movement of a controller handle, without shock or jar, when electric current is used for propulsion. This makes it possible for ordinary drivers to control the vehicle, because it does not require any special skill to move the controller handle, whereas it does take practice and experience to properly manipulate a sliding gear transmission and clutch.

Gas-Electric Systems.—There are some general disadvantages to the application of electric power alone, and it seems to be the general opinion of engineers all over this country and in Europe that gas power is more suited for commercial work than is electric power, if the latter is derived solely from storage batteries. An electric vehicle depending upon stored energy is not capable of the speed that can be made with a gasoline engine as a power plant. The range or radius of action of the average electric battery is apt to be somewhat limited, and one might easily imagine a condition, especially in a city or town of any size, where enough distance might be covered in the course of a day to prevent proper charging of the storage battery, and this, of course, would result in diminished efficiency as the battery charge became depleted. The writer does not mean to imply that electric power derived from a storage battery is impractical. On the contrary, many very efficient automobiles are propelled by this power.

An ideal combination in which the main advantages of both gas and electric power are obtained is the combination or gasoline-electric system in which the prime mover is a gasoline motor which delivers

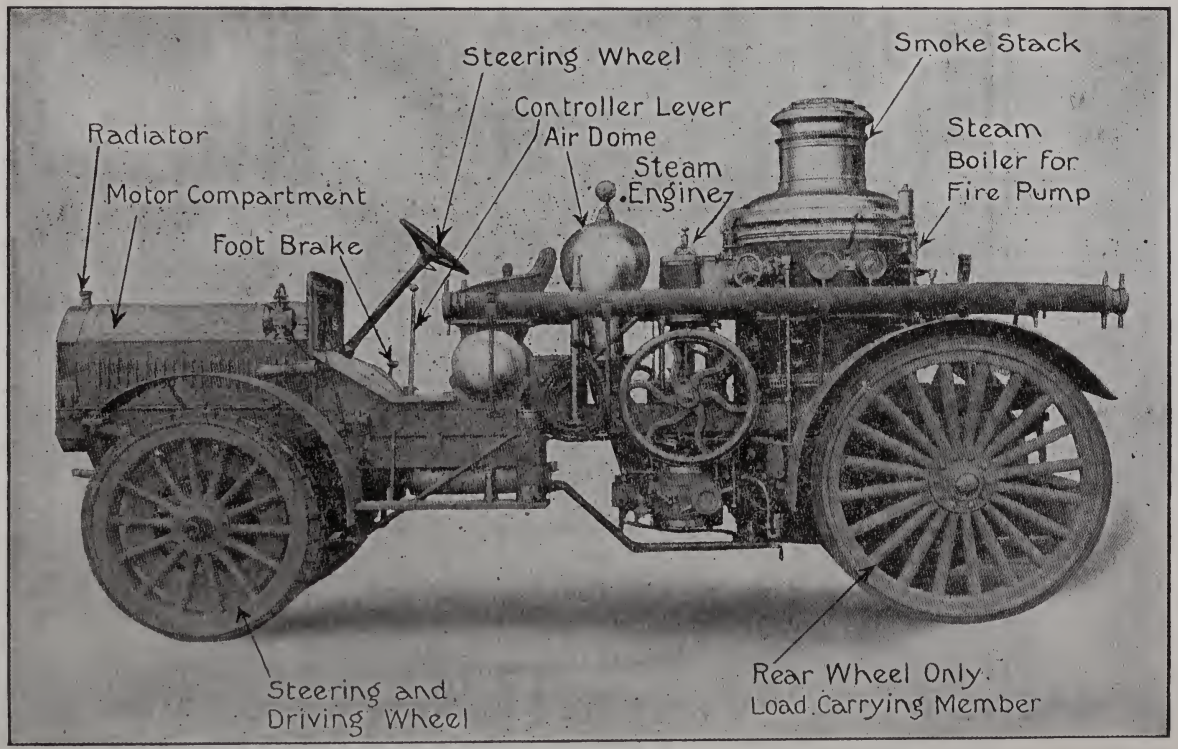


Fig. 516.—Amoskeag Steam Fire Engine Attached to Hoadley System Tractor.

its power to an electric generator instead of to the usual form of gear transmission. With this combination one is obliged to obtain a large radius of action, inasmuch as the gasoline engine may be operated continuously as long as the supply of gasoline and oil is adequate, and by the use of the electric power to turn the wheels one is enabled to gain the main advantages, namely, easy control and simplicity of operation that would be obtained in electric automobiles.

A very efficient tractor has been devised by the American and British Manufacturing Company which is particularly suited for fire department and general commercial service, as it can be just as well adapted to use on existing wagons and all kinds of fire apparatus as to new fire engines and other machines. The construction is such that the change from horse-drawn to motor traction is a simple operation that does not require the vehicle to be out of commission very long.

This tractor construction operates on the Hoadley system and gives excellent service because there is nothing radical in the design. Efficiency is obtained by an ingenious application of well-known mechanical elements. Among some of the advantages of this system as advanced by the makers may be mentioned, extreme simplicity, minimum depreciation, because there are few parts that can wear out, and every part of the machine is unusually substantial. There is great flexibility of control as relates to power and speed. It possesses satisfactory hill-climbing ability, has superior traction and stability on slippery roads, and it can be steered and maneuvered without expenditure of undue energy. In addition to the points enumerated this system of construction also shares the advantages present with the tractor system of propulsion. These are that the body design will be independent of the mechanism, which makes the same tractor construction suitable for all forms of vehicles; the body may be high or low as desired, and the tractor can be applied to any existing horse-drawn vehicle. The general appearance of the A. & B. tractor applied to an Amoskeag Fire Engine is clearly shown at Fig. 516. It is claimed that the 40 H. P. tractor with a "first size fire engine" can be speeded to a maximum of twenty-five miles per hour, which is about four times as fast as the same engine can be drawn with a three-horse hitch for any distance, that it will climb a 15% grade at three to five miles per hour, and that it has sufficient reserve power to start from a standstill and maneuver on that incline. It will climb a twelve-inch curbstone or pull through sand until the axle is buried. So sensitive is the control that the massive machine may be moved an inch or two at a time by the driver standing on the ground and controlling the speed lever.

This tractor is made in four sizes, as follows: 22 H. P., suited for vehicles of 1½ tons capacity; 30 H. P., adapted to vehicles up to 2½ tons capacity; 40 H. P., suited for 5 tons, and 60 H. P., for vehicles up to 7½ tons.

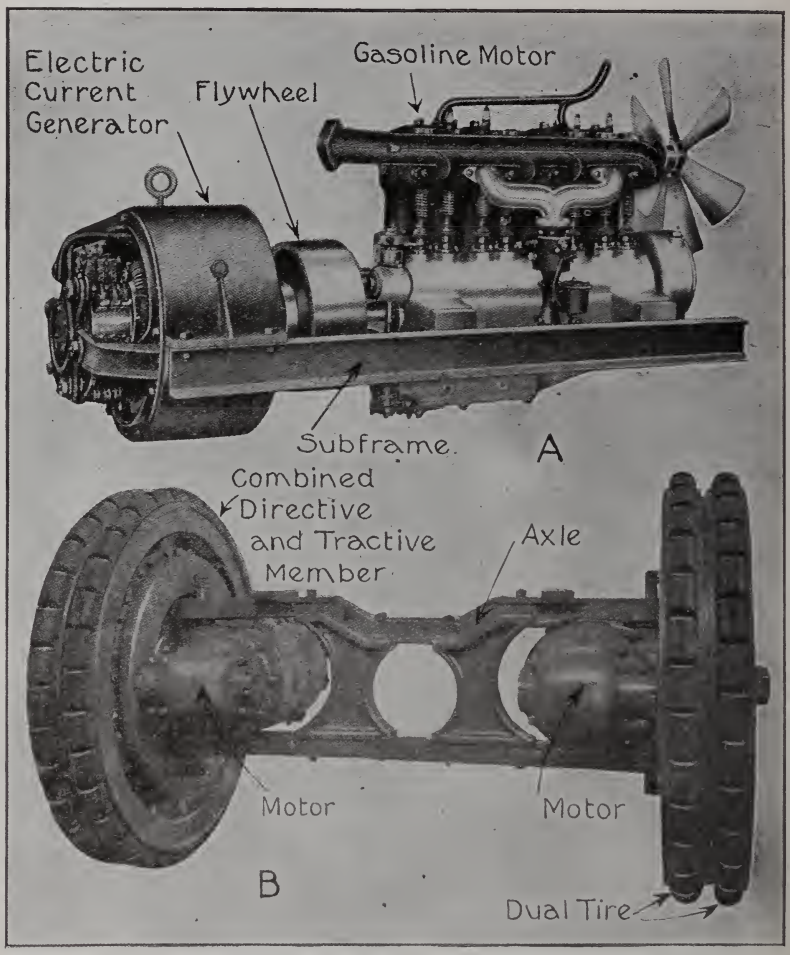


Fig. 517.—Principal Parts of Hoadley System Tractor. A—Power Plant and Generator Assembly. B—The Combined Driving and Steering Axle, Showing Method of Supporting Wheel-Drive Motors.

The power plant, which is clearly outlined at A, Fig. 517, consists of a four-cylinder L head gasoline motor with cylinders cast in pairs, which drives an electric generator coupled directly to the motor flywheel. This generator supplies current to operate the driving

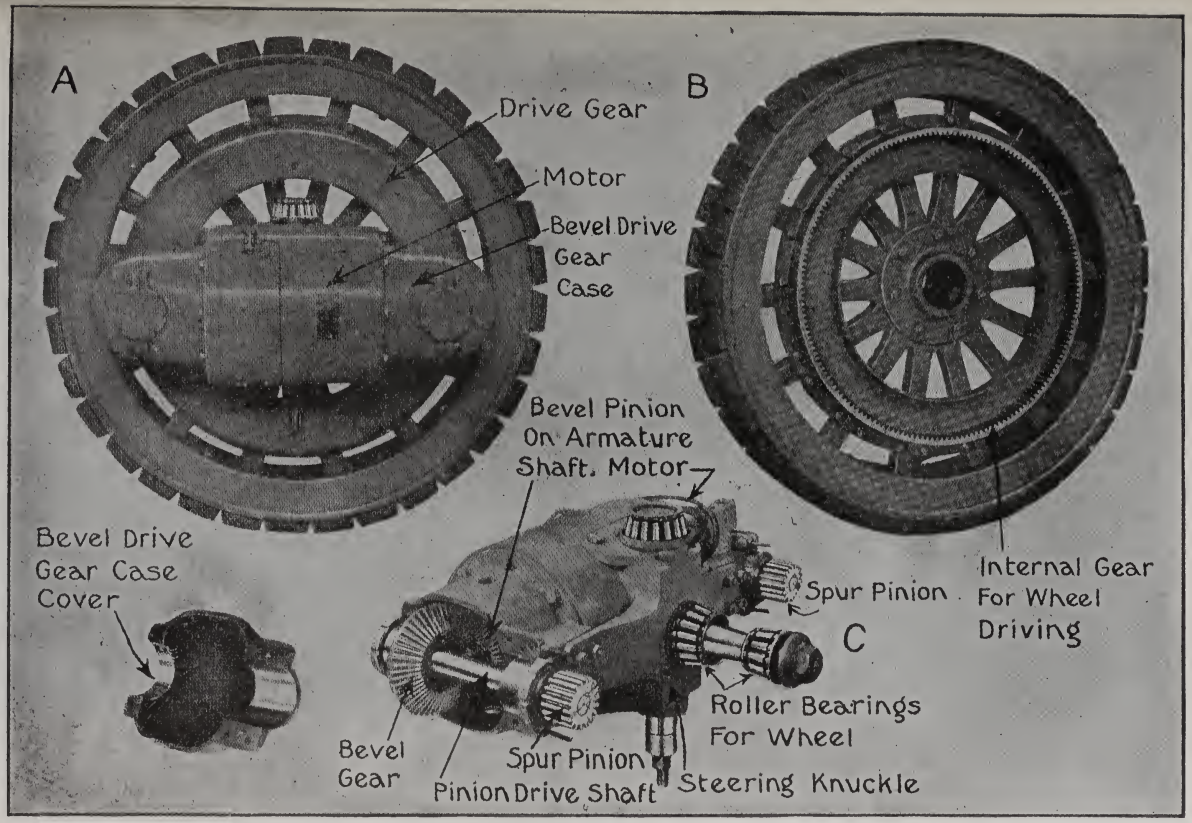


Fig. 518.—Depicting Important Parts of the Wheel and Motor Assembly Used in the Hoadley Combination Gas-Electric Drive Tractor.

motors, which are located at each front wheel. Each motor, with the entire driving gearing, is combined with the combination tractive and directive member in a unit structure which swings on pivots for the purpose of steering. The wheels are connected and controlled by the usual form of handwheel and reduction gearing and by drag link and tiebar, as in the conventional front axle. The electric generator is connected directly to the wheel motors through a simple form of three-point control switch, there being no other electric intermediate member, except plain simple wiring.

The power and speed are controlled chiefly by controlling the power and speed of the gasoline motor by the usual spark and throttle levers. The controller offers two forward speeds and a reverse, and by this added control the power and speed of the vehicle may be varied to suit conditions. With this electric drive combination, ideal control is obtained. Both speed and power are under instant command, and one can obtain any variations from zero to the maximum point without the various steps that are unavoidable where clutch and change speed gears are part of the transmission mechanism. The illustration at B, Fig. 517, shows a completely assembled tractor axle with wheels and driving motors in place. At Fig. 518 one will see the various details of the combined motor and wheel assembly at *A*, the appearance of the motor with the wheel and one end of the casing removed is depicted at *C*, and the wheel with internal spur driving gear in place is clearly shown at *B*. These views give excellent ideas of the application of the various parts of the power plant, the axle with the wheel driving motors and the various members comprising the axle assembly. The axle is of particularly stiff and rigid design, as the depth and bracing near the pivot ends permit of obtaining great strength without the use of a large mass of metal. The motors, which are of the enclosed type, as shown at Fig. 518, are built into the steering knuckles, so that the motor, knuckle and spindle are practically an integral structure. As the combined driving and steering wheel forms a substantial unit, the torque reaction on the wheels is sustained by the pivots of the steering knuckle and the exceptionally strong front axle. The weight of the motor on one side of the pivot is said to closely balance the weight of the wheel on the other side, and it is advanced that this method of sustaining the weight minimizes the evil effects due to impact stresses found in construction where the motor had a pronounced overhang in relation to the wheel. This feature proved to be a serious drawback in the early attempts that were made to employ an electric motor drive directly attached to members that could be moved for steering. The

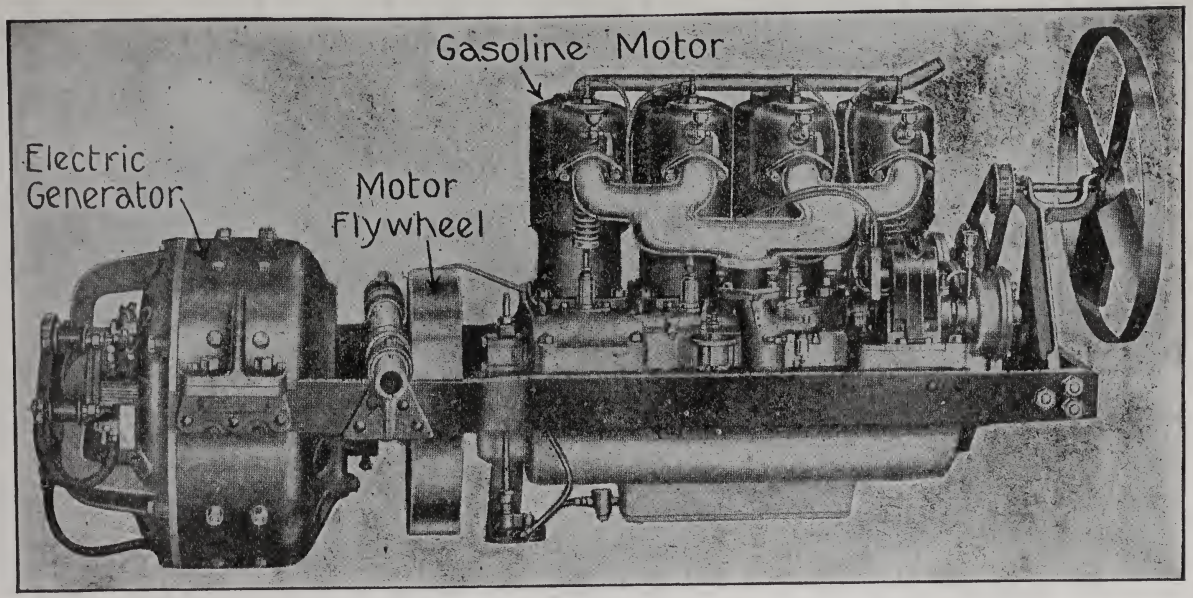


Fig. 519.—Power Plant of the Couple-Gear Combination Gasoline-Electric Drive Trucks.

wheel is driven by spur pinions which engage with the large internal gear fastened to the wheel spokes.

To anyone who has had experience in applying electric power to heavy vehicle drive, it is apparent that it is not easy to design a mechanically efficient method of drive between the motor and the driving wheels. An electric motor must run up to a certain speed in order to obtain the proper amount of power without using extremely large motors and also to obtain the proper degree of efficiency. The driving wheels of heavy vehicles must turn at a relatively slow rate to correspond to the speed of the vehicle, and as large wheels are generally used on fire apparatus, this necessitates having a large ratio of speed reduction from electric motors to wheels which might be obtained by a two-step or three-step reduction. The two-step reduction is much the simplest, and is also the most efficient because less power is lost in friction of gearing. By referring to the illustration which the electric motor used for power, it will be seen that the method of power application is based on a clear understanding of correct mechanical principles. Instead of taking the drive from but one end of the motor armature, as is common practice in most electric vehicles, the driving strains on the motor armature and the loads on the bearings due to driving torque are equalized by taking the power from each end of the armature shaft. A bevel pinion is securely attached by means of a taper fit and key at each end of the armature shaft and the driving pinions are retained firmly in place by the clamping nuts provided for that purpose. The armature shaft is mounted on ball bearings which provide maximum efficiency, owing to the practical elimination of bearing friction. At each end of the motor casings a cross shaft is placed which is at right angles to the armature shaft. These shafts have the spur driving pinions (which engage with the large internal gears of the wheels) formed integral and are driven from the motor armature shaft by bevel gears securely fastened to the shaft and meshing with the bevel drive pinions. The wheel pinion drive shafts are mounted on roller bearings of the taper form which are provided with adjustments by which they may always be kept in proper alignment. The use of the taper roller bearings mounted in the manner indicated permits of keeping the shaft from end movement, and also makes it possible to resist the end thrust on the gears, due to the angularity of the teeth. While there would be a certain amount of end thrust present on the armature shaft of the motor if the drive was taken from only one end, the use of the two bevel pinions and the method of mounting make it possible for the end thrust of one pinion to bal-

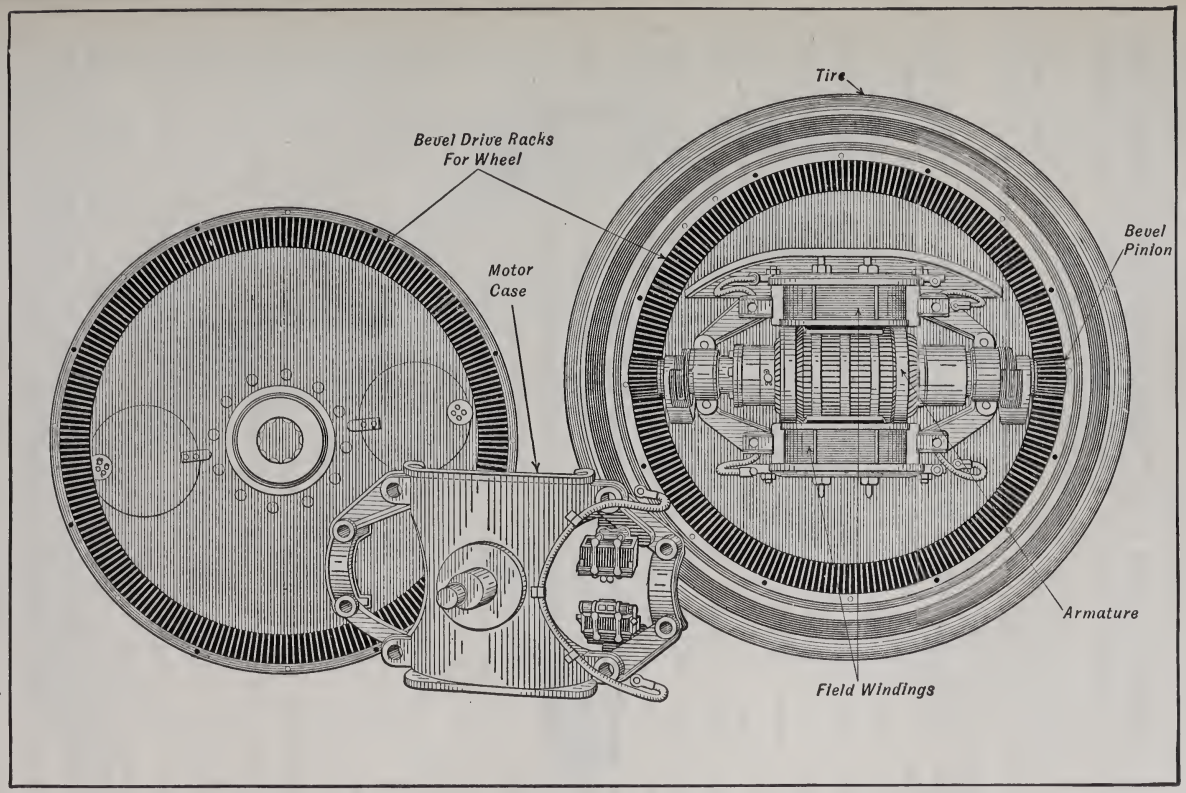


Fig. 520.—Outlining Construction of the Wheel Used in Couple-Gear Vehicles. Note the Location of the Driving Motor in the Center of the Wheel and Method of Driving.

ance that of the member on the other end of the shaft. The traction member is driven by the spur pinions, which are placed at opposite sides of the large internal gear, and thus the power delivered by the electric motor is applied to the wheel at very effective points or near the contact point of traction member and the ground. By the use of the two pinions at opposite sides of the large rack or internal gear, an absolutely balanced drive is obtained at the wheel as well as at the motor armature. The electric motors are designed so they will operate at a 300% overload with absolute safety.

The Couple-Gear Four-Wheel Drive System.—The Couple-Gear system is another method of utilizing electricity as a means of speed changing and power transmission with a gasoline engine as a prime mover that supplies electrical energy by driving a dynamo attached directly to the crankshaft. The general arrangement of parts of the power plant is depicted at Fig. 519. The gasoline engine and the dynamo it drives are attached to a subframe member, so the power plant complete is a unit that may be readily installed on the main frame of the chassis. The distinctive feature of the Couple-Gear system is the method of mounting the wheel-driving motors between the two members comprising the wheel. One motor is attached inside of each driving wheel, as shown at Fig. 520. The motor frame is attached to a carrier member integral with the wheel spindle and drives the wheel through two beveled pinions at the ends of the armature shaft, one of which meshes with a bevel drive rack at one side of the wheel, while the other pinion engages a rack of similar size on the other side of the wheel. At Fig. 520 one side of the wheel is taken off so the construction of the wheel-driving motor and the arrangement of the driving gearing may be readily ascertained. The illustration, Fig. 521, shows a front view of the wheel with the rim removed to show the manner in which bevel pinion *A* drives bevel rack *A*, while the bevel pinion *B* is in mesh with the bevel rack *B*. The wheel spindle which projects from one side of the wheel fits a corresponding taper hole in a steering knuckle of suitable form, which makes it possible to incline the wheel as desired for steering without interrupting the continuity of the drive. The couple-gear system is sold in two- and four-wheel units, and where four wheels are used, all four members combine directive and tractive functions. The two-wheel type is in the nature of a tractor that is intended to be attached to the front portion of the frame of any heavy vehicle, such as fire apparatus.

The Entz Electric Transmission.—In the Entz electric transmission system shown at Fig. 522 there are two dynamos arranged tandem

fashion. These are connected up mechanically in such a way that the efficiency is much higher than that secured by the use of the gasoline-electric systems described at other points in this book. The field frame of the first dynamo is attached to the crank shaft of the en-

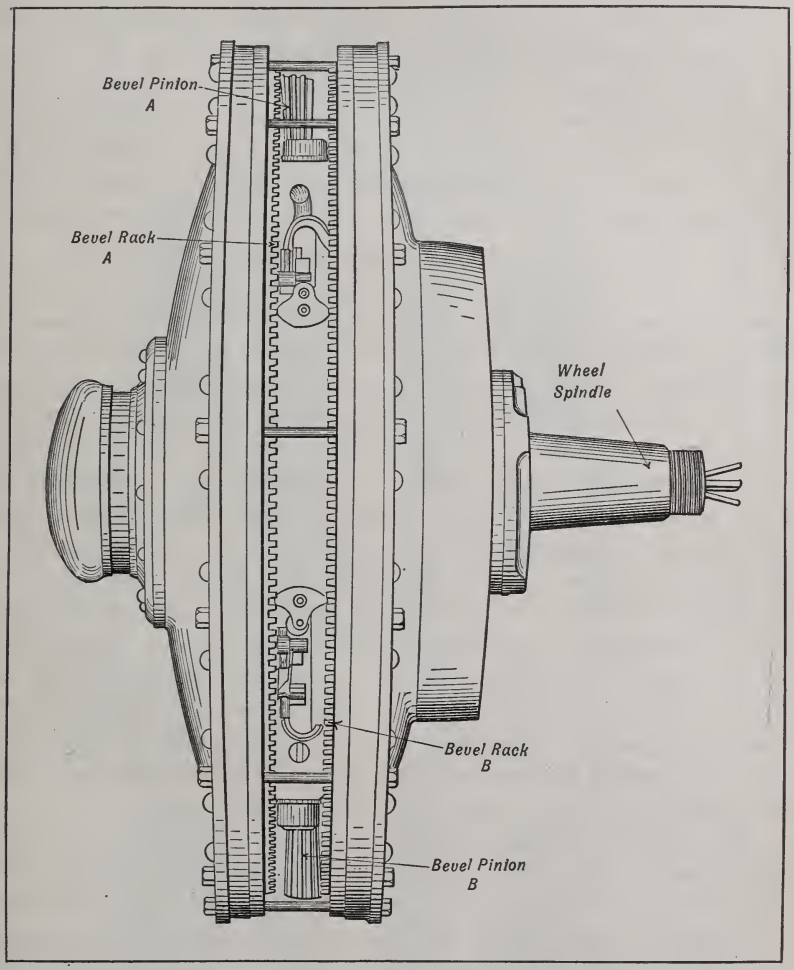


Fig. 521.—Front View of the Couple-Gear Wheel, with Tire and Rim Removed to Show Method of Driving by Bevel Pinions and Racks.

gine, and when the armature circuit is closed, the armature will also revolve and thereby propel the car, acting exactly the same as a slipping clutch, the amount of slip being subject to control. The armature is attached directly to the driving shaft, as is that of the motor

placed back of the generator. When one transmits power through a slipping clutch, one cannot get any more from it than is put into it. If friction clutch slips fifty per cent., one-half of the energy supplied to it is converted by friction into heat. Similarly in the dynamo or generator of the Entz system, if that member turns only half as fast as the field frame, only one-half of the power supplied to the field is mechanically transmitted. The other half appears in the form of an electric current in the armature circuit. If the armature were short circuited, then all of this electrical energy would be converted into heat. Under conditions of light running, however, when the high gear or direct drive would be used in a car equipped with a sliding gear transmission, the armature of the Entz system is short circuited, but the slippage and loss then amounts to only a few per cent.

When the resistance to car movement is greater, so that a lower gear must be employed in the gear driven cars, with the Entz system, the current produced in the first armature by the slip is sent to the windings of the motor where it produces useful mechanical power. As the armature of the motor is secured to the propeller shaft it transforms the electrical energy produced by the slip at the generator to mechanical power, which supplements that transmitted by the generator armature. The windings of the second machine are such that the electric system can increase the torque or turning effort of the engine three times, at the same time reducing the speed of driving pinion rotation at the rear axle to one-third that of the engine speed. The engine is permitted to develop its full power, and to turn at such speed as is necessary to secure this effect, and when the resistance to road wheel rotation is such that these must turn slower, instead of slowing up the engine speed it may be kept at the same point and the armature of the generator allowed to slip and generate current, which is then directed to the second machine.

This system was first devised eight or nine years ago, and has been recently reintroduced in an improved and simplified form. The appearance of the unit is clearly shown at Fig. 522. Bolted to the rear of the engine crank shaft is an aluminum housing, which carries the electrical system. Two arms on this crank case rest on the chassis frame to support it. Inside of the housing is another case bolted to a flange at the rear end of the crank shaft. This is the frame of the forward unit of transmission, which carries the field coils, and which acts as a fly-wheel for the engine. To the rear end of the stationary outside housing the field frame of the rear electrical unit, which is intended to be stationary, is attached. The armatures of both units are carried upon a large tubular shaft supported by annular ball bear-

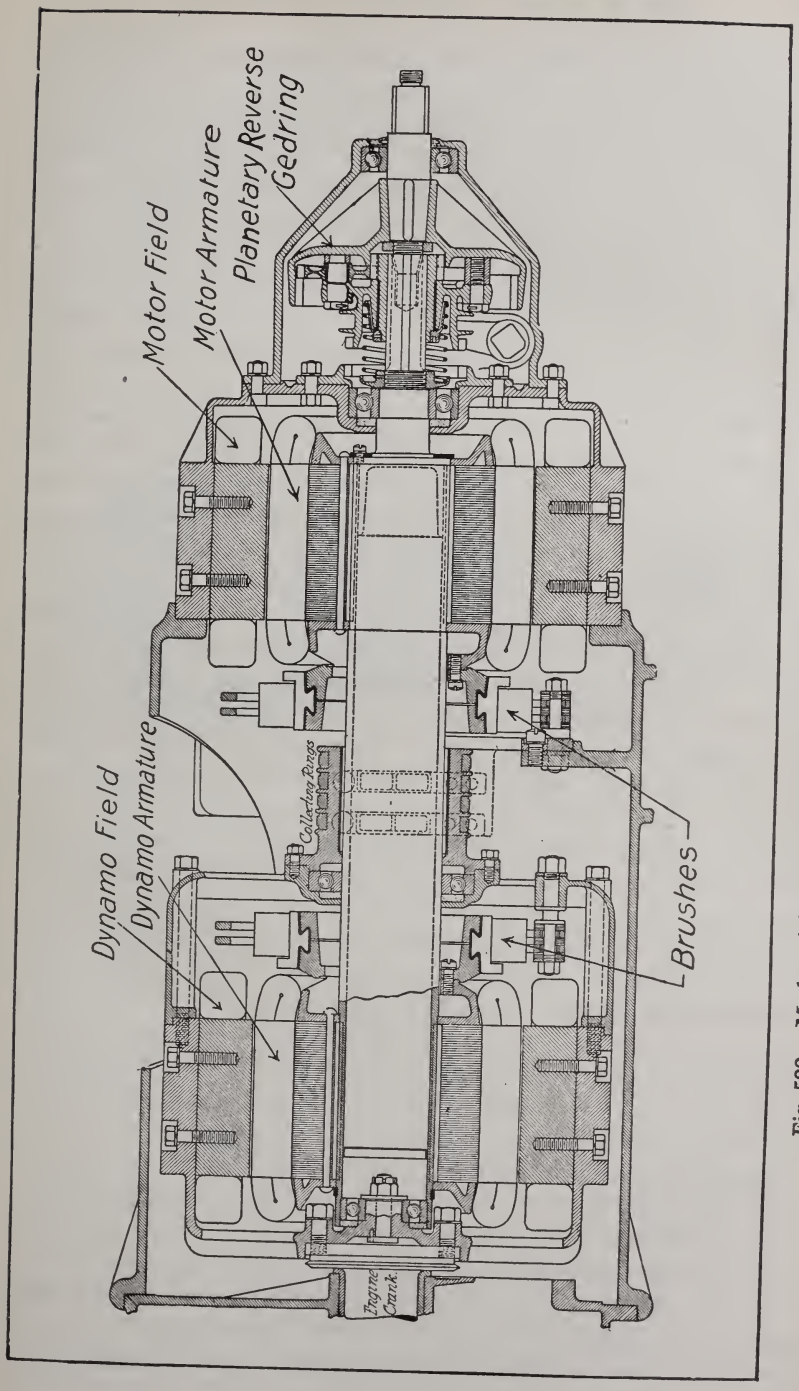


Fig. 522.—Modern Adaption of the Entz Electric Transmission on Owen Magnetic Car.

ings. The armature shaft is connected directly to the propeller shaft, and when the car is standing still, the armature shaft is stationary, whereas when running in the high speed position of the controller lever, it turns at practically the same speed as the engine crank shaft.

The action may be described as follows: When the car is standing still with the engine running, the field of the forward electrical unit, which is called the "generator," is rotated with the engine crank shaft to which it is fastened while the armature remains stationary. At this time all electrical circuits are open and there is no tendency for the engine to drive the car. When the controller lever is thrown into the first, or "soft start," position, a circuit is closed through both the generator and the rear unit, which is called the motor. The generator then begins to produce a current, which is fed into the motor. At the same time there is power applied to the armature shaft equal to the engine tendency to turn the shaft in the same direction as the crank shaft. The current produced by the slip owing to the difference in speed between generator field and armature, is being fed into the motor, which also turns the shaft in the same direction as that produced by the magnetic clutch. In other positions of the controller up to the high speed position different arrangements of resistances change the speed ratio between engine and propeller shaft, but there are no off points between the various notches, so the application of power to the wheels is not interrupted in changing speeds. When the high speed position is reached, there is no electrical connection between the generator and the motor. The former is short circuited, and acts as an electrical or magnetic clutch. When it is desired to secure reverse speeds, a mechanically operated planetary reverse gearing is used, which changes the direction of rotation of the driving pinion. When the controller lever is in "off" position, the rear unit is short circuited and it will act as an electrical brake, preventing the car coasting down hill faster than ten miles per hour. When actually applied in a car, current may be shunted from the generating unit to charge a battery, which may be used for lighting and ignition, and the current of which may be directed through the electrical machine when it is desired to start the engine.

Magnetic-Centrifugal Clutch System.—The advantages of electromagnetic control may be obtained without the use of storage batteries by a novel transmission system in which a specially designed, combined magnetic-centrifugal clutch is used. This is a motor-generator which replaces the flywheel, friction clutch, lighting current generator and engine starting motor of the conventional car. An electrically operated gearset which provides two- or three-speed

reductions for emergency use is also provided, but the car may be operated for the most part on the direct drive through the use of either the electrical clutching action at slow speed and a friction drive at higher speeds. The armature of the motor-generator takes the place of the flywheel of the engine, and the field portion is mounted on the forward end of the driving shaft with a special constant mesh gearset between it and the final drive propeller shaft. As the fields are carried within the armature, an internal commutator must be used as shown at Fig. 523. The brushes, which are of large

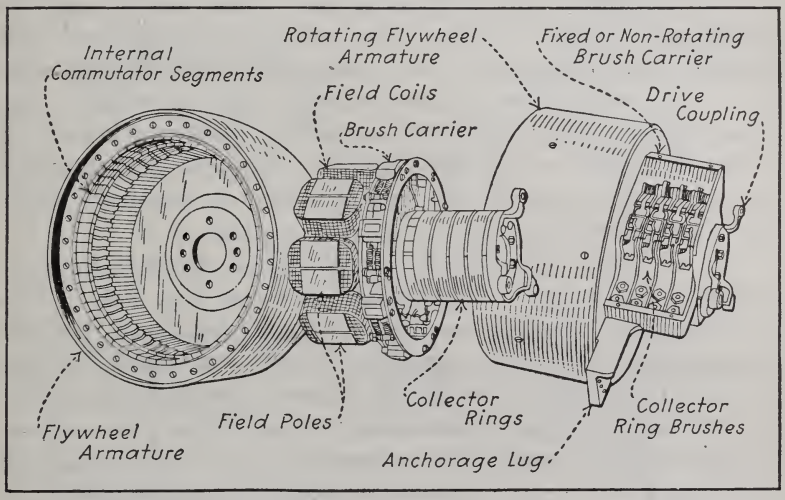


Fig. 523.—Illustrations Showing Construction of the Vesta Transmission.

size, are mounted in a carrier which rotates with the propeller shaft and press outwardly against the commutator. When the speed of rotation is sufficiently great, the centrifugal force augments the hold they have against the commutator.

Whenever the resistance of the rear wheels is high enough so that the frictional contact of the brushes is not sufficient to prevent movement between the brushes and commutator, the slippage will permit the fields to revolve at a slower speed than the armature, and a current is produced in the armature by this difference in speed. This current is directed to the field windings and, of course, transforms the field poles to magnets. The magnetic attraction or pull increases with the slip and consequently as the current produced augments. The surplus electricity produced by this slip between the armature and field portions above that required to obtain the proper magnetic clutch action is diverted to the storage battery to keep that charged.

No current for the operation of the clutch is produced by the battery and this is called upon to supply electricity only when the electric machine is operated as a motor to crank the engine. It is said that sufficient brush pressure to provide a non-yielding friction driving connection is obtained at speeds in excess of 20 miles per hour.

This device differs from the Entz electric system in that it acts merely as a clutch whereas that takes the place of both clutch and gearset. The speed control of the engine is by the conventional accelerator and the various changes of speed are secured by operating electric push buttons on the control switch. These various speeds are obtained smoothly and silently. Two sets of brushes are used, those mounted in the brush carrier that revolves with the field coils and a fixed or non-rotating set of brushes which bear on collector rings carried by the rotating field which are held in place by a suitable anchorage lug bolted to the frame member. Suitable electric connections are made between the two sets of brushes to obtain the desired electric generating and magnetic driving qualities.

The simplicity of the Vesta transmission is apparent on an inspection of the diagram of the chasis shown at Fig. 524. "A" is the dynamo which replaces the flywheel, the friction clutch, the starting motor and the lighting generator. "B" is the speed compound which provides one low gear ratio for forward drive and a low or high gear for reverse, replacing the ordinary transmission gears and case. The gears in this transmission are always in mesh but do not slide and except when in low or reverse do not rotate on each other. In the "running" position they all rotate freely around the propellor shaft, without friction or wear, acting merely as additional flywheel weight. "C" is a locking device, which holds the propellor shaft when the dynamo acts as a starting motor, and prevents the car from running backward. Except when starting the engine, the pawl is held out of contact with the ratchet by a spring. "D" is the automatic controller which connects the batteries, in series with the dynamo armature, to crank the engine and is parallel when the car is running. "E" and "F" are the service and emergency brakes. "I" indicates the controlling buttons for all forward speeds. Pushing a button closes a switch, pressing the release just over the button opens the switch.

The speed is governed by the accelerator, and when the foot is removed the car coasts freely. The sequence of operations in starting or running is simple. The ignition key is inserted, the button on steering post, marked "start," is pushed "in," and the dynamo acting as a motor cranks the engine. This button is then released by

touching the release spring just above it. So long as this switch remains closed a small magnet holds the pawl of the locking device in contact with the ratchet. Without this feature, unless the wheels were locked, the starting motor would drive the car backward. The engine is now running freely as may be tested by touching the accelerator and giving it gas. The button marked "run" is now pressed "in." This is the position of "ready" to go forward on high and when the

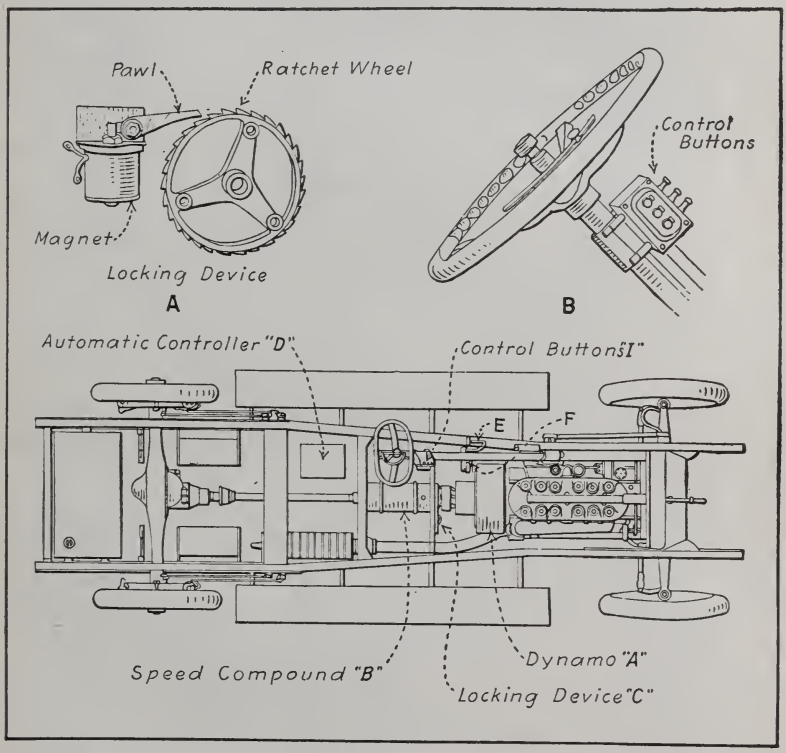


Fig. 524.—Diagrams Showing How the Vesta Transmission is Utilized.

accelerator is operated, giving the engine gas, the car will move forward. If it is desired to go backward from the "ready" position, pull the reverse button on the dash, feed gas to the engine, and the car will move backward.

When the load is greater than the magnetic pull, the car slows down and stops, but the engine continues to run as it cannot be stalled and the dynamo charges the batteries. To go ahead from this position, the button marked "low" is pressed in and the lower gear ratio becomes effective, permitting the car to move forward because of the

compounding of power, just as when the lower gear of a sliding gear-set. When the car has accelerated, releasing "low" button without any other operation, cut out the low gearing and the transmission is in high or direct drive.

The Vulcan Electric Gearshift.—A new system of gear shifting has been recently developed which depends on the use of electric current to shift the gears instead of the usual hand lever. The steering wheel is shown at Fig. 524A, with the various speed-changing buttons let into a box attached to the steering post. The operation of shifting a gear is very simple, consisting merely of depressing the clutch pedal and pressing down on the switch button marked with the gear ratio desired. The system is not complicated, the gears being controlled by solenoid coils, one being used for each forward speed and one for reverse. Two switches are utilized between the battery and the coils, a knife switch controlled by the clutch pedal and a push button located on the steering wheel. All changes of gears are controlled by the knife switch and the push buttons on steering wheel merely arrange the circuit for the particular speed desired. A glance at the cut shows that the clutch pedal moves through a link during the first part of its motion and during the remainder picks up the link and carries it along with it. Thus the first movement is the regular operation of the clutch, but a continued operation of the clutch lever actuates the knife switch.

Current flows from the battery through the solenoid coil and pulls a plunger against a magnet with a force which is given as 40 to 100 pounds. This energy is transmitted through an arm to the gear-shifting fork and gear in exactly the same manner as if the gears were operated with a hand lever. The plungers are normally in a neutral position. When the button is pressed on the control member, current passes through the coil around one of the plungers, drawing it against the magnet. It is said that the current required to make the shift is about 17 amperes, and it is claimed, further, that three hundred speed changes may be made with less current consumption than is required in starting the motor with an electric starting device.

An advantage claimed for this electric gearshift is that the gears cannot be stripped, for the reason that the clutch must be disengaged before a shift can be made and the gears are always in neutral before the coils can accomplish the change. Furthermore, no two speeds can be utilized at the same time, because each speed is governed independently of the others, and an interlocking device prevents the operator from using any two buttons at one time, even if he should make a mistake or be careless.

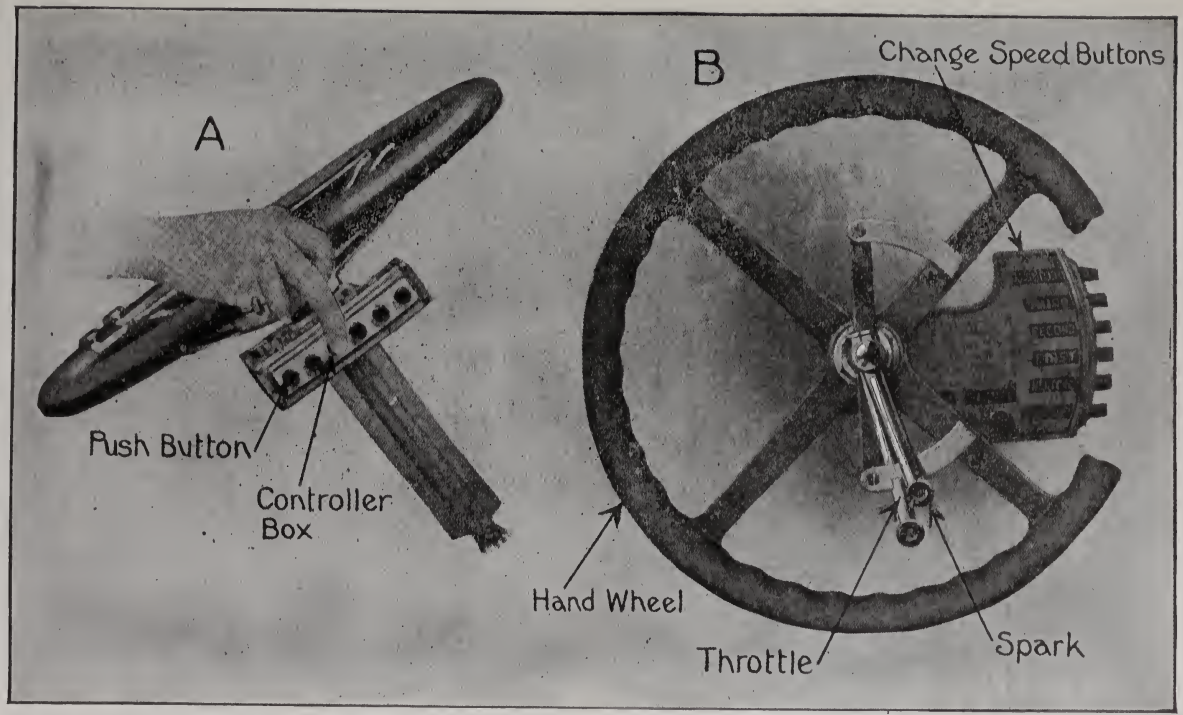


Fig. 524A.—How the Change-Speed Buttons are Located on the Steering Post of Cars Utilizing the Vulcan Electric Gearshift.

The box which contains the switches and solenoid coils is mounted at the side of the gear box, and it is said that the device adds only 46 pounds to the weight of the chassis. On the S. G. V. car the control buttons are mounted in a neat aluminum box on the steering wheel, one for each speed, and one for a neutral member. In operation the system is very simple. If, for instance, the fourth speed button is pushed down and the clutch is thrown out and then reëngaged, the car will remain in fourth speed. When driving in traffic on the third speed the driver may set the second speed button and by depressing the clutch pedal fully will automatically shift into second speed. In a similar manner all other changes may be made. The driver need not lift his hand from the wheel in order to accomplish any change in the gears. Those who have witnessed the operation of this device state that the system is quiet, the only noise being a slight click as the gears engage when changed.

CHAPTER X

THE CHASSIS AND ITS COMPONENTS

Frame Design and Construction—Underslung Frames—Materials Employed in Frame Construction—Tubing—Wood—Steel—Typical Pressed Steel Frames—Raised Frame Side Members—Cambered Frames—Brush Frame—Suspension of Motor Vehicles—Design of Leaf Springs—Common Forms of Springs—Semi-Elliptic Springs—Full Elliptic—Three-quarter Elliptic—Cantilever Springs—Unusual Spring Designs—Quarter Elliptic Springs—Double Springs—Springs without Shackles—Spring Attachment—Modern Chassis Designs—Adjustable Clutch and Brake Pedals—Universal Joint Types—Spring Plate Universal Coupling—Why Fabric Couplings are Preferred to Steel—How Automobiles are Steered—Steering Gears—Worm and Worm Wheel Reduction—Nut and Rack Types—Lubricants for Chassis Parts—Suggestions for Oiling.

THE average motor-car chassis is composed of a number of parts distinct from the power plant and transmission groups. The important components are the axles, the steering system, the method of power transmission to the wheels, the design of the frame, and the spring suspension means. The frame forms a connecting link between the motive power and the parts which serve to support the body and machinery. Formerly frames were made in many different styles and a number of different materials were utilized in their construction. At the present time the practice has crystallized to a point where certain construction has been definitely accepted as the best and this is generally followed in practically all forms of motor cars.

Frame Design and Construction.—The usual arrangement of the components of typical chassis forms is outlined at Fig. 525. The power plant and its accessory groups as well as the change-speed gearing have been previously described, and the chassis forms outlined are presented to show the two distinct systems of chassis construction that have been used, though that at the top is now generally followed. The arrangements of parts depicted has become accepted as best practice and practically all motor cars are about the same in general design. The arrangement of the chassis shown at A is the conventional one, and in this the frame which carries the operating

parts is mounted above the axle. In the form shown at B an underslung frame construction is used. In this case the springs are coupled to the axles, but the frame members are suspended from the springs instead of being placed above them as shown at A. But few cars were made incorporating this feature, which is practically obsolete at this time.

The advantages claimed for the underslung construction are that it is more stable because the weight is carried nearer the ground and the car is more easy riding and will sway less at high speeds than those types where the frame is carried above the axle. The advantage of bringing the center of gravity close to the ground is clearly illustrated at Fig. 526. At A the center of gravity of a heavy limousine car which has an underslung frame is at a point just above the axle, and if the car tilts over a marked degree, a line drawn from the center of gravity will fall within the area of the base of support as represented by the rectangle, the corners of which are at the contact points of the wheels and the ground. The center of gravity of any body is the theoretical point around which the weight may be said to be evenly distributed, and whenever a line drawn from the center of gravity falls within the base line of any body or mass it is in stable equilibrium.

In the case outlined at B the center of gravity is carried higher because the frame is mounted above the axle and conditions may obtain where the line drawn from the center of gravity will fall outside of the base line and the car tip over. While the conditions shown are somewhat exaggerated they will serve to make the comparison clear and will enable the nontechnical reader to understand the advantage of carrying the weight of the machinery as near the ground as possible to secure steadiness at high speeds.

The factor of carrying the weight low is much more important in the case of cars which are to be equipped with large closed bodies of the limousine type. It must not be inferred that it is not possible to carry the weight low with the form of frame construction defined at Fig. 525, A, as in the case illustrated the machine weight is carried practically as near to the ground as it is when the underslung frame shown at B is employed. The difference in center of gravity of the whole machine is evident only when the body is fitted and it will be carried considerably lower with the underslung frame than in the one where the frame members are mounted above the axles.

Materials Employed in Frame Construction.—The first motor cars were based somewhat on experience obtained in bicycle construction and had frames made of steel tubing. This material was not as

suitable for motor-car frames as it had been for the lighter two-wheeled vehicles because the multiplicity of brazed joints necessary made the frame quite a costly proposition. Then again the round section of the tubing did not offer as easy means of attaching the engine and transmission units as do those frames which are composed of members having a rectangular section. Tubing is used only in subframe work at the present time and in very few cases.

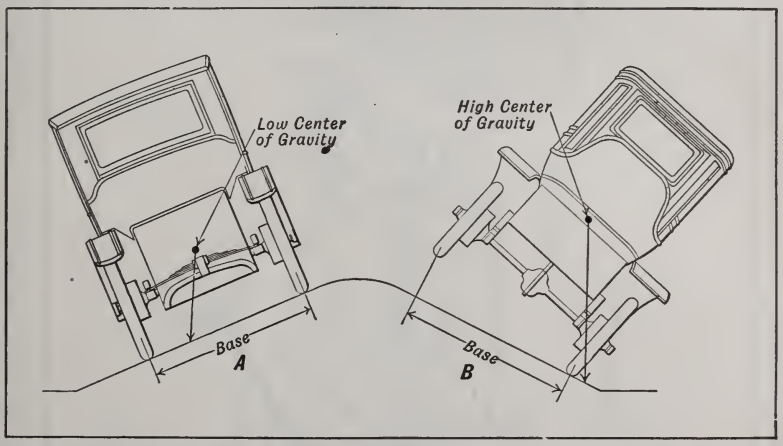


Fig. 526.—Advantage of Low Weight Placing and Carrying Center of Gravity Near the Ground. A—Low Center of Gravity Makes for Stability. B—High Center of Gravity Unsafe.

Following the use of the tubing, automobile builders used angle iron and other structural shapes available on the open market. Other makers used wooden frame members, but at the present time one rarely finds either structural iron or wood used in pleasure cars, though both of these materials have been applied to some extent in motor-truck construction. Some makers, notably the Franklin Company, employ frames which are made of laminations of specially seasoned and strong wood. The majority of manufacturers, however, favor the use of pressed steel forms which are not only light and strong but which have a degree of flexibility which is very desirable and which is not easily obtained with the various structural shapes in iron.

Frames may be divided into five main classes, as follows: Those in which wood only is used, forms utilizing pressed steel construction, types employing steel tubes, frames built up of iron structural shapes, and combination frames where two or more different methods of construction may be combined. For instance, it is possible to reën-

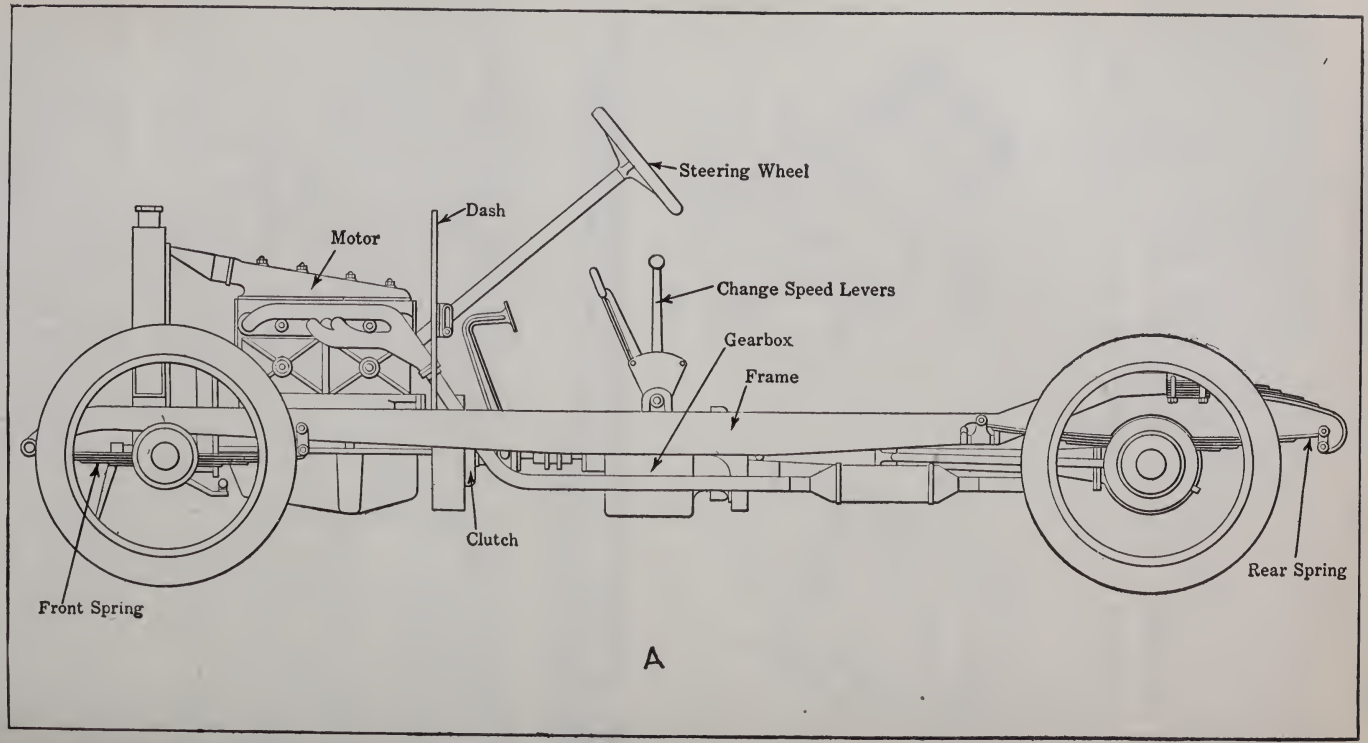
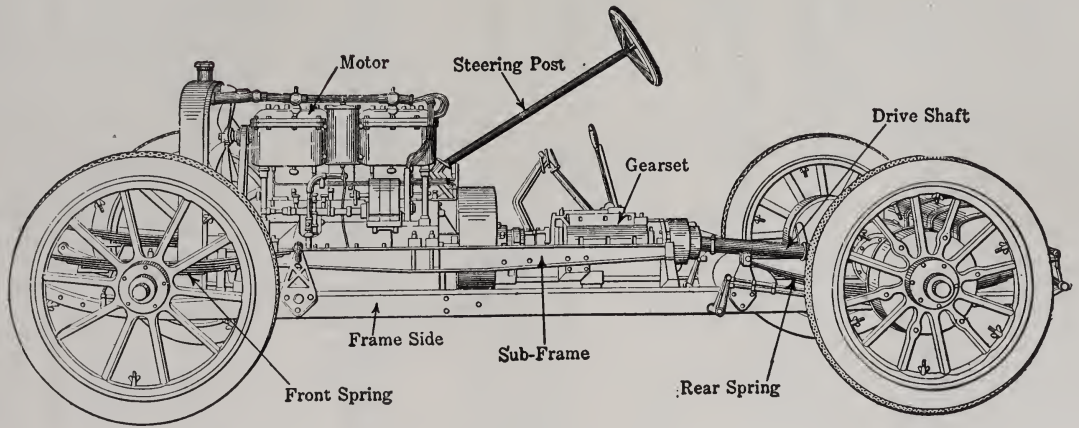


Fig. 525—Radically Different Gasoline Automobile Chassis Forms. A—Type in Which Frame Is Mounted Over the Axle, the Usual Construction. B—Underslung Chassis, Now Practically Obsolete, in Which the Frame Is Suspended Beneath the Axles.



B

Fig. 525—Continued.

force a wooden frame side member with a strip of steel or iron, or at the other hand, some makers sometimes fill the channel of a pressed steel frame with wood to strengthen it. Each of these main divisions might be again divided. For instance, wood frames may be made of a solid strip or beam or may be composed of vertical or horizontal laminations. Pressed steel may be made into channels, angles, or modifications of these, while frames composed of tubing may be square, rectangular, or round section. The various structural shapes may be utilized in the form of plate, angles, T rail sections, and I beams.

A typical pressed steel frame is shown at Fig. 527, and this is the type which is very generally employed. The frame-side members are

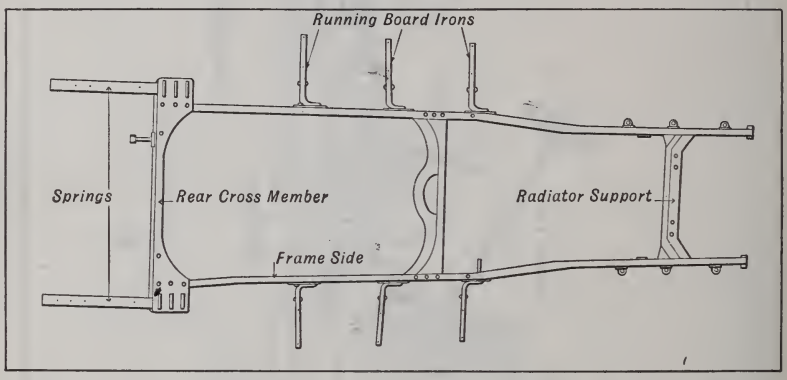


Fig. 527.—Conventional Form of Pressed Steel Automobile Frame with Cambered Side Member at Front End.

two pressed steel forms cambered at the front ends and joined together by a series of three cross braces. The front one serves as a radiator support, that in the center provides anchorage for the torque tube of the axle, while the rear cross member projects on either side of the frame and provides a point of anchorage for the rear supporting springs. The object of cambering the frame members in front is to provide a greater angle of operation for the front wheels and to permit turning on curves of smaller radius than would be possible if the frame members were straight and movement of the wheels limited thereby.

In some frame constructions where semi-elliptic springs are used at the rear end as well as the front of the car, the frame is sometimes raised at a point directly over the axle, as shown at Fig. 528, A. Often a double drop is provided in the frame side, as shown at Fig.

528, B. In this construction the frame side is straight to a point about half the length of the chassis, then it drops and when it reaches the axle it raises again to allow for movement of the axle. The object of dropping the frame is to provide a slightly lower floor board placing than would be possible if the body was carried at one level. The rear upsweep, by raising the back end of the frame, enables the axle to be carried in a position that will permit a nearly straight line drive. It will also bring the running board of the car closer to the ground, which makes the body more accessible, and it lowers the center of gravity as well. At the same time sufficient space is provided between the raised rear end and the axle to permit of using

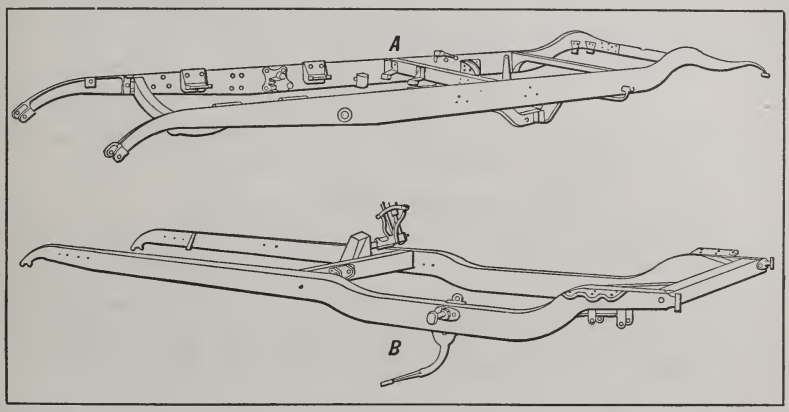


Fig. 528.—Frame Forms Having Raised Side Member. A—Frame Side Member Raised Over Rear Axle. B—Framework with Dropped Side Members.

springs which will be adequate to support the weight of the mechanism and body and yet permit these to have a considerable radius of movement and make for much easier riding.

Considerable interest obtains at the present time in frames of the type shown at Fig. 529. This is a patented construction known as the Brush frame and is a built-up member made of steel stampings having a particularly deep section to the side members. The running boards are of steel, bent up at each end to form the lower portion of the fenders. The running board is riveted to the steel side member, greatly stiffening and strengthening it. Obviously, the running board supporting irons and usual mud apron are eliminated. This type frame is used on the Moline-Knight, Monroe and Marmon cars.

By bringing the lowest level of a drop frame at a point between the front and rear it is possible to carry the body low and at the same

time support the engine and transmission at a sufficient height above the ground to insure ample clearance between the bottom of the motor and the surface of the roadway. The advantage of the pressed steel frame over the other forms is that it is a very easy type to make and very cheap after the forming dies have been made. It lends itself readily to designs where it would not be possible to use the wood frame because of the serious diminution of strength if wood is bent in any way that will distort the grain.

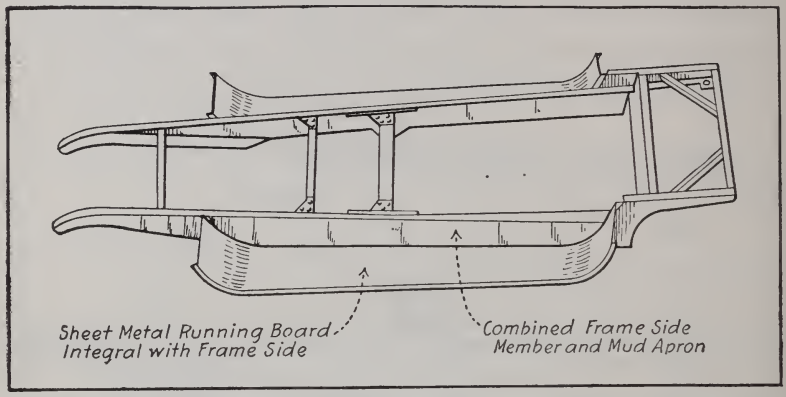


Fig. 529.—The Brush Frame Design Has Exceptionally Deep Section Side Member to which Running Boards are Attached Directly.

Suspension of Motor Vehicles.—One of the most important problems in connection with chassis designing is that of the supporting members which join the frame to the axles and which are depended upon to absorb much of the shock and jar incidental to motor-car operation. The importance of the springs and the part they play in promoting the comfort of the passengers, the durability of the machinery, and economical application of power are but little appreciated by the majority of motorists. One point that has made it difficult for the automobile designer to evolve spring types which were entirely satisfactory was the paucity of data regarding spring action of high-speed vehicles. The forms of springs that were used on wagons and carriages were studied, but when these were applied to motor cars which had much greater speed than the simpler vehicles the problem assumed a new aspect. While the horse-drawn vehicle operates on rough roads the speeds are comparatively low, and the roughness of the roads is not such an important factor as it is in the design of automobile springs. Railway cars were studied in

the hope of finding a solution. Here the conditions are reversed, and while they operate at high speeds they run on comparatively level-steel rails and the conditions of operation make the problem of spring suspension one that is not difficult.

One point greatly in favor of the motor car is that for the most part these are mounted on pneumatic- or air-filled tires and these have valuable cushioning properties in themselves and are of material value in solving the problem of spring suspension. It is very difficult to combine both strength and resiliency in springs, as if these are made light and flexible they are not likely to be strong. A vehicle that might be very easy riding on good roads would have too much spring movement if the springs were lacking in strength when operated on rougher road beds. At the other hand, if springs are made stiff to take care of severe conditions they will be hard acting when used on smooth roads.

Another factor which makes it difficult to select the proper springs is the variation in weight carried. When an engineer designs a five-passenger touring car he must provide springs of adequate strength to take care of the car when it carries its full complement. If but two passengers are carried the car will be stiffer riding than when the weight of five persons must be supported.

An added point that makes it difficult to select springs for automobile suspension except by experiment is that the propelling force forms part of the conveyance and power must be transmitted from the source mounted on the frame to the wheels resting on the ground. As the frame is suspended on more or less flexible members and moves in various directions, the degree of movement must be limited so there will be no excessive strain imposed on the transmission mechanism. Ease of riding is largely determined by the radius of movement or upward throw of the body, and the object with any kind of spring suspension is to reduce the up and down movement to as low a point as possible without actually retarding the vibrations. Rapid vibration of the springs will cause discomfort and will affect to a considerable degree various parts of the chassis which connect the frame to the axle, such as radius rods, steering connections, torque members, and driving means.

Of the various forms of springs it is possible to use the laminated leaf spring is that which has been generally applied on automobiles just as its use has become universal on horse-drawn conveyances. The great value of the laminated leaf spring is that its capacity can be varied by changing the number of plates or leaves used and almost any desired degree of resiliency can be obtained by varying

the thickness, grade of material, and width of the plates of which the spring is composed.

Design of Leaf Springs.—The leaf springs used for the suspension of road vehicles consist of several layers of steel plates so shaped that when laid together they form superimposed arcs of as many circles as there are leaves. The spring effect is obtained by the elasticity of the metal used which is increased in value by a process of

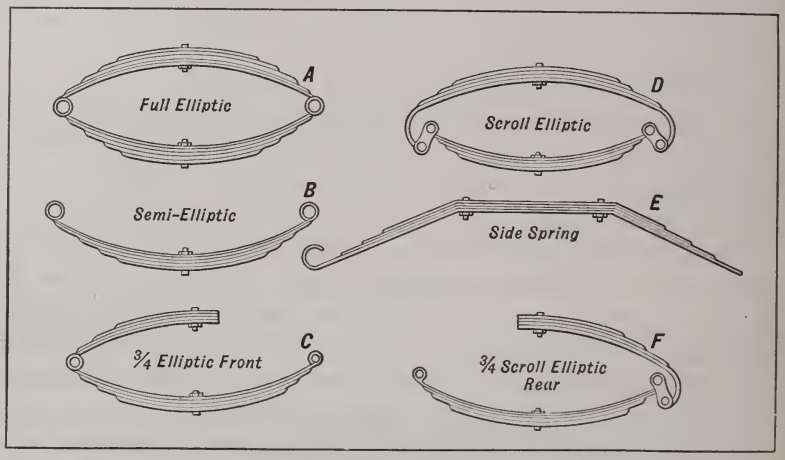


Fig. 530.—Springs Usually Employed for Supporting Motor-Car Frames and Horse-drawn Vehicle Bodies.

heat treatment known as tempering. The leaves are usually graduated in thickness, being thicker at the center and tapering from the center to the ends.

The reason for following a common line or arc when a spring is composed of more than one leaf is that as all of the leaves are deflected at once by the load and as the tendency is to straighten out the curved member, they should slide upon one another when altering their shape in such a manner that they will always be in contact with the neighboring leaf at all points. If the curvature of the leaves differed appreciably the tendency of the plates under load would be to straighten out and separate and the load would only be carried on those members which were in contact at all points. This would be undesirable because it would cause a loss of spring action and would also result in frequent breakage.

The common forms of springs which have been used for supporting motor-car frames are shown at Fig. 530. That at A is a full elliptic type and consists of two semi-elliptic spring members hinged together

at their ends. The semi-elliptic type, which is half of a full elliptic spring, is shown at B. The spring illustrated at C is a three-quarter elliptic form used for suspending the front end of some types of cars. The scroll elliptic spring depicted at D is a modification of the full type, but it is somewhat more flexible because the lower member is fastened to the upper by means of shackles which permit more movement than the rigid bolt and eye connecting the members of form A. The side spring depicted at E is a modification of the side spring commonly fitted to Concord buggies, and while it has received some application on earlier forms of automobiles it is not used at the present time. The form shown at F is a three-quarter scroll elliptic member which is very widely used at the present time for rear suspension of motor cars, especially in those chassis having upswept rear ends.

The application of the spring forms previously considered to the front end of motor-car frames is outlined at Fig. 531. When semi-

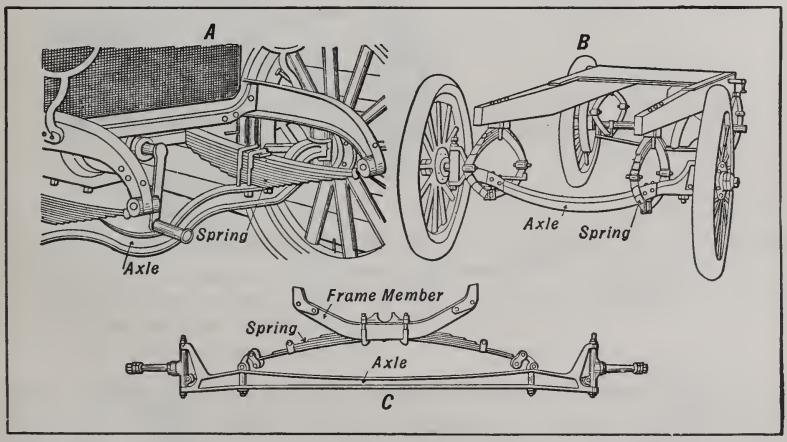


Fig. 531.—Spring Suspension Means for Front Ends of Motor-Car Frame. A—Semi-Elliptic, the Most Popular Method. B—Full Elliptic of Franklin Car. C—Single Cross Semi-Elliptic Spring of Ford Design.

elliptic springs are used at the front of the frame, there are various ways of attaching them. In some cases, the fixed point may be at the rear and the shackle at the front end, as shown at C and D, Fig. 532. The methods of suspension shown at A and B are most often followed, however. The views at Fig. 533 show various spring combinations used for rear-end suspension. The common method of supporting the front end is shown at Fig. 531, A, and is used on the greater pro-

portion of motor cars. Of the rear suspensions that shown at Fig. 533, D, is popular on heavy vehicles, while the full elliptic depicted at C and the three-quarter scroll elliptic outlined at E also receive general application. The semi-elliptic spring is not as easy riding as the other forms unless it is made very long and composed of but a few

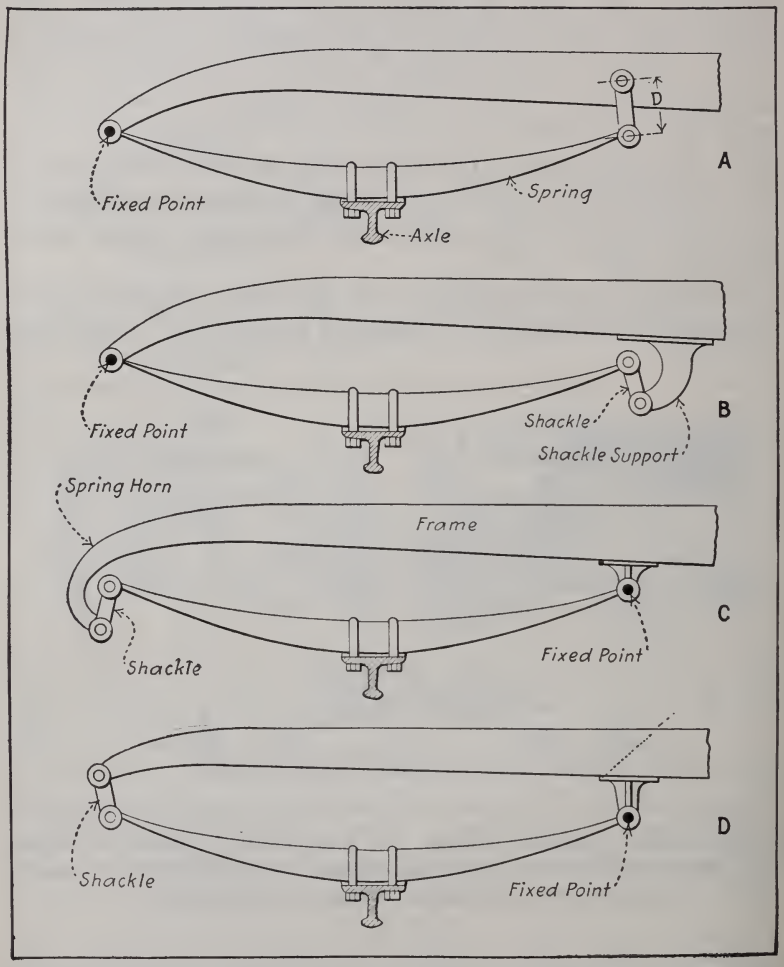


Fig. 532.—Showing Various Practical Methods of Shackling Front Spring. Forms Shown at A and B Most Generally Used.

leaves. The various full and three-quarter elliptic forms are much more flexible than a semi-elliptic of the same length and are more generally used for rear suspension where a greater degree of movement is desirable than at the front end.

The cantilever spring was first applied to automobiles by F. W. Lanchester, of England, who has favored this type for years. With a cantilever spring there is less unsprung weight on the rear axle than with the usual type, as it is apparent that only those portions of a spring which move up and down through the same range as the body are fully spring supported. The parts fastened to the axle are wholly unsprung and intermediate portions are only partially spring supported. Another advantage of the cantilever spring is that for a

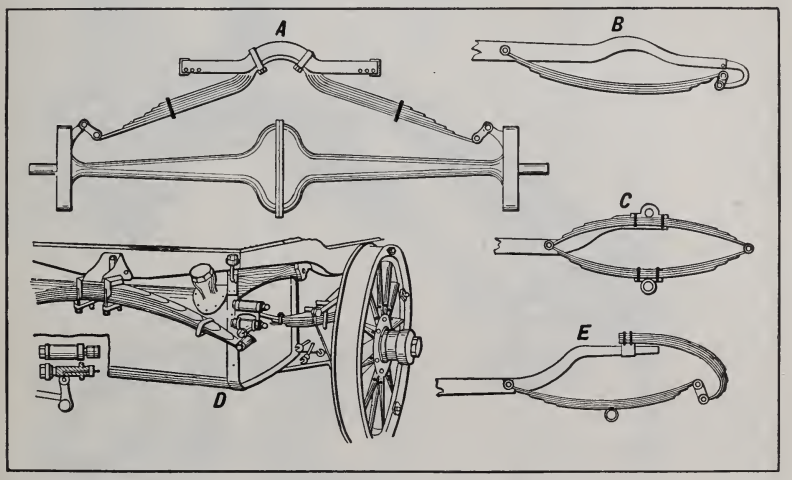


Fig. 533.—Spring Suspensions for Rear End of Automobile Chassis. A—Single Elliptic Cross Spring of Ford Cars. B—Semi-Elliptic Side Member. C—Rear Support by Full Elliptic Spring. D—Platform Spring Construction. E—Three-quarter Elliptic Spring.

given length of body and frame it permits a longer wheel base or provides the same effect. The way the spring is attached to the frame side members permits of increasing the wheel base eight or ten inches over that possible with a conventional semi-elliptic or three-quarter elliptic spring unless these have a large overhang at the rear of the vehicle. If a certain car is equipped with semi-elliptic springs and these are changed over so the mounting is as a cantilever spring, one would find that they deflect more than before, and that they are more susceptible to minute road irregularities than they were when hung up in the conventional manner.

The usual method of hanging a cantilever spring is shown at Fig. 534-A. The thickest portion of the spring is attached to a fitting, which rocks on a hanger pin secured to the frame side. The front end of the spring is shackled to the spring support in the usual

manner, while the rear end is attached to the rear axle, as outlined at Fig. 535-C. Sometimes two cantilever springs are used, as in the Austin design shown at Fig. 535-D, or a cantilever may be used in connection with a quarter elliptic for front suspension, as in the

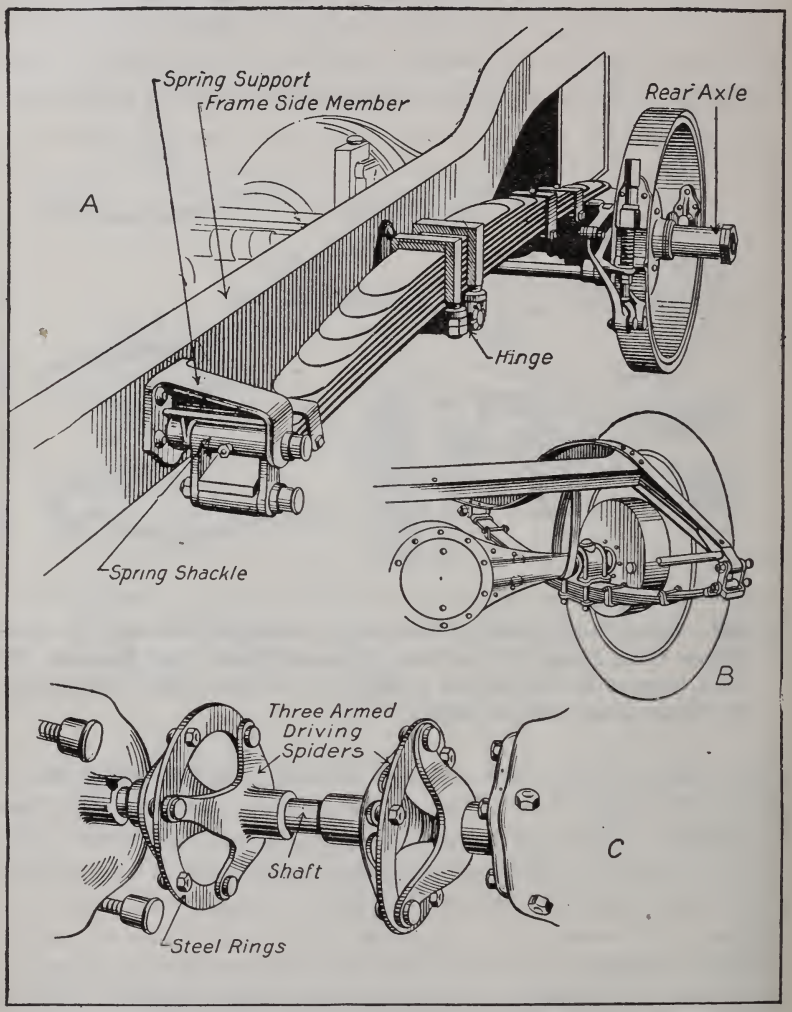


Fig. 534.—Recently Devised Methods of Springing at A and B and Steel Plate Universal at C.

Moore design, outlined at Fig. 535-A. Another tendency is to use the underslung semi-elliptic or three-quarter elliptic springs, as shown at Fig. 534-B. This makes it possible to carry the weight lower than

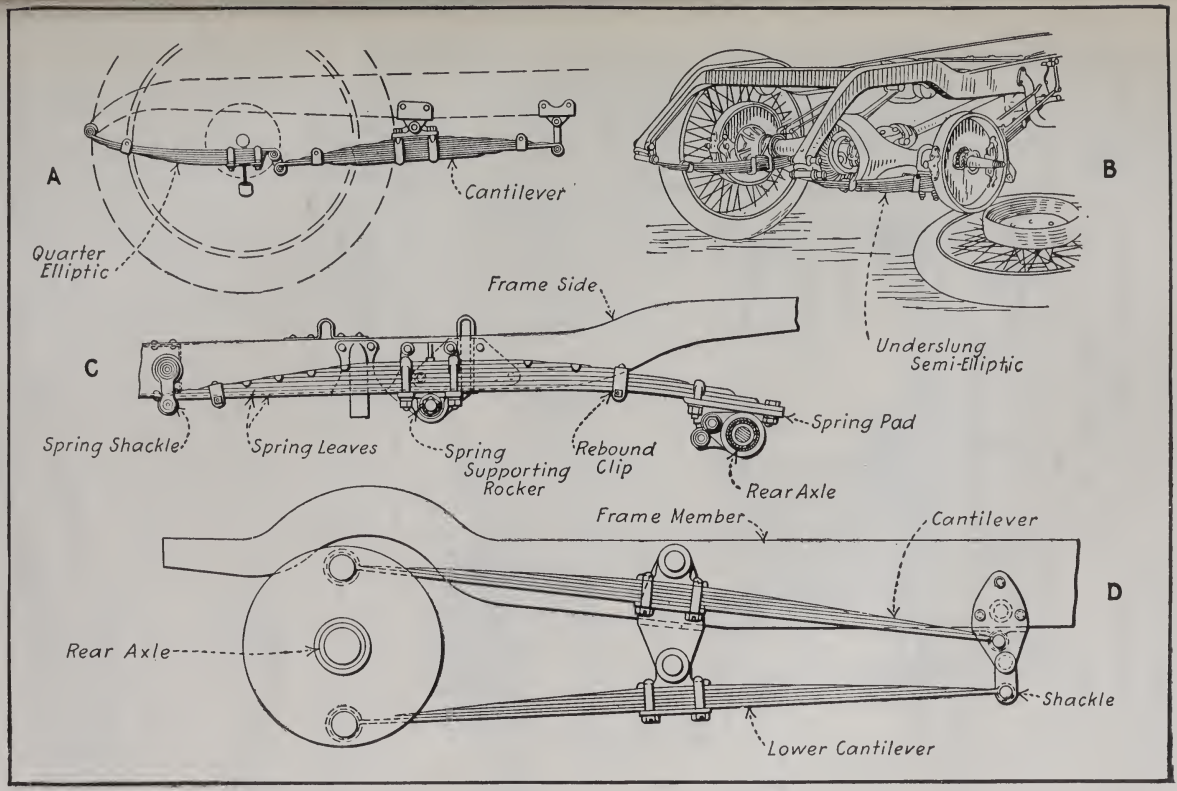


Fig. 535.—Various Methods of Suspending Automobile Frames. A—Combination Quarter Elliptic and Cantilever Spring Support on Some Lexington Models. B—Underslung Semi-Elliptic, a Popular 1917 Development. C—Cantilever Spring Showing Anchorage to Frame and Axle. D—Double Cantilever Spring Used on Austin Cars.

is the case when the spring is placed on top of the axle, and it also permits a greater range of spring movement without cambering the frame side member unduly.

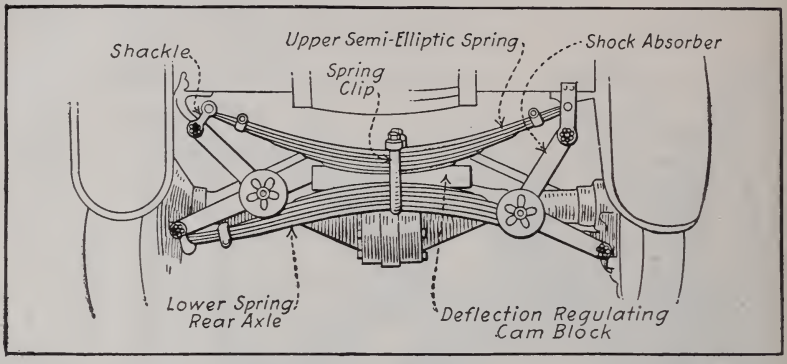


Fig. 536.—The Distinctive Brush Rear Spring Suspension System Used on Marmon, Moline Knight, and Monroe Cars.

An unusual method of rear suspension which is used in connection with the Brush frame design previously outlined is shown at Fig. 536. This consists of two semi-elliptic springs joined together at their center by a cam block which limits spring deflection. Side throw is prevented by shock absorbers mounted between the spring ends, as outlined.

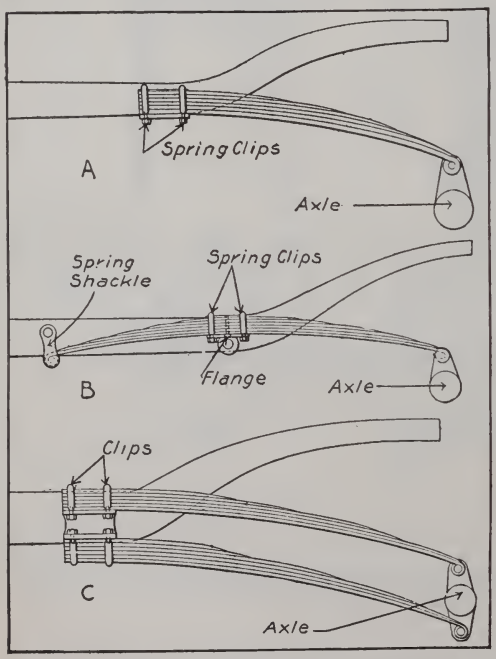


Fig. 537.—Methods of Using Cantilever and Quarter-Elliptic Springs.

A number of light cars offered have true cantilever springs, which have been generally known as "quarter elliptic," for front or rear end suspension. Contrasted to the usual construction of cantilever springs, as shown at Fig. 537-B, it will be seen by refering to Fig. 537-A, that this spring is only half of a semi-elliptic member. It is fas-

tened securely at its front or big end by means of spring clips to a frame bracket and to a suitable carrier on the axle at the rear end. These springs are sometimes made double, as shown at Fig. 537. This is a reversion to an early design which was not thoroughly practical on account of the spring steels then available. At the present time spring steel combines great strength, endurance and flexibility, and the simple springs that were formerly unsuitable can be used to ad-

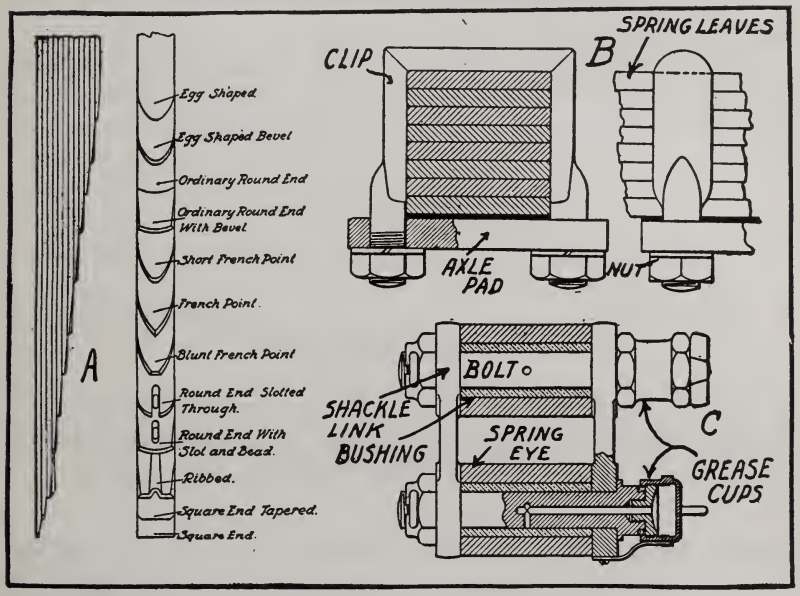


Fig. 538.—A—Defining Designation of Finishes of Spring Leaf Ends. B—Showing Construction of Spring Retaining Clip. C—Section of Spring Shackles Using Lubricated Shackled Bolts.

vantage. In several light cars the quarter elliptic shown at Fig. 537-A is used for front suspension, though when used in this manner the lower leaf is strengthened and is attached to the spring pad in a positive manner. This form of spring is found on the Saxon and Chevrolet 4-90 models. The various finishes for spring leaves are shown at Fig. 538-A. The usual form of hold-down clip is depicted at B, while the approved type of simple spring shackle is shown at C.

Springs Without Shackles.—Spring shackles are a part of the automobile that have been improved very slightly because practically no change is possible owing to their simplicity. These shackles are subjected to severe loads, and as they are practically always in motion to compensate for spring movement they soon wear and are a fertile

source of rattling noise. A special spring construction, which is illustrated at Fig. 539, has been devised to do away with the shackles by the substitution of a supplementary spring action. In the design outlined the curved ends of the main spring leaf provides sufficient flexibility so that the slight alteration in the form of a main spring produced by flexure will compensate for the change in length of the curved spring as it flattens out under the load. These springs are still in the experimental stage, but seem to offer commercial possibilities.

When an automobile chassis is suspended on springs the frame will move in various directions. There is a certain amount of forward and backward end throw, an element of side sway and the

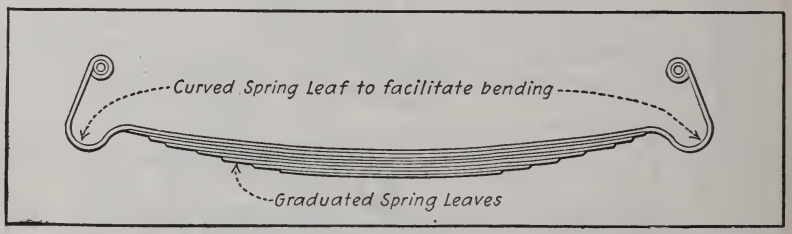


Fig. 539.—Experimental Form of Semi-Elliptic Spring Intended to be Used Without Spring Shackles.

up and down motion caused by the deflection and recoil of the spring. The object of an efficient spring suspension should be to minimize the end throw and side sway as much as possible and yet preserve the freedom of movement of the spring. It is for this reason that the semi-elliptic form is so popular for front suspension. It is a stiffer member than the others and is better adapted to carry the weight of the power plant without side away and to keep the front axle in that relation with the steering mechanism necessary to secure the best action.

In general the methods of suspension employed by automobile designers follow closely those that have been used for a number of years by manufacturers of horse-drawn vehicles. When elliptic or semi-elliptic springs of the ordinary description are used one will see that in most light horse-drawn carriages but two are employed, one being placed over each axle and parallel with it. In motor cars one seldom finds a single spring used for suspension at both ends. Usually if one spring is placed in this manner over one of the axles there are generally two arranged in the conventional manner over the other

axle to provide a three-point support. A notable exception is the Ford car which employs a single cross spring at each end of the frame.

When only one spring is used in this manner radius or distance rods are required to maintain a fixed distance between the axle and the frame at the front axle, and more substantial members of the same character which will have to take the driving torque effect as well as the braking stresses will be required for the rear end. This makes two sets of radius rods necessary on each car. Most automobile designers favor the use of two semi-elliptic springs at the front end because with these there will be no need of using radius rods, as the springs are capable of maintaining the proper relation between the axle and the frame as well as resist the pushing or pulling effect depending upon location of shackle, due to vehicle movement, which would otherwise have to be taken by radius rods.

With practically all forms of rear suspension, especially in those which utilize the elliptical forms of springs, the inevitable forward throw makes the use of radius rods desirable on heavy cars and trucks, though good results are being secured by using the Hotchkiss drive system with specially designed semi-elliptic or cantilever springs. It is necessary that the proper distance be maintained between the motor mounted on the frame and the rear axle, where the power is applied to the wheels. The amount of play permissible is governed entirely by the character of the driving system, and with some forms there can be more latitude of movement than possible with others. In nearly all cases, however, it is essential that very nearly a fixed distance be maintained, or there will be injurious stresses on the sprockets, chains, universal joints, or gears with attendant loss of power.

A factor that has become very important is the selection of suitable alloy steels for the construction of the springs. The rapid development of high-powered automobiles which are capable of extremely high speeds had made the development of more resisting and elastic steels imperative, as the open hearth metal of standard analysis used in the manufacture of carriage springs would not make satisfactory supporting members under the severe conditions imposed by the modern automobile. For this reason, various alloy steels, such as vanadium steel and mixtures of iron, carbon, chromium, and nickel have been developed especially for fabrication into springs.

Among the other functions of springs they reduce to a certain extent the traction resistance. When the driving wheels meet obstacles the shock produced depends upon the inertia of the axle and that of the wheel which comes into contact with the impeding substance plus the resistance of the springs, which factor varies with

the elasticity and design. If the springs are not sufficiently resilient the shock will lift a portion of the car as well as the wheel and axle, whereas if elastic members are employed only the axle and spring will be affected. It is patent that more power is required to surmount obstacles when stiff springs are employed, and part of the power delivered by the engine which might be used to better advantage in propelling the car is absorbed in overcoming the obstacle.

The attachment of springs to the frame and axle is a phase of the suspension problem that is important. The front end of the front springs is usually pivoted directly to the frame in spring horns forming a portion of the frame-side member. The free end of the spring is connected to the frame by a shackle to allow the necessary motion. (See Fig. 532, A and B.) The rear springs are usually attached to the frame in a different manner than the front member because to secure maximum efficiency the rear springs should be called upon only to support the load, and they should be relieved of all traction and torsion forces by suitable torque members or radius rods. If springs of the semi-elliptic type are used with radius rods it is advisable to double-shackle them, whereas full elliptic forms should be attached to the frame by some sort of a swivel joint in order to allow the necessary motion.

The method of fastening the springs to the axle is by means of clips very similar to those that are used in carriage construction, as shown at Fig. 538, B, but they are usually heavier and of better material. The spring rests upon a piece of leather or wood placed between it and the supporting pad on the axle, and this material is usually curved enough to conform with the arc of curvature of the spring. This cushion is interposed between the two elements for two reasons, one of these being to avoid the strain which would be imposed upon the spring if attempt was made to attach it directly to the flat or slightly curved spring pad on the axle. The other reason is that the cushion provides a more rigid fastening because there is a certain amount of friction between the spring and the wood or leather piece which prevents slipping of the fastening. Authorities agree that springs should never be fastened by means of bolts passing through the leaves, as this will make a weak place in the spring which may break if stressed unduly at this point.

Some manufacturers use distinctive forms of springs developed solely for use on their product, as shown at Figs. 535 and 536. The spring shown at Fig. 540, A, was employed on some early models of the Winton cars and is a compound form which consists of two parts which are virtually separate and distinct semi-elliptic springs. These

are shackled up in such a manner that when the loads are light but one portion of the spring is used, though when the car is fully loaded both sections of the spring are brought in action. It is claimed that this method of spring construction permits easy riding under all varying conditions of load or road surface, as the strength or resiliency of the springs is governed entirely by the demands made upon it. When conditions of operation are severe the spring strength is augmented proportionately, and it becomes more resilient as the load is decreased.

The method of suspension employed on the early Brush runabout is outlined at Fig. 450, B. This is distinctive inasmuch as it was the

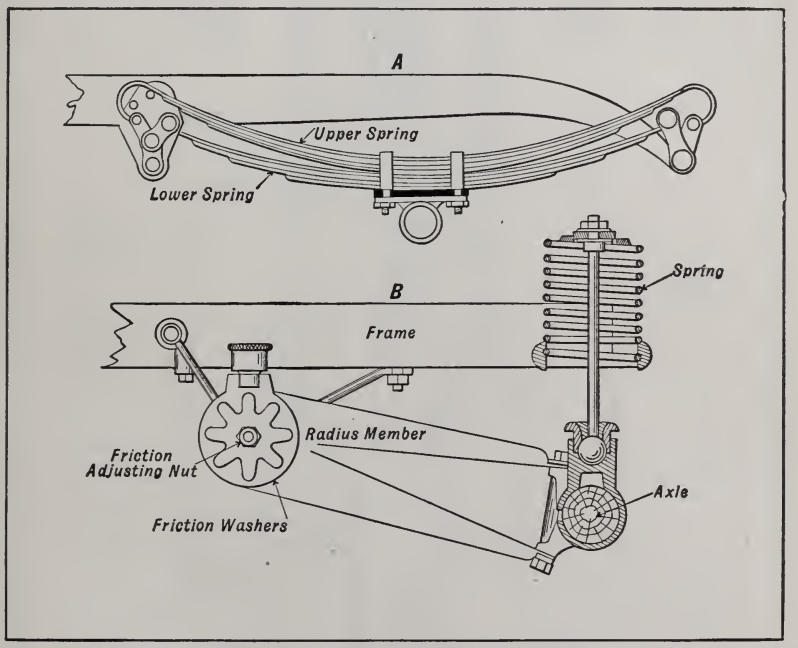


Fig. 540.—Unconventional Spring Suspension. A—Double Semi-Elliptic Used on Some Early Winton Cars. B—Coil Spring and Shock Absorber Combination Used on the Early Liberty-Brush Runabout.

only motor vehicle produced in quantities or in a commercial way which employed helical coil springs under tension to support the load. It will be noted that a combined shock-absorbing and radius-rod device is essential. This method, while extremely efficient, appears rather unconventional and was regarded as a "freak" design by most engineers. The construction is clearly outlined in the illustration and four such springs were employed, one at each corner of the frame.

Modern Chassis Designs.—An example of a modern chassis in which a twelve-cylinder V type engine is used is shown at Fig. 541. This shows clearly the combination of change speed gear set and

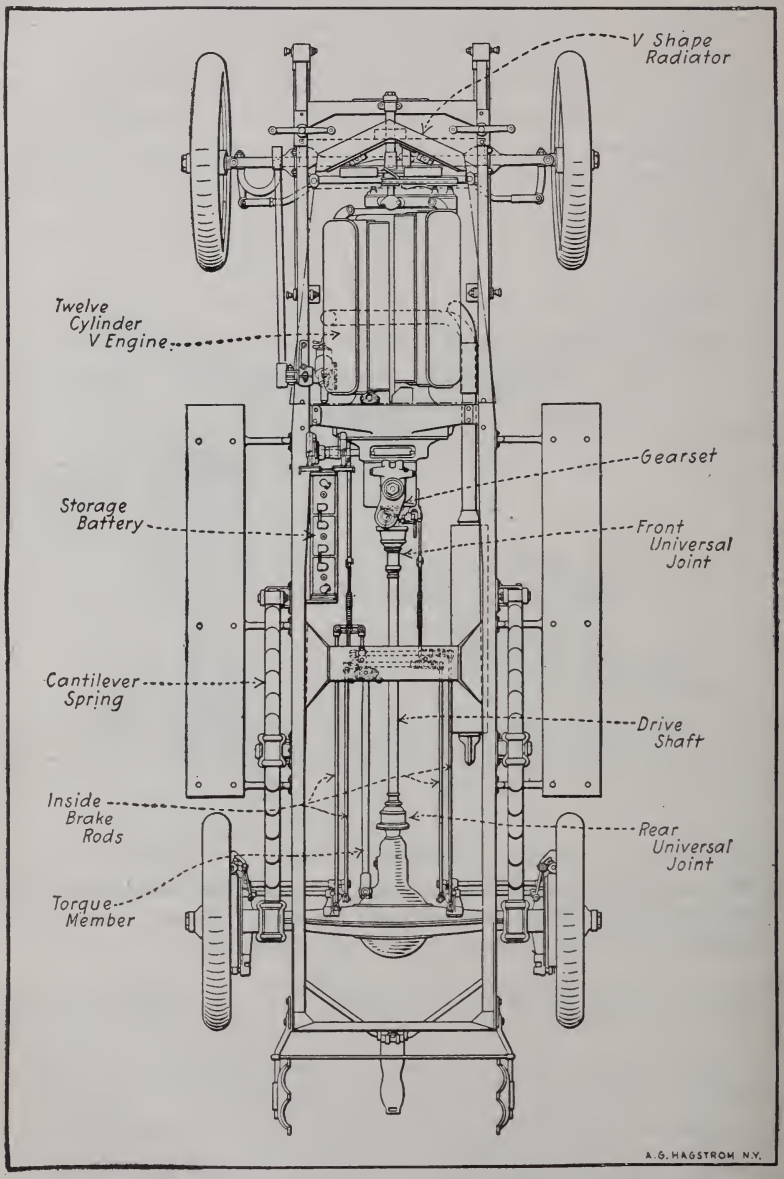


Fig. 541.—Plan View of the Chassis of the 1917 Twelve-Cylinder Pathfinder Automobile.

clutch case with the engine crank case to form a unit power plant and also outlines the application of cantilever springs, which are used

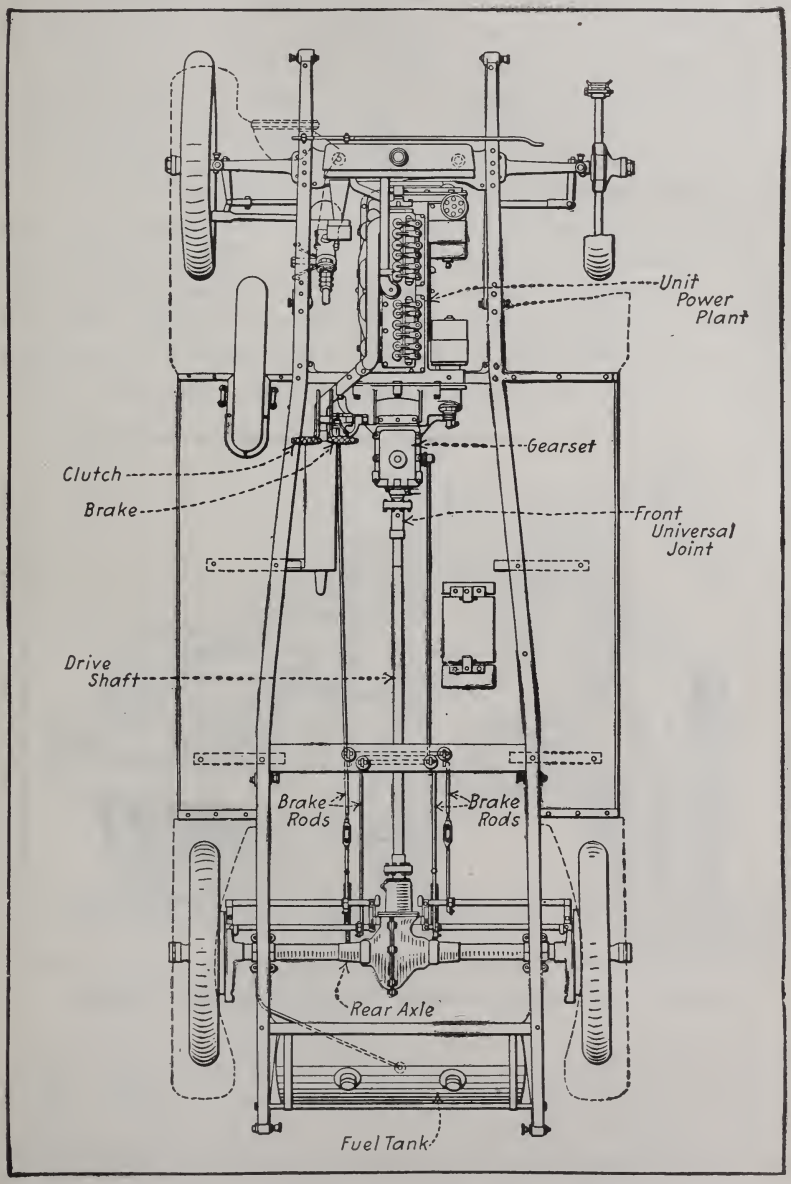


Fig. 542.—Plan View of Oakland Model 34, Six-Cylinder Chassis, Showing Modern Design Tendencies. Note Clean Layout Obtained by Using Hotchkiss Drive.

on many of the 1917 cars. The tendency toward the use of straight brake rods, all carried inside of the chassis frame, is also clearly outlined. In connection with chassis design the most evident point is a simplification of detail and the reduction in the number of parts used to operate the brakes or change speed gearing. The brake rod arrangement has been simplified in many cases, to reduce a number of supports or connecting links. The foot brake and clutch pedals, and in some cases even the steering gear, are being attached to the power plant instead of to separate points on the frame.

Another point making for simpler chassis construction is the use of the Hotchkiss drive shown at Fig. 542. With this system the braking and driving torque is taken through the rear springs, which means that all radius rods, torque members or distance rods have been completely eliminated. This reduces the number of points liable to wear and results in a quieter operating chassis. This form of drive

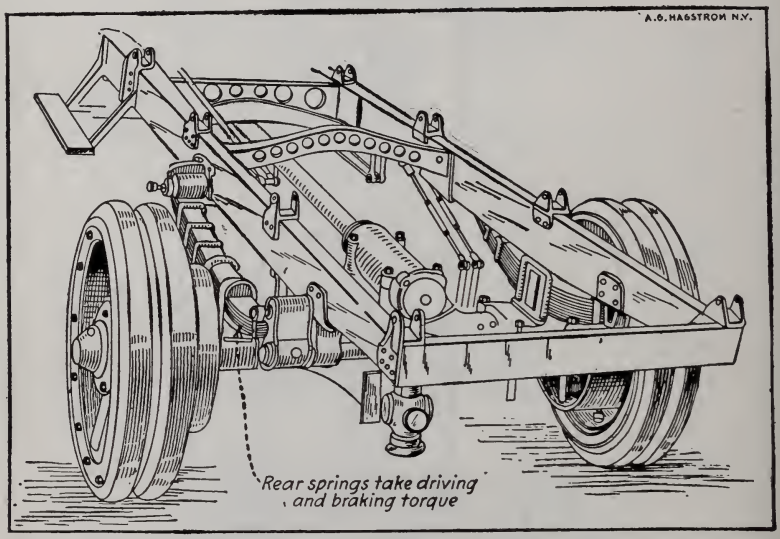


Fig. 543.—Application of Hotchkiss Drive to Motor Truck Chassis.

has been found practical on trucks, as shown at Fig. 543, as well as in pleasure cars of both the light and medium weight designs. There is some division of opinion relative to the merits of the Hotchkiss drive on heavy trucks and a number of makers of the highest grade commercial vehicles favor the use of radius members, as shown at Fig. 544, to take both the push of propelling the truck as well as taking the driving and braking torque coming on the axle.

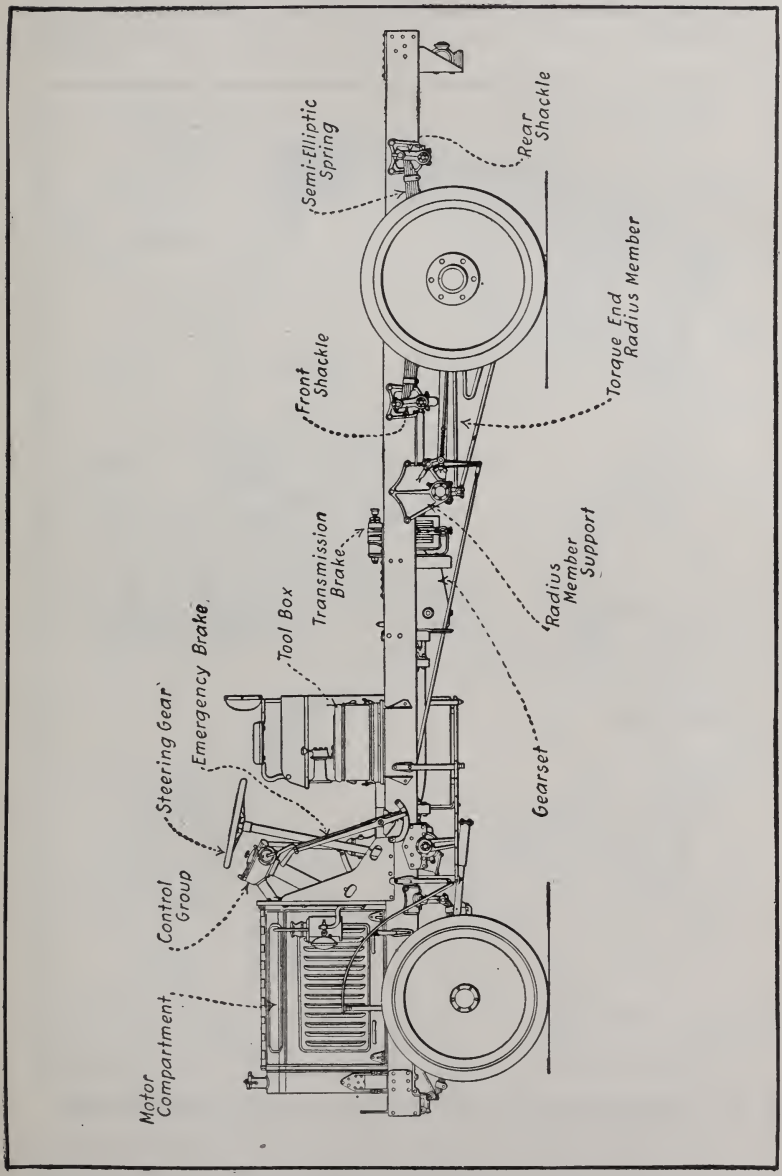


Fig. 644.—Side View of Packard Truck Chassis. Note Use of Radius Rods and Torque Member to Take Driving, Braking and Propulsive Effort. Note Double Shackling of Semi-Elliptic Rear Spring.

Modern chassis designs incorporate a number of refinements of detail that are noteworthy. The various brake actuating assemblies and grouping of control rods are now done in a more orderly manner. Equalizers are used on both sets of brake rods and adjust-

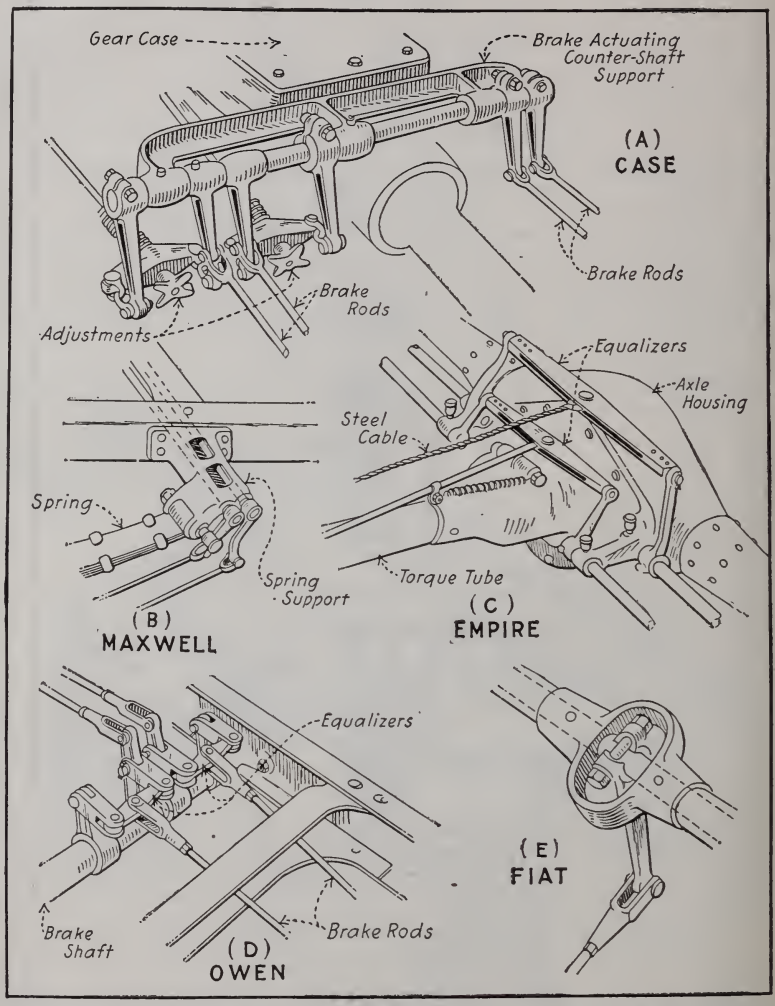


Fig. 545.—Application of Typical Brake Control and Equalizing Members.

ments are much more accessible. Steel cables are used instead of steel rods in some designs to operate brakes and reduce liability of rattling. There is a disposition to make parts perform more than one function, as shown at Fig. 545, B, where the rear spring front support

also serves to guide the brake rod actuating shafts. Sometimes the equalizers are on the rear construction as at Fig. 545, C, but they are most often mounted on the brake actuating countershaft, as shown at A and D.

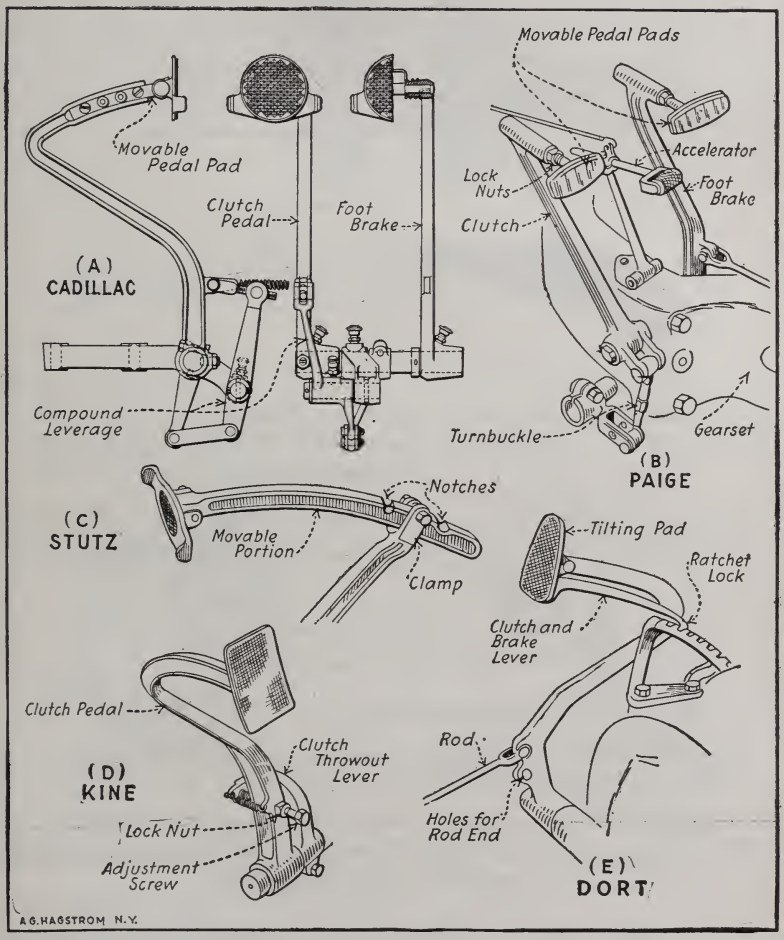


Fig. 546.—1917 Practice in Adjustable Clutch and Brake Actuating Pedal Design.

In operating clutches that have very strong springs to maintain driving engagement between the clutch members, it is often desirable to use a compound leverage to release the clutch throwout without too much exertion. A very effective clutch leverage employed on the Cadillac cars is shown at Fig. 546, A. There are two adjustments, one to permit of moving the pedal pad to suit the limb length of the

driver and a threaded adjustment to operate the compound leverage. The clutch pedal is not in direct connection with the clutch throwout shaft, but must work it through the multiplying leverage.

It is customary now to find that most all cars have an adjustment for the brake and clutch pedals. The brake pedal usually can be set as to position by the forward end brake adjustment. These sketches at Fig. 546 show different ways of giving adjustment for the clutch pedal. Paige threads the pedal piece itself, as shown at B, and screws

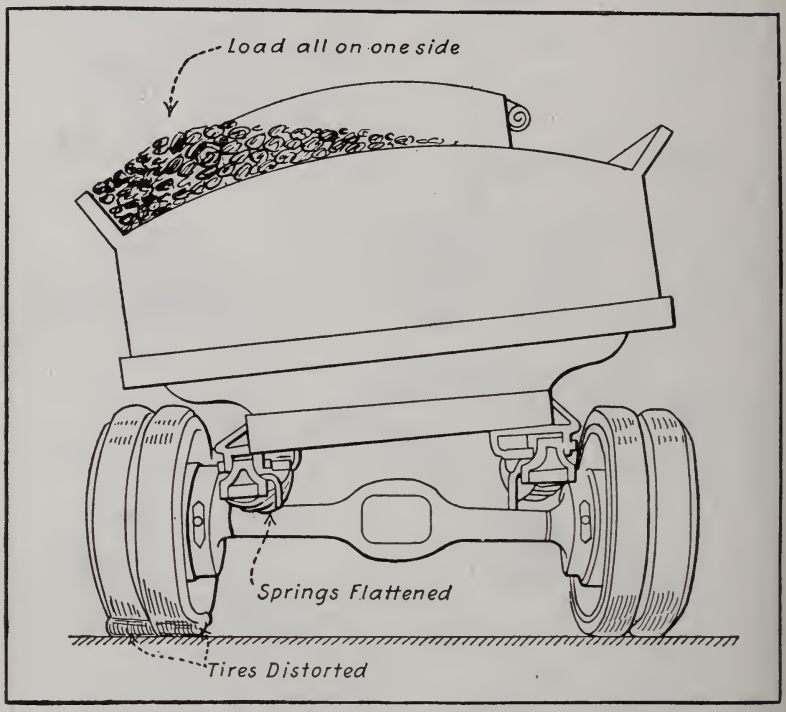


Fig. 547.—Diagram Outlining Evils of Overloading and Unequal Load Distribution on Motor Truck Frame Parts.

it into the end of the lever, and also goes to the trouble of providing an adjustment for the accelerator pedal, this being of a more simple nature. This is a very useful adjustment seldom thought of. Stutz uses a device fully explained by the cut at C, and this gives a very wide range of position to the pedal. Kline has a particularly neat adjustment, using a set screw and lock nut, as at D, the coil spring preventing the pedal from rattling. Dort has an original notion, and effects adjustability by providing a second hole at the bottom of the pedal, into which the brake-rod pin can be put, as shown at E.

Universal Joint Types.—Most cars using the Hotchkiss drive employ two universal joints in the propeller shaft to permit free move-

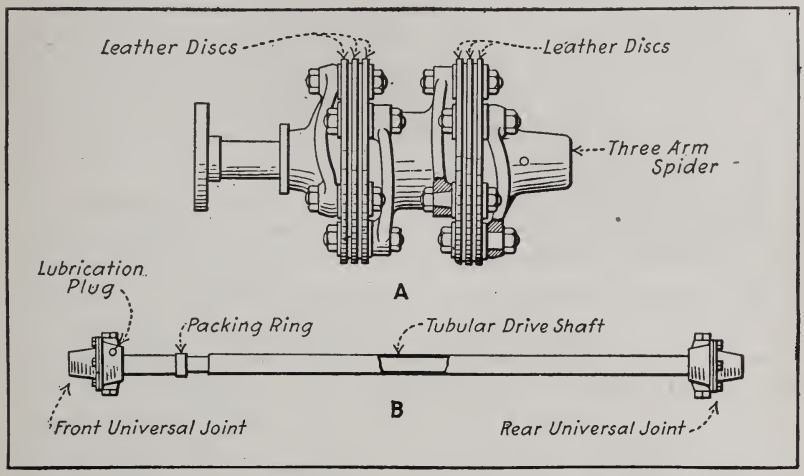


Fig. 548.—Recent Developments in Power Transmission Members. A—Universal Joint Employing Leather Disc for Flexibility. B—Tubular Drive Shaft Reduces Liability of "Whipping."

ment of the axle relative to the chassis. Various types of universal joints have been devised, the leather disc type shown at Fig. 548, A,

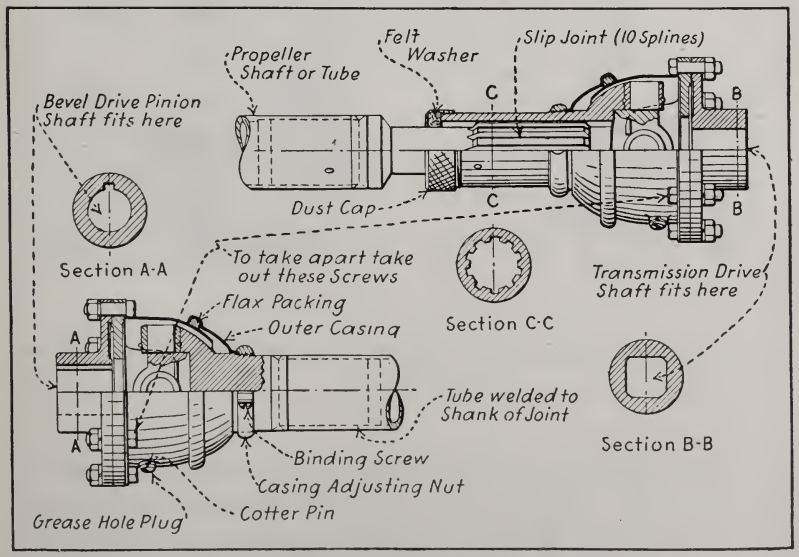


Fig. 549.—Construction of Typical Universal Joint Outlined.

being satisfactory where there is but little relative movement between driver and driving members. Where the propeller shaft is moderately long, as in any car of average wheel base using a unit power plant, the shaft is apt to "whip" because of deflection at its center. By making the shaft of tubing, the diameter is increased without augmenting the weight and deflection is greatly reduced. This is shown at Fig. 548, B, which illustrates a typical universal joint and propeller shaft assembly.

The usual universal joint construction is shown at Fig. 549. A cross-shaped member is carried between two yokes, which are free to swing on suitable bearings on the cross. It will be apparent that one yoke may drive at an angle to the other, because the cross will oscillate in its bearings to compensate for the disalignment. The best universal joints are encased as outlined and the interior of the casing packed with lubricant. Universal joints of the sliding block type are

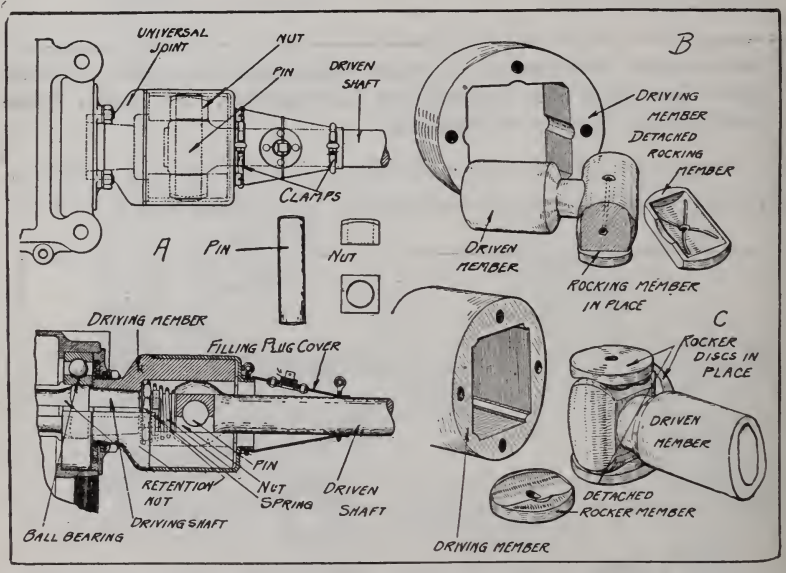


Fig. 550.—Diagrams Outlining Construction of Typical Sliding Block Pattern Universal Joints.

also used in some cases. Various designs are shown at Fig. 550, and as two views are presented its construction should be easily understood. A driving member is keyed to the end of the transmission shaft and is securely held on the taper by a suitable clamping nut. The driving member is provided with two longitudinal slots in which square nuts or sliding blocks fit. These are mounted on a pin which is driven

through the enlarged end of the propeller shaft. With this construction two joints are necessary.

A number of cars now use spring plate or leather disc universal joints at points where these are not subjected to undue deflection in place of the sliding jaw coupling or Oldham couplings so widely used heretofore. A point where they could be used to special advantage is between the clutch and gear case, and for magneto or starting generator drive. Some have been applied on the end of a propeller drive shaft, where the degree of movement was not apt to be excessive owing to the use of straight line drive. The construction of these joints is clearly shown at Fig. 534, A. Two three-arm driving spiders are attached to a flexible steel ring, or to a series of leather rings, as shown at Fig. 548, A, the degree of flexibility of the ring member being such as to permit slight disalignment, and at the same time secure positive driving. The advantage of the form of joint using leather or fabric discs is that it is quiet in action and that there is nothing to wear out.

Spring Plate Universal Joint.—Various types of universal joints have been devised to take the place of the modified Hookes couplings

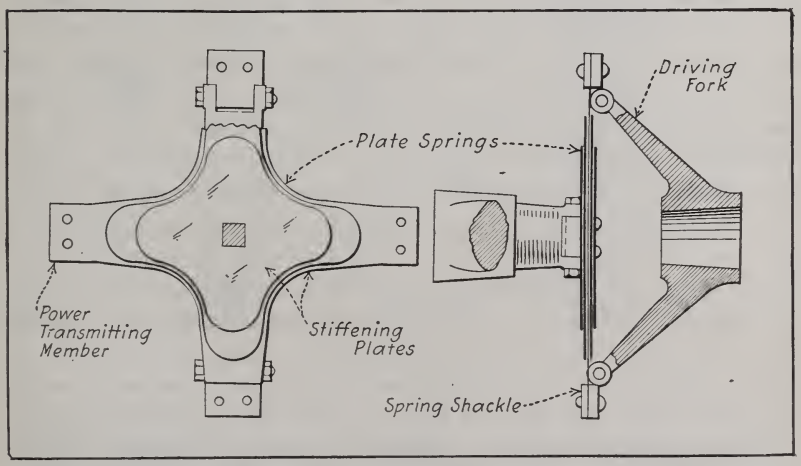


Fig. 551.—Unusual Flexible Driving Coupling Composed of Plate Springs.

which are so widely used in transmitting motion from the power plant to the rear construction of modern automobiles. The leather disc coupling used possesses no elements of novelty such as the spring steel universal joint shown in accompanying illustration does. Two armed driving forks are used, these being shackled to a thin cruci-

form plate spring of very flexible steel. Reinforcing or stiffening plates are provided, which do not take any appreciable strain off the drive, but which back the power-transmitting member and prevent undue flexion. It is evident that a joint of this type will not have the flexibility that the leather disc joint has or the range of movement of the conventional double yoke and cross joint. It would, however, seem to have some advantages as a coupling between two shafts that are practically on a line.

Why Fabric Couplings are Preferred to Steel.—It would seem to the student familiar with the strength of materials that steel discs could be used instead of leather or fabric and a simpler and equally strong joint be obtained as a result. The reason why steel was abandoned was because of noise and not because it lacked strength. Experiments made in the development of the present, 22-70 model Mercer car several years ago determined this point positively. The description of these experiments is reprinted from the *Automobile:*

"Originally the car was fitted with a large diameter flexible leather coupling between the clutch and the gearset, taking up all the play between the engine shaft and the main shaft of the gearbox. Changes in the gear in the gearbox and the propeller shaft brake which was added necessitated a different type of joint in place of the leather. The leather had to be abandoned, as it was found that with the stresses that were added with the propeller shaft brake, it would not be strong enough in the small diameter that was required. The three leather discs were replaced by two thin leaves of tempered saw steel on six or eight cars as an experiment. It was known that the strength of these leaves would be ample, but the uncertain part of the coupling was its action in practice, and very soon after they were put on it developed that a rattle would occur. It took several days to locate this, as nobody suspected the coupling, which was solidly bolted together. What made it particularly puzzling was the fact that the rattle would occur generally on direct drive and especially when running light or coasting. There was one peculiar feature, and that is the rattle would never occur until the car had been run for ten or fifteen minutes.

"The steel discs in the coupling were finally suspected, and to determine if they were really at fault they were removed and a fabric disc coupling was substituted. Immediately the rattle ceased, and as a result of these experiments all the Mercer cars were equipped with the Thermoid discs. The laminated steel disc coupling which had to be abandoned is shown in the drawing at Fig. 552, A. A three-armed dog is used on each shaft as a flange member and so arranged that the flange arms are bolted alternately between the arms of the

flange on the opposite shaft. The flange members are secured to the shafts by squared ends and bolts which fit upon the ends of the shafts. An investigation into what could have caused the noise in a coupling of this nature showed that it was due to a slight misalignment between the crankshaft and the mainshaft of the gearbox. This would cause a flexure in and out of the discs, similar to the action of a hand in pressing the bottom of an oil can, or in the disc devices that are used

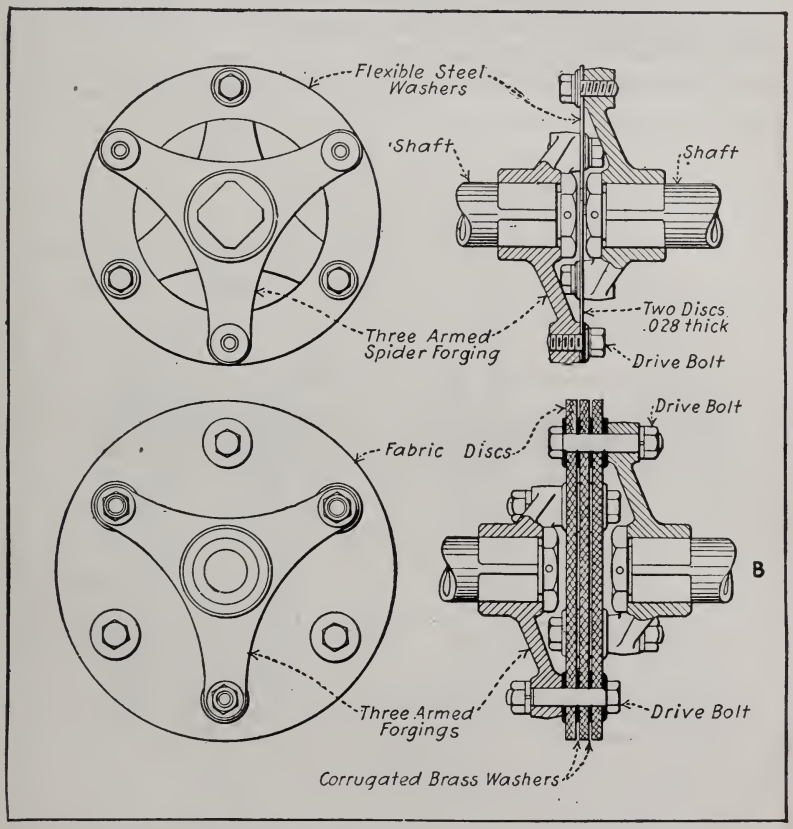


Fig. 552.—Two Forms of Flexible Couplings. A—Spiders Attached to Flexible Spring Steel Washers. B—Fabric or Leather Discs Give Flexibility without Noise.

as a diaphragm in noise-making instruments. This in turn would transmit a torsional vibration to the gearset pinion whose teeth would naturally vibrate against the teeth of the countershaft gear, the clearance between the teeth being 0.004 inch. The rattle would not show up for the first ten or fifteen minutes until the grease would soften

and cease to act as a cushion. After a little running the grease would thin out and thereafter the noise would be heard.

The Thermoid discs which replaced those of saw steel are made under a patented process of cross layers of high-grade cotton fabric with rubber between them, and they are cured under compression similar to a tire. Their tensile strength is very high and is higher than that of leather, as tests at the Columbia University have shown that couplings of the design illustrated at Fig. 552, B, have withstood a torque of 21,000 inch-pounds before fracture.

How Automobiles are Steered.—The problem of steering the motor car is a somewhat different one than that of directing a horse-drawn

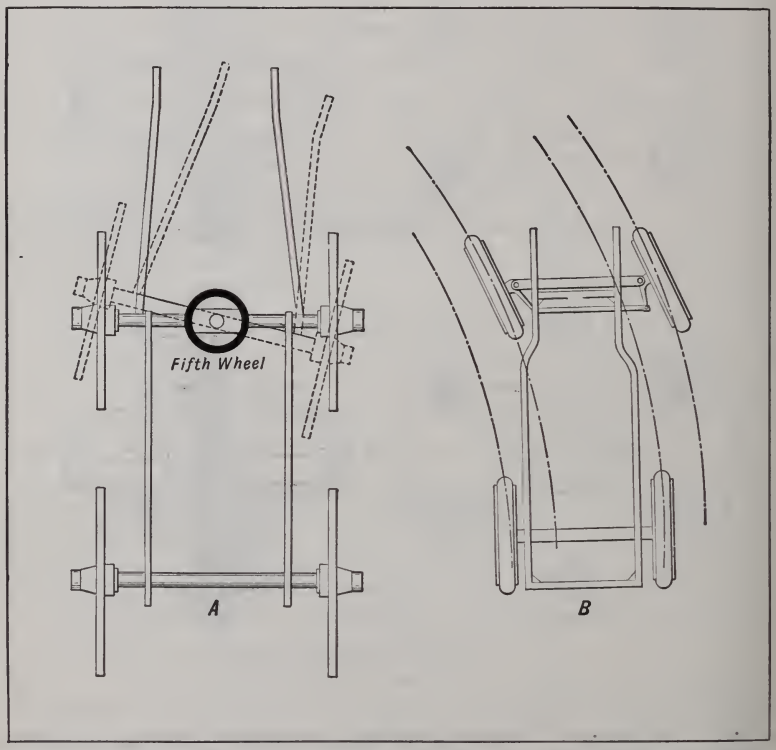


Fig. 553.—Methods of Steering Vehicles Outlined. A—Horse-drawn Vehicle Directed by Swinging Axle. B—Motor Car Steered by Movable Wheels on Fixed Axle. Rear Wheels will Track with Front Wheels Only When They are Mounted on Steering Spindles.

vehicle because in the animal-drawn conveyance the shafts which are attached to the front axle are used to turn the vehicle as well as to pull it along. The front axle is usually pivoted at a central point

and turns on a fifth-wheel arrangement, as shown at Fig. 553, A. When it is desired to turn in either direction the animal is guided by the reins and the axle is turned at an angle to the body sufficient to allow the vehicle to describe a curve as shown by the dotted lines. When turning sharply or in a narrow thoroughfare the construction is usually such that the front wheels may swing under the carriage body in such a way that the front axle may be parallel with the body side members or at right angles to the rear axle under extreme conditions. The stability of the carriage would be very poor if it was not for the bracing effect derived from the horses' weight between the shafts.

In most motor vehicles the propulsive force is applied to the rear wheels and the structure is pushed from behind instead of being pulled, as is the case with a horse-drawn conveyance. Obviously, it would not be practical to turn the entire axle under the car because if it described a too acute angle when the car was driven at high speed it would be extremely difficult to control the vehicle. This was very ingeniously overcome by an engineer named Ackerman, who devised the pivoted axle which is commonly accepted as the proper method of steering automobiles.

This consisted of a fixed axle member, as shown at Fig. 553, B, which was attached to a frame by suitable springs or other means in such a way that it could only move in a vertical direction under the influence of road irregularity. The wheels are mounted on spindles carried in a yoke at each end of the axle, and when it is desired to turn an automobile only the wheels are turned instead of moving the entire axle assembly as is the case in a horse-drawn vehicle.

In order to actuate the steering knuckles, suitable mechanism that will be easily operated must be placed convenient to the driver. The earlier forms of automobiles were provided with forms of tillers very similar to those employed in controlling boats, but while these simple levers gave a certain degree of satisfaction on light cars operated at slow speeds, the development of the higher-speed vehicles made necessary more easily handled and positive forms of steering gears. The disadvantages of the tiller are that it may be whipped out of the operator's hands by road irregularities, and it is very tiresome to hold because of the continual vibration.

With the modern forms of wheel-steering devices the hands are always in an easy position, the wheels may be readily operated and because of the elimination of vibration by the feature of irreversibility provided by most steering gears of conventional construction, no road shock can loosen the grip of the driver, nor is he fatigued by continued movement of the wheel.

Steering gears are made in a variety of forms and all types have their adherents. The accepted construction is clearly illustrated at Fig. 554, A. In this the steering wheel is attached to a rod which carries a worm at its lower end. This worm meshes with a worm gear to which a steering arm is attached, and a rotary movement of the hand wheel will produce a reciprocating movement of the steering arm at the lower end of the steering column. The steering arm is coupled to one of the steering knuckles of the front axle by a connecting link and the movement imparted to the one steering knuckle is translated to the other one by means of the tiebar which joins them.

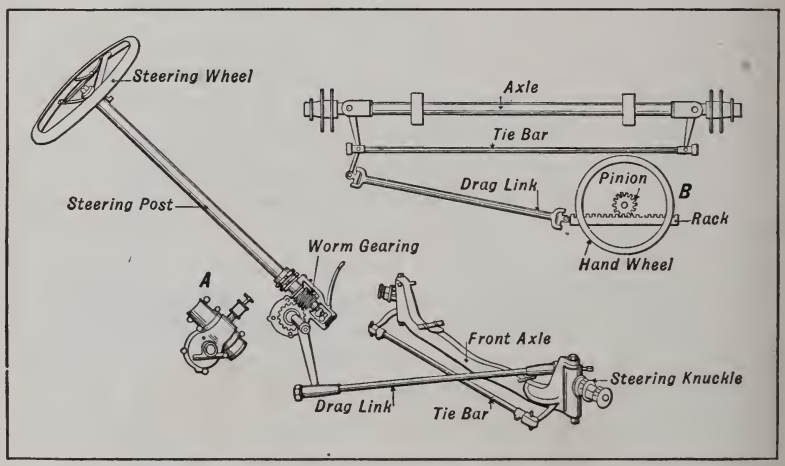


Fig. 554.—How Front Wheels of Motor Cars are Moved. A—Conventional Worm-gear Reduction Steering Arrangement. B—Simple Rack and Pinion System Used on Light Cars of Early Design.

The form of steering gear outlined at B is a simpler one, but it does not incorporate the good features of the worm-gear type. It consists of a spur pinion at the end of the steering post which meshes with the spur-gear rack actuated when the hand wheel is turned in such a way that the rotary motion of the wheel is transformed to a reciprocating movement of the rack. The rack is directly attached to one of the steering knuckles by a drag link coupled to an extension from one of the steering arms. In a modification of this type a bevel gear is used at the lower end of the steering post and a bevel-gear sector is utilized to actuate the drag link. The principle of action is the same as in the form described, however, and while either of these forms may be applied to light cars and make for ready control be-

cause they are quick acting, they are not desirable on heavy vehicles because they do not provide the feature of irreversibility which is necessary.

The factor of irreversibility in steering gearing is one that was formerly a point of contention among authorities on automobile construction. It was argued that the irreversible form does not provide that quick action which is considered necessary to secure prompt con-

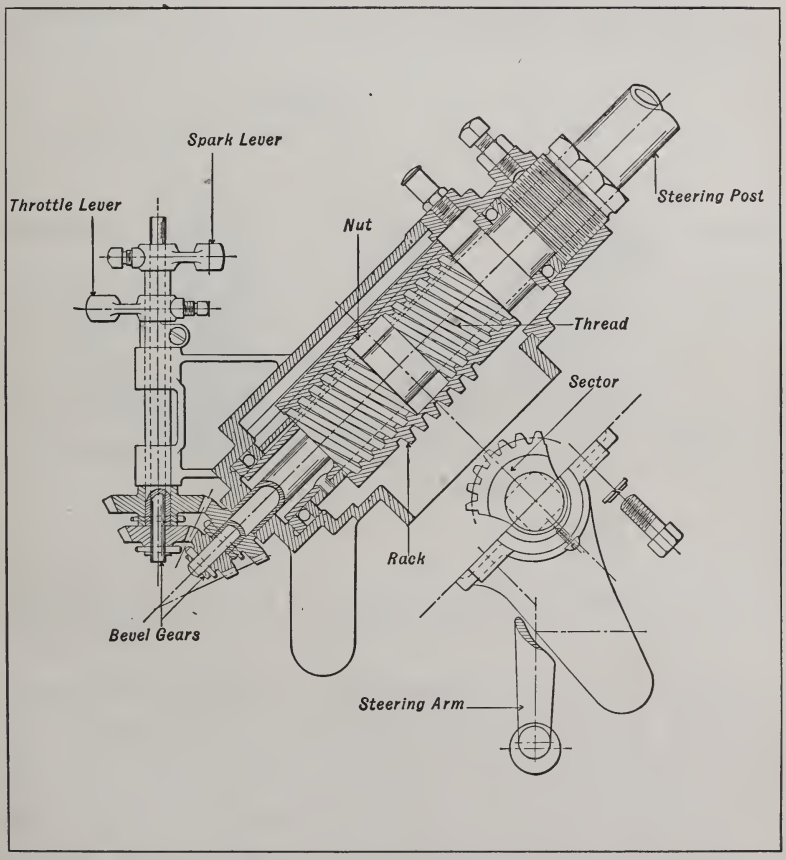


Fig. 555.—Steering Gear Employing Threaded Steering Post and Movable Nut Having a Rack to Engage Sector on Steering Arm Shaft.

trol of the car. At the other hand, the strictly reversible gear, such as the spur rack and pinion, which is especially quick acting, will tire the operator whenever the car is operated on rough roads, as every inequality of the road service will tend to produce a corresponding

side motion of the wheel which will mean considerable play at the rim of the steering wheel.

Some engineers who contended that the worm and sector gear were liable to wear devised combination forms in which a screw and nut principle was combined with a rack and sector gear, the object being to provide a largely increased bearing surface on the threads and gear teeth and in this manner reduce wear.

A gear of this type is shown at Fig. 555. The nut or internally threaded member is held from turning by various methods, such as flattening one side and having this in contact with the walls of the

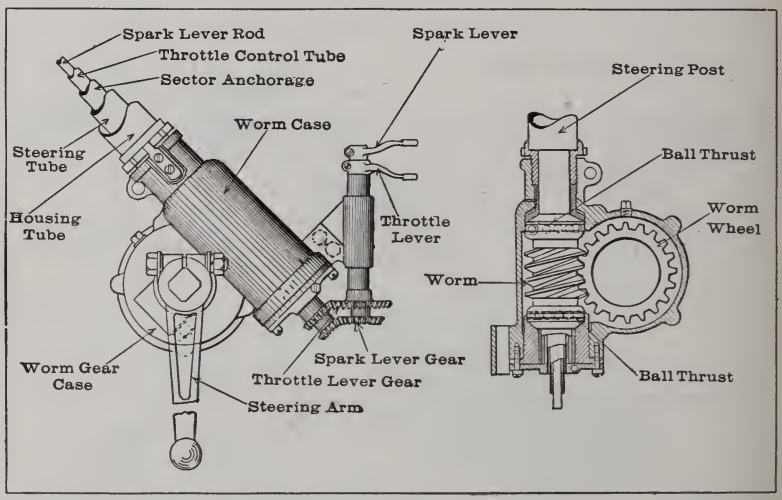


Fig. 556.—Construction of Worm and Worm-gear Reduction Gearing for Steering Purposes.

casing, by the use of keys or dowel pins, or merely by the pressure of the rack and sector shown in illustrations. The advantage of this form of steering gear is that it is wholly irreversible and at the same time a minimum of effort is needed on the part of the driver to properly control a very heavy car. The amount of movement of the nut, up and down, is regulated by the pitch and angle of the thread and as the nut is provided with a spur rack its rectilinear motion is transformed into an oscillating movement of the steering arm attached to the spur-gear sector.

The worm and segment type of steering gear is without doubt the most popular with automobile manufacturers of this country and Europe. It is simple, compact, and positive in action. The steering post carries a worm at its lower end, as shown at Fig. 556. This

in turn meshes with a suitable worm wheel or segment attached to the steering arm. The worm when turned will produce a fore and aft movement of the steering arm which in turn is transmitted to the wheels by suitable leverage. This type of gear must be maintained in perfect adjustment and be well lubricated at all times. The greatest defect is the wear that will exist between the worm and worm-gear teeth, and the difficulty of devising any really practical method of taking up the play. The constant oscillations of the vehicle wheels will cause the sector teeth and worm thread to wear at one place, which corresponds to the straightahead position of the gear.

This may be taken up in most forms by the use of eccentric bushings in which the sector shaft is mounted, these being moved in such a way that the sector teeth are brought into closer engagement with the thread of the worm. This method is not desirable because if the eccentric bushings are turned enough to take up the lost motion existing between the teeth, the change in worm-gear position would cause binding between those portions which had not worn as much and which were brought into play only when it was desired to turn the wheels to nearly the extreme angular position. The preferred method is that outlined at Fig. 556. In this a full worm wheel is used instead of a sector and when wear occurs at one point the worm wheel is removed, the hand wheel and worm are given a complete turn, and the worm wheel is replaced in such a way that a new set of teeth on both worm and worm gear will be in mesh.

With all conventional forms of steering gears the object has been to get a complete sweep of the front wheels, that is to turn them from one extreme position to the other with about one and one-half turns of the hand wheel. Anything slower than this will be so tardy of action that it will be difficult to steer the car properly and quickly at anything but low speed. On some heavy commercial vehicles, however, it is necessary to provide lower reduction, and two or two and a half turns of the steering wheel are sometimes necessary to produce the proper degree of movement of the front wheels. This is not a point that can be seriously objected to when one considers the low speed of the conventional motor truck. On high-speed cars some authorities claim that one turn of the wheel to produce a full movement of the steering wheel is entirely satisfactory, as it permits handling the car with minimum lag and makes it quick to respond to the control gearing at all speeds.

It is common practice on most motor cars to combine the motor-controlling levers with the steering gear in such a way that the speed of the motor may be varied as desired without the operator removing

his hands from the steering wheel. The manner in which this may be accomplished is clearly shown in the steering-gear design depicted at Fig. 557. In this the steering wheel is attached to a tubular

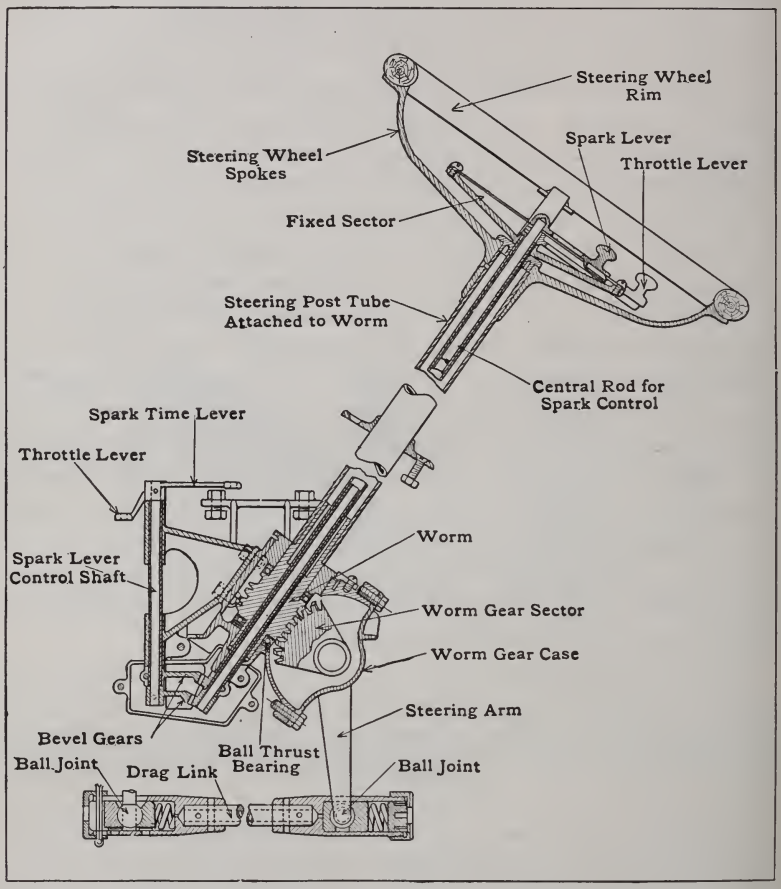


Fig. 557.—Typical Steering Post Assembly, Showing Hand Wheel and Motor Controlling Levers. Sectional View Shows Worm and Worm-gear Sector, also Drag Link Connecting to Steering Arm on Axle.

steering post, through the center of which a rod mounted inside of two concentric tubes is passed. The outer tube is anchored at the bottom end of the steering-gear casing and carries the sector on which the spark and throttle levers move. The short lever is attached to the rod passing through the center of the assembly, and this in turn actuates by means of bevel gearing an auxiliary control shaft mounted in front of the steering-gear assembly. The long lever is attached to

the tube which surrounds the central rod, and this member also carries a gear at its lower end which engages a tube surrounding the spark-lever control shaft at the front of the steering gear. The spark timer or commutator is attached to the upper lever while the carburetor throttle is operated from the lever immediately below that controlling the spark-timing device.

As the sector is anchored at the lower end of the gear case it remains stationary when the steering wheel is turned and the motor-control levers always maintain a fixed relation to each other and the operator. All gearing is enclosed and thoroughly lubricated, and as there is but little chance for dirt to get in, the mechanism is very enduring. Ball-thrust bearings are provided above and below the worm to take the end thrust which results when it is turned. This makes the gearing much easier to operate than would be the case if the considerable amount of end thrust present was taken on plain bearings.

Several automobile designers have built the steering wheel so that this may tilt out of the way to permit the driver getting in and out of his seat with more comfort. Two practical methods of accomplishing this are shown at Fig. 558. In the design at A, the steering wheel is

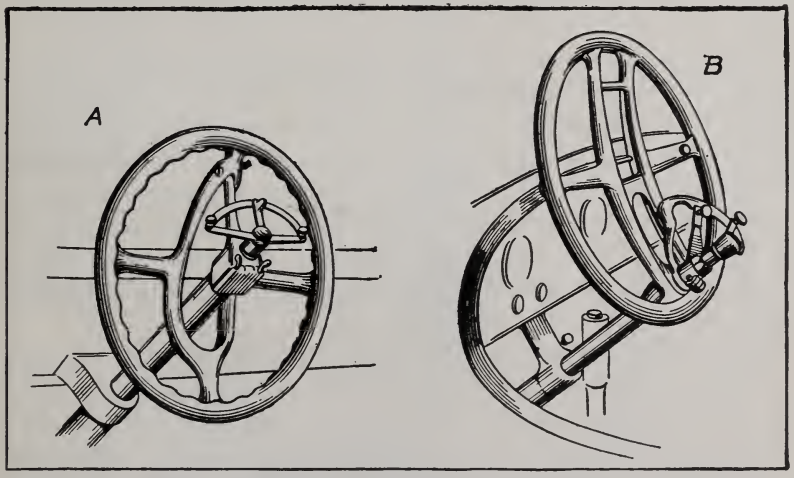


Fig. 558.—Forms of Tilting Steering Wheel.

carried by a hinged joint in one of the spokes, while in the other shown at B, the wheel frame work is of peculiar form, and the entire wheel may be rocked back and forth on a guiding member which works in grooves in the two spokes forming a central support for the wheel rim.

Lubricants for Chassis Parts.—Three forms of lubricants are used in oiling the various parts of the chassis and transmission system. These are greases, semi-fluid oils and gear compounds. The various lubricants and their characteristics are clearly described by the Platt and Washburn Company, the greases being known by the trade name "Veedol." The parts of an automobile which comprise the transmission systems are clearly shown in the sectional view at Fig. 559 and the lubricants best adapted are outlined.

In the manufacture of cup greases fatty oil is saponified in the presence of water. When the soap is formed some hydro-carbon oil is added to form a cup grease. Variation in the proportions of soap and hydro-carbon oil makes possible the manufacture of soft and hard greases. The quality of cup greases cannot always be judged by their appearance. Some manufacturers employ cheap gas oil which is about as heavy as kerosene in the blending and use more soap or a filler. The finished grease made with such cheap oil has but little lubricating value. Finished cup grease always contains more or less combined water, which causes the soap and the hydro-carbon oil to permanently separate if they are heated to a temperature often met with in automobile mechanisms. On account of their instability, cup greases are not to be recommended for use in transmissions or driving axles.

An appropriate grade of finely divided graphite is mixed with cup greases to form different grades of graphite greases. Such greases are not to be recommended for use in transmission or differential cases because of the separation of cup greases or semi-fluid oils as indicated above and because of the tendency of graphite to precipitate and to accumulate in the bottom of the cases. Semi-fluid oils are made in the same manner as cup greases, the only difference being that a smaller quantity of saponified fatty oil is combined with the hydro-carbon oil.

Gear compounds are generally manufactured by blending a sponge, i. e., fibre, grease with a carefully selected high grade hydro-carbon oil. Sponge grease is made by the saponification of fatty oil with sodium or potassium hydroxide in the presence of water. When the saponification is completed, all of the water is boiled out and a hydro-carbon oil is then added. Variation in the quantity of the constituents makes possible the manufacture of light, medium and hard grease. This grease when heated up becomes entirely fluid and upon being allowed to cool returns approximately to its former consistency. Gear compounds being very adherent in nature are excellent gear lubricants. They cushion the blows between the gear teeth and

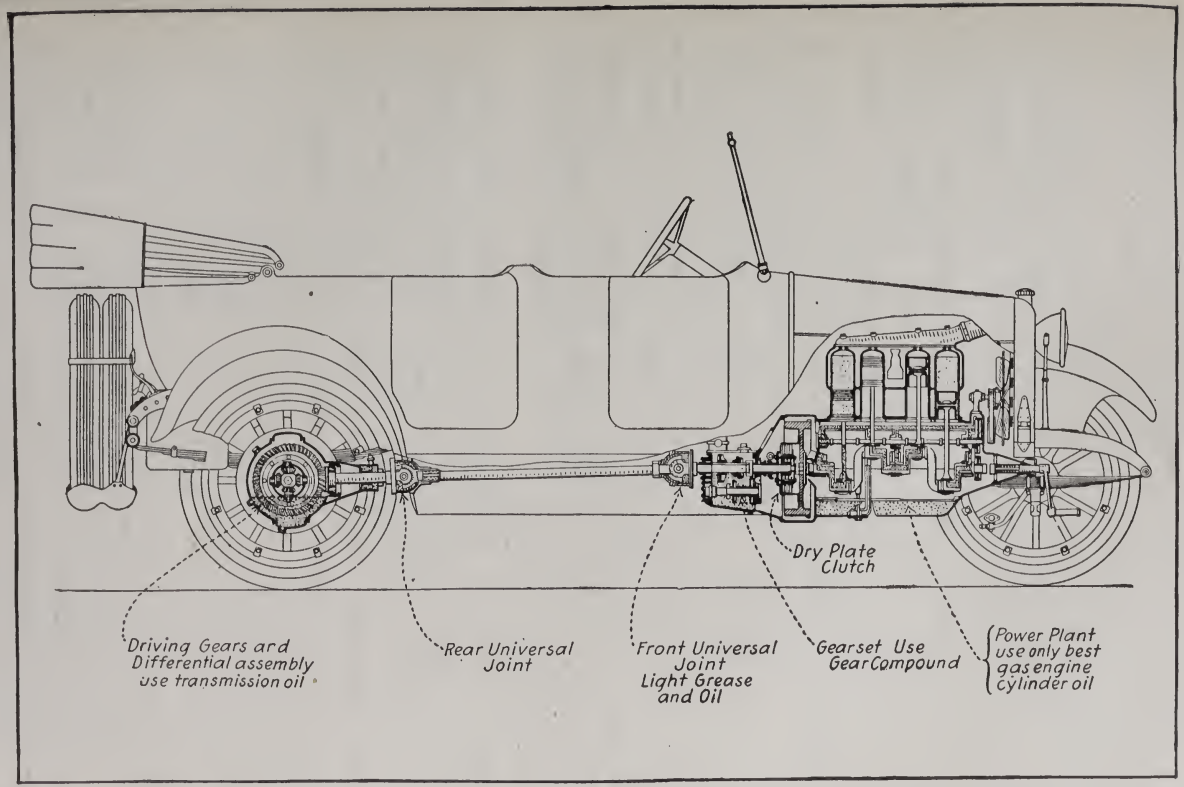

Dry Plate Clutch
Driving Gears and Differential assembly use transmission oil
Rear Universal Joint
Front Universal Joint Light Grease and Oil
Gearset Use Gear Compound
Power Plant use only best gas engine cylinder oil

Fig. 559.—Sectional View of Power Generating and Transmission System of Typical Automobile, Showing Parts Requiring Continual Lubrication.

diminish noise to a marked degree. These lubricants leak less than any other by way of joints in the mechanisms. Inferior grades of gear compounds are sometimes made from a mixture of paraffin wax and heavy oil, but inasmuch as paraffin wax has practically no lubricating properties they should not be employed.

Transmission oils consist either of a heavy specially selected hydrocarbon oil, or of a blend of such oil with a small percentage of fatty oil, and are used for the most efficient lubrication of both transmission and worm- or bevel-drive rear-axle mechanisms wherever the housings are sufficiently tight to prevent leakage. For the lubrication of worm-driven rear axles, chemically pure castor oil is sometimes used, in spite of the fact that it offers no noticeable advantages over transmission oils, and in the face of an almost prohibitive cost.

Suggestions for Oiling.—One of the most important points to be observed in connection with gasoline-automobile operation is that all parts be oiled regularly. It is not enough to apply lubricant indiscriminately to the various chassis parts, but it must be done systematically and logically to secure the best results and insure the economical use of lubricant. The most important parts are the power plant and transmission system and the engine is but one point in the car that must be properly oiled at all times to obtain satisfactory results. Some of the running-gear parts are relatively unimportant, others demand regular inspection and oiling.

Very comprehensive oiling charts are presented at Figs. 560 and 561, this showing practically all of the points that require oil as well as giving instructions regarding the character of the lubricant needed and how often it should be applied. Some of the points are governed by special instructions, these being the clutch, transmission case, timer, and rear axle. The points of the clutch which need lubricant vary with the form of clutch employed. Multiple-disk types which run in oil must be kept filled up with the proper grade of lubricant. At the other hand, cone and dry-plate clutches work better without any lubricant between the surfaces. When a cone clutch is employed it is sometimes desirable to soften the leather facings with a little castor oil or neat'sfoot oil, if the action is beginning to get hard. A transmission-gear case which is moderately tight can be filled with a good grade of steam-engine cylinder oil, and very heavy grease should not be used if the transmission shafts run on ball bearings. A transmission oil will have sufficient viscosity to cushion the teeth of the gears against shock and at the same time it will not be too heavy to flow into the bearings and lubricate them properly.

Neither the transmission case nor the differential case on the

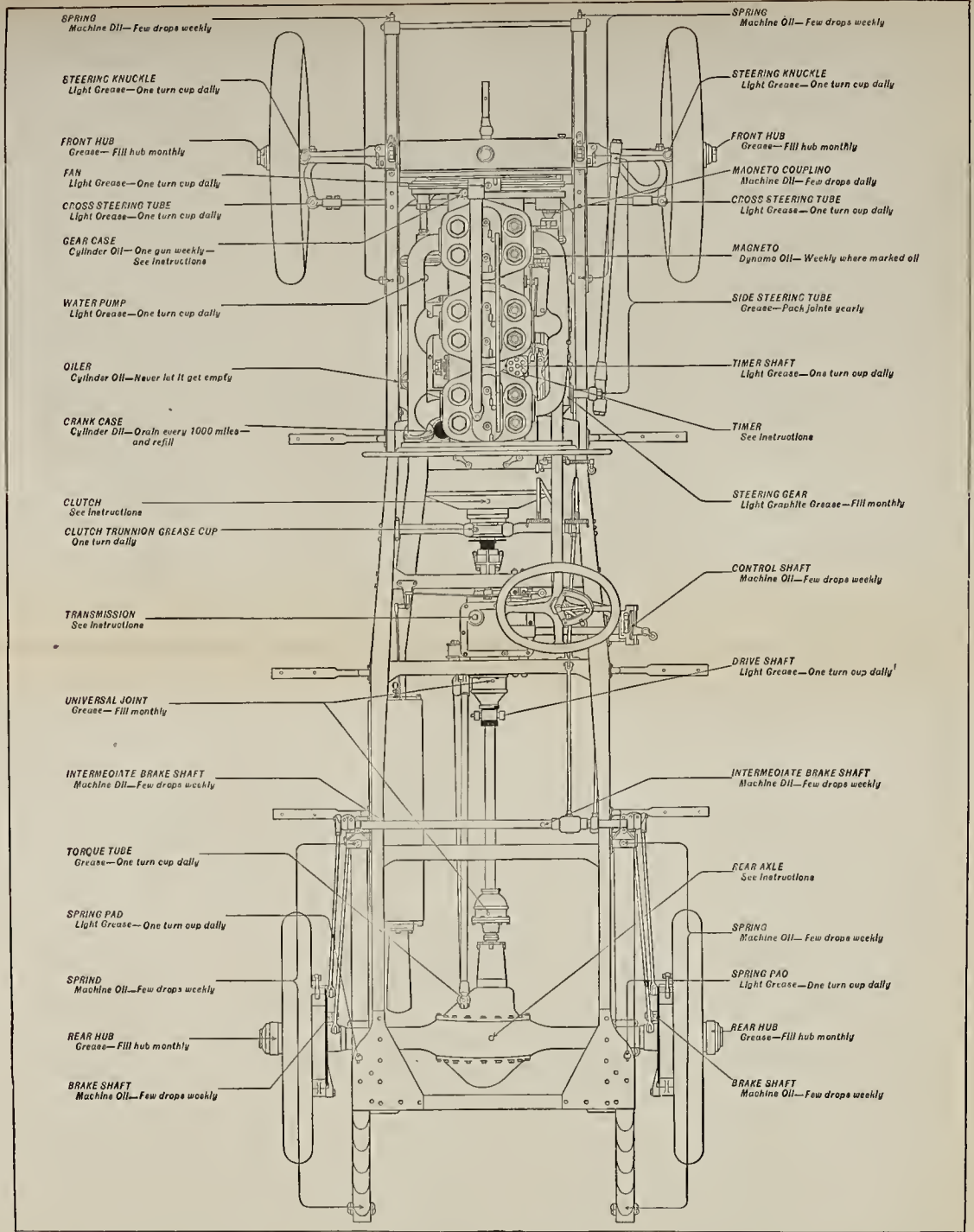


Fig. 560—Comprehensive Lubricating Chart for Guidance of Owners Insures Adequate Lubrication of All Essential Parts of the Mechanism at Regular Periods.

rear axle should be filled with the heavy "Dope" widely sold, which may contain wood fiber or cork particles to make for more

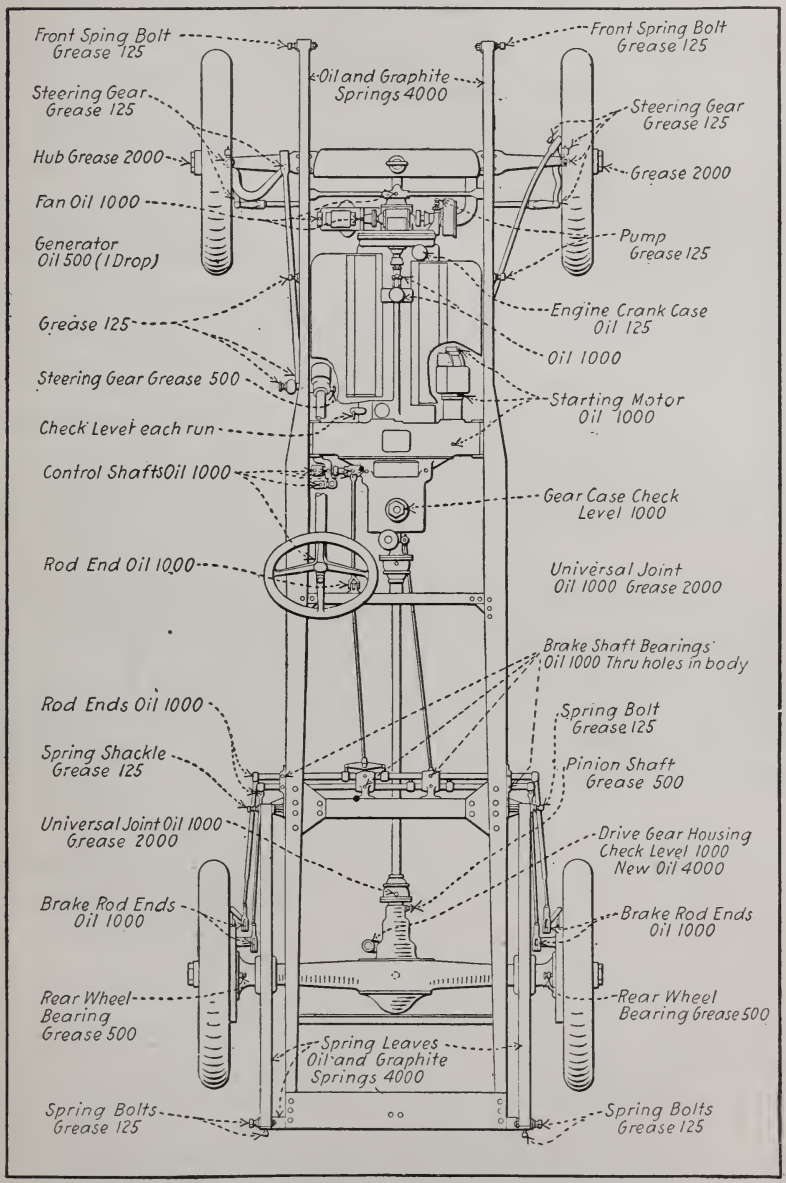

Front Sping Bolt Grease 125
Front Spring Bolt Grease 125
Oil and Graphite Springs 4000
Steering Gear Grease 125
Steering Gear Grease 125
Hub Grease 2000
Grease 2000
Fan Oil 1000
Generator Oil 500 (1 Drop)
Pump Grease 125
Engine Crank Case Oil 125
Grease 125
Oil 1000
Steering Gear Grease 500
Starting Motor Oil 1000
Check Level each run
Control Shafts Oil 1000
Gear Case Check Level 1000
Rod End Oil 1000
Universal Joint Oil 1000 Grease 2000
Brake Shaft Bearings Oil 1000 Thru holes in body
Rod Ends Oil 1000
Spring Bolt Grease 125
Spring Shackle Grease 125
Pinion Shaft Grease 500
Universal Joint Oil 1000 Grease 2000
Drive Gear Housing Check Level 1000 New Oil 4000
Brake Rod Ends Oil 1000
Brake Rod Ends Oil 1000
Rear Wheel Bearing Grease 500
Rear Wheel Bearing Grease 500
Spring Leaves Oil and Graphite Springs 4000
Spring Bolts Grease 125
Spring Bolts Grease 125

Fig. 561.—Plan View of Typical 1917 Eight-Cylinder Automobile Chassis, Showing Parts Requiring Lubrication. Figures Indicate Mileage Covered Before Attention is Required.

silent operation. If gearing is noisy it is either because it is worn or out of adjustment, and the use of the nostrums and freak lubricants will not improve their operation. The rear-axle differential housing should be filled with the special gear compound or as light mineral grease as it is possible to get, those having about the consistency of vaseline being the most desirable as lubricants. Light oils should never be used in either the transmission-gear case or in the rear-axle housing, because these will not stay in place and will not have sufficient body to cushion the gear teeth.

The only point on the chart, at Fig. 560, which needs explanation is lubrication of the timer interior. This should only be oiled when it is a roller contact form, as on the Ford car, and then a few drops of dynamo, magneto, or spindle oil applied to the roll and the contact segments once a week is all that is necessary. If the timer is a form using platinum contact points it does not need any lubricant. Never use graphite grease or any heavy oil in a timer or distributor case, because these will not only gum up the parts but will also produce electrical troubles by short-circuiting the current. Be sparing of oil in all electrical devices such as magnetos, generators or starting motors.

After a car is oiled it is well to go over all the exposed joints with a piece of cloth to remove the accumulations of surplus oil on the outside of the parts which serve no useful purpose and which only act to attract and retain dust and grit. The instructions given on the chart can be followed to advantage on all types of gasoline cars, though, of course, the different constructions will have to be treated as the peculiarities of design dictate.

CHAPTER XI

FRONT AND REAR AXLES AND BRAKES

Front Axle Types—Steering Knuckle Forms—Power Transmission System—Chain Drive—Bevel Gear Drive—Trend of 1917 Motor Truck Driving Systems—Worm Gear Drive—Internal Drive Axles—Rear Axle Forms—Live Rear Axle—Stationary Axle—Rear Axle Nomenclature—Semi-Floating Axle—Three-Quarter Floating Axle—Full-Floating Axle—Purpose of Differential Gear—Differential Gear Action—Differential Substitutes—Positive Drive Differential—Typical Worm Gear Drive Assembly—Skew Bevel Drive Gearing—Two Speed Direct Drive Axle—Differential Locks—Single Chain Drive—Four Wheel Drive and Steer System—Front Wheel Drive System—Utility of Motor Car Brakes—Forms of Motor Car Brakes—Internal Brakes—External Brakes—Multiple Disc Brake—Front Wheel Brakes—Vacuum Operated Brake—Hydraulic Brake—Anti-Friction Bearing—Ball Bearing Types—Roller Bearing Types.

Front Axle Forms.—Various front axle constructions used in automobiles follow a common design and the same general principle of action prevails in all. Front axles differ from each other only in matters of minor constructional detail, such as the type of steering knuckles used and whether the axle is a one-piece forging or a built-up structure. Axles of good design are shown at Fig. 562. That at A is composed of a one-piece I-section drop forging of steel which has the advantage of having the steering-knuckle yokes and the spring pads formed integral. This is the type most generally used because it is exceptionally strong and when properly designed is not unnecessarily heavy.

One of the front hubs is shown in section in the plan view of the axle depicted at A. The hub is mounted on ball bearings, which in turn are supported by the spindle which forms part of the steering knuckle. A long through bolt passes through the steering knuckle and acts as a bearing for it to swivel on. Steering arms project from each knuckle and are joined together by a tiebar.

The construction of the axle depicted at B is practically the same in general design as that shown above it. It differs in the important respect that the axle proper is formed of a piece of steel tubing to which the separately forged yokes and spring seats are secured by

brazing. Those who favor the tubular axle claim greater flexibility and lightness combined with adequate strength, while the adherents

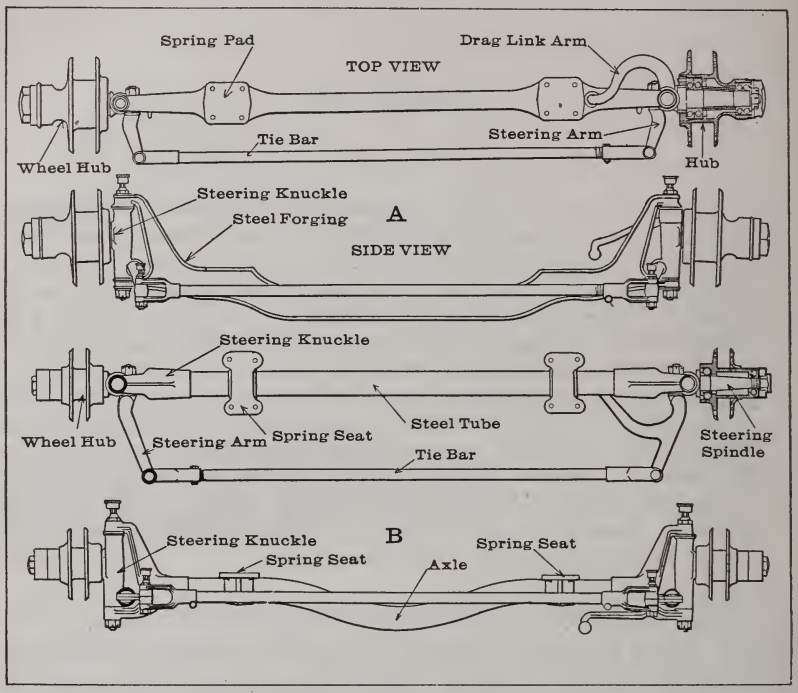


Fig. 562.—Typical Front Axle Types. A—Forging of I Section. B—Tubular Axle.

of the I-beam construction advance the argument of exceptional strength and contend that flexibility is not a point of moment com-

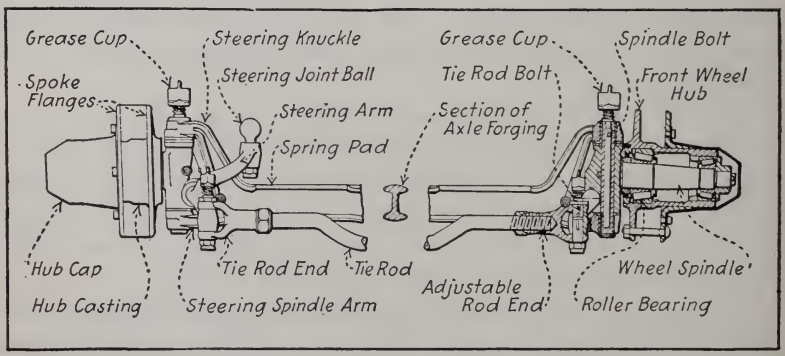


Fig. 563.—Typical Motor Truck Axle, Showing Use of Roller Bearings in Wheel Hub.

pared to rigidity of the structure. As a general rule, tubular axles are employed only on light cars, while the heavier forged form is utilized extensively on the larger vehicles. A typical heavy duty front axle is shown at Fig. 563, this being of the forged bed type with Elliot type steering knuckles.

Various forms of steering knuckles and bearings used for mounting the front wheel are shown at Fig. 564. At A an Elliot type knuckle,

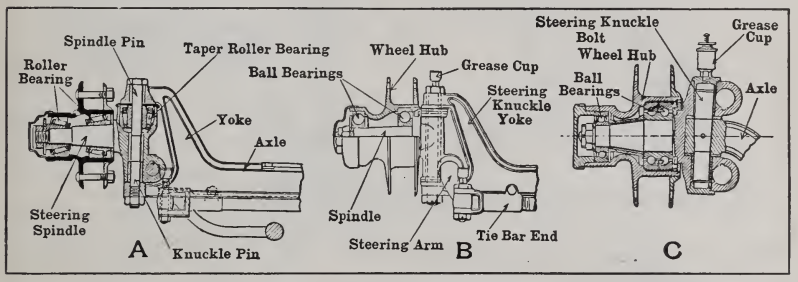


Fig. 564.—Typical Front Hub and Steering Knuckle Designs. A—Elliot Type, Hub with Taper Roller Bearings. B—Front Hub Mounted on "Radax" Ball Bearings. C—Mercedes Type Steering Knuckle, Hub Mounted on Single and Double Row Bearings.

which is provided with a roller-thrust bearing at its upper end to take the thrust due to the weight of the car, is shown. The wheel hub is mounted on taper-roller bearings secured to the spindle in the usual manner. Another Elliot knuckle is depicted at B, but in this construction the front hub is supported on ball bearings of the cup and cone type. The steering knuckle depicted at C is a modification of the Mercedes design, and in this the yoke forms part of the wheel spindle and oscillates on a pin carried by the end of the forged steel axle. Special attention is directed to the form of ball bearings utilized for supporting this hub. Practically all of the weight is taken by a large New Departure double-purpose bearing specially adapted to support both end thrust and radial loads. This forms a very effective bearing and is often used at points in the motor-car chassis where severe loads are to be resisted. The general construction of these steering knuckles and the mode of application of the bearings on which the hubs revolve are so clearly shown that further description is not necessary. Two modifications of the Lemoine type steering knuckle are shown at Fig. 565. That at A is the form used on the new Marmon car; the design outlined at B is employed on the light Overland models. The use of this type steering knuckle makes it possible to carry

the axle low and bring the center of gravity of the entire car toward the ground, thus making for greater stability at high speeds.

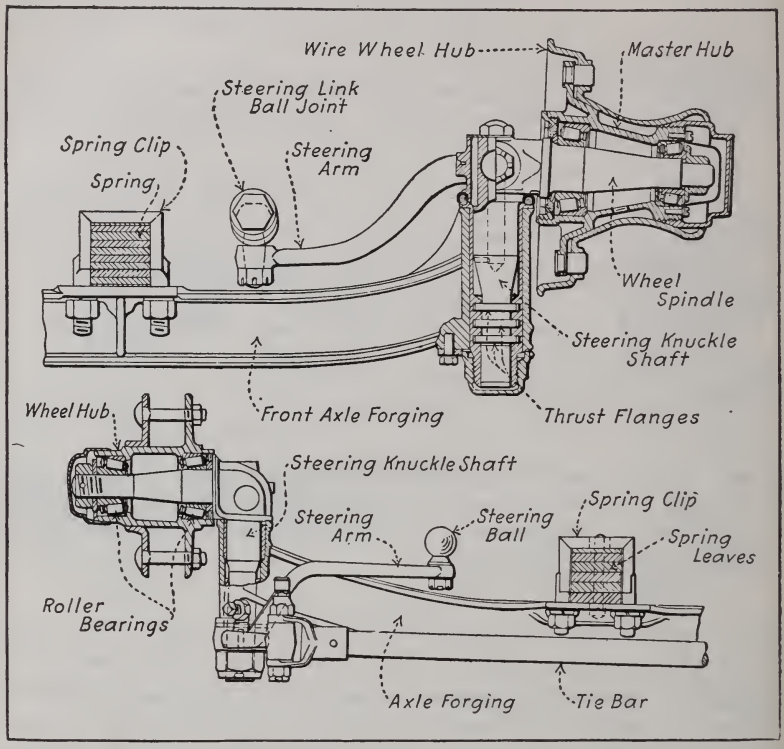


Fig. 565.—Two 1917 Modifications of the Lemoine Steering Knuckle. At Top, Part of Marmon Front Axle; at Bottom, Overland Front Axle.

Typical Power Transmission Systems.—One of the factors making for motor-car efficiency is the system of transmission employed by which the power delivered by the engine is transmitted to the rear wheels, and the most efficient system is obviously that which will deliver the power to the rear wheels with minimum loss. The common methods of power transmission are outlined at Fig. 566. That at A is the system formerly used on many light cars which derived their power from a single-cylinder engine placed lengthwise in the chassis. The drive from the sprocket on the planetary gearset is by means of a chain to a sprocket on the differential gear of the rear axle. This was one of the most direct methods of transmission possible and was remarkably efficient as long as the chain was kept clean, properly oiled, and in correct adjustment. The efficiency of

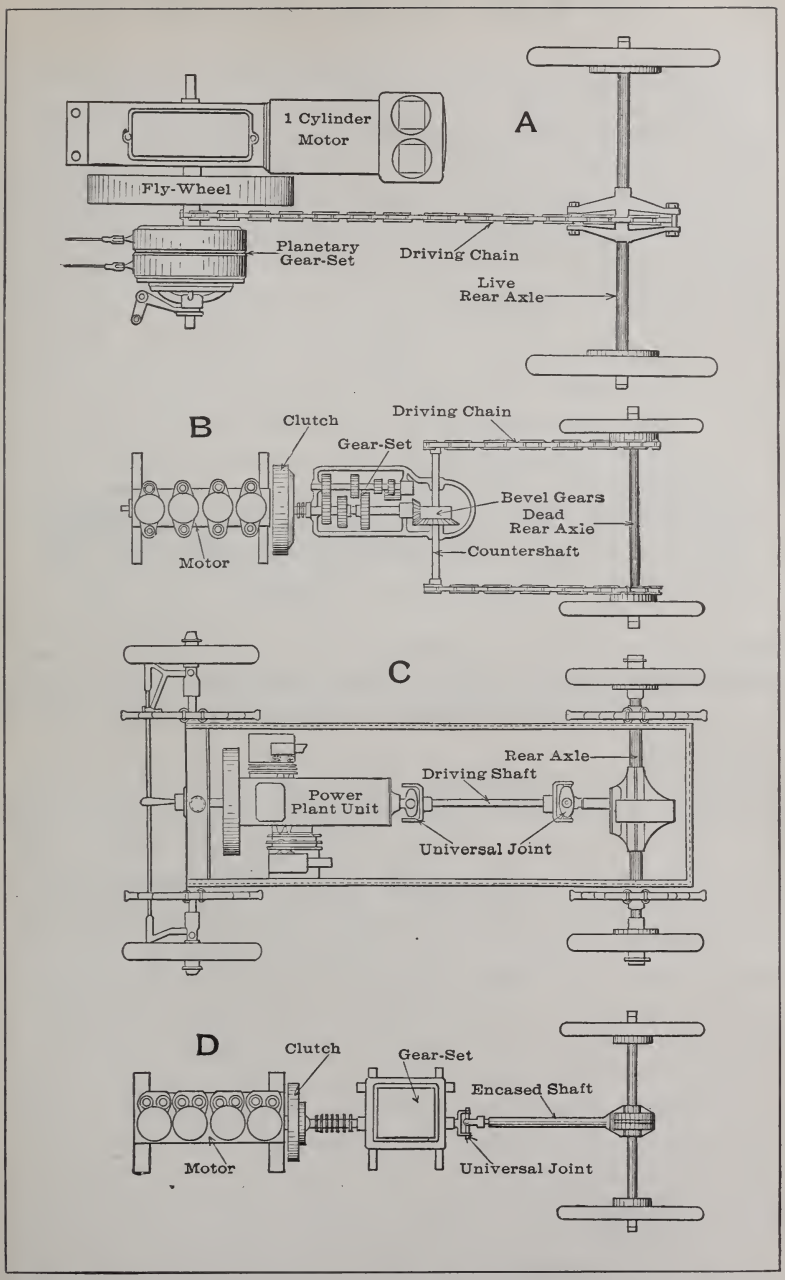


Fig. 566.—Methods of Power Transmission that Have Been Used by Motor Car Designers. A—Obsolete Single-Chain Drive. B—Side-Chain Drive System, Seldom Used Now. C—Drive by Exposed Shaft Having Two Universal Joints. D—Drive Shaft Enclosed in Torque Tube; Needs but One Universal Joint.

this arrangement was very high, and about ninety per cent of the engine power was delivered to the wheels on the direct drive and about seventy-five per cent when the planetary gearset was in operation.

The system shown at B was formerly very popular on all classes of touring cars, but is seldom used at the present time except in heavy commercial vehicles, where it is losing favor very fast and being replaced by internal gear and worn drive axles. With this system the differential gear is carried adjacent to the gearset and driving shafts extend therefrom to sprockets at each side of the frame. The drive from the countershaft member is by means of driving chains to sprockets on each rear wheel. The wheels are mounted so they revolve on a stationary axle. It is believed that this construction is stronger than the live axle for heavy vehicles, and it is also used because it permits the designer to obtain a double reduction and very low ratios of speed, which make it very suitable for motor-truck service. The efficiency of this method of driving is lower than that in which either chains or gears are used alone, and even when the gearset is in the direct drive position or high-speed ratio there is a loss of twenty-five per cent in transmission, which gives a net efficiency of seventy-five per cent under most favorable conditions. When on the lower ratios, which demand the use of the change-speed gearing, the efficiency is reduced to about sixty per cent.

Various forms of shaft-drive systems are popular at the present time and the two methods of employing shafts differ merely in detail. In the diagram shown at Fig. 566, C, two universal joints are employed and a length of driving shaft. One of these joints is mounted at the end of the gear box on the power plant unit, while the other flexible member is attached to the differential housing. The drive from the shaft to the wheels may be by bevel or worm gearing and when this system is employed it is necessary to use some form of radius rod member to keep the axle in proper relation with the frame.

When the method depicted at D is employed but one universal joint is needed. The driving shaft is encased in a tubular member usually attached to the frame in such a manner that it serves as a radius member and permits the axle to move up and down under the influence of rough road surfaces, but does not permit end movement of the axle. The efficiency of the shaft-driving systems is very high compared to the double-chain drive and as all parts are always enclosed and run in lubricant the efficiency may be conserved. While the power loss with a bevel-gear and shaft-driving system is apt to be a little higher than the single-chain method when both are new, deterioration is apt to be more rapid in the chain-driven cars. If

care is taken to install the power plant so the propeller shaft will be on a straight line with the engine crank shaft, as depicted at Fig. 567, but fifteen per cent of the power will be lost in transmission. If the driving-shaft angle increases the efficiency will be lower. A safe rule for estimating this is given by some authorities as one per cent loss for each degree of shaft inclination. This power loss is due to friction in the universal joints, as the amount of movement of the joint

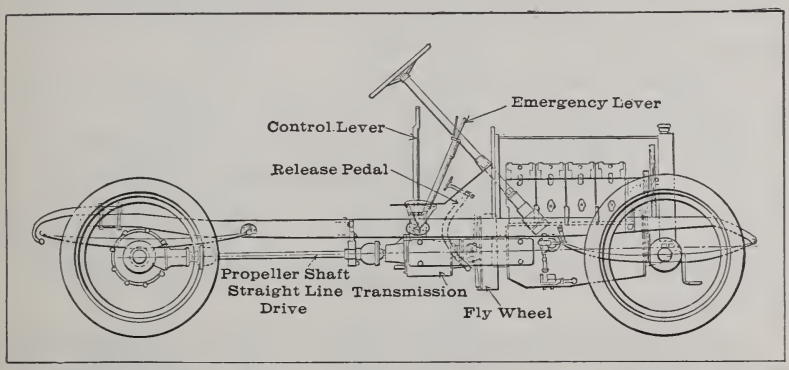


Fig. 567.—Chassis of Shaft Drive Car Having Shaft on a Straight Line, which Permits Power Transmission with Minimum Loss.

yokes on the cross or bearing pins increases with the angularity of the shaft. The universal joints will depreciate rapidly if there is too much movement and soon become noisy.

Trend of 1917 Motor Truck Driving Systems.—During the first few years, or what we may call the development period of the American industry, it was natural to expect American engineers to follow closely the work of the foreign builders, and inasmuch as the field of British development was the easiest to study, it was to be expected that many of the features of design that had proven practical in England would be adopted in this country. It is to the influence of the English designers that the popularity of the worm and worm gear driving system can be traced. Police regulations abroad were such that noisy trucks were barred from the streets. The rules established by the larger English municipalities, especially London, were so drastic that many double-chain-driven omnibuses were condemned by the authorities because they could not be made to conform with regulations.

Experience with worm gearing developed a form of gear drive that was not only remarkably enduring, but which was silent in operation and which did not become noisy in service. The completely

enclosed worm drive was also found to be more reliable in the hands of the average motor truck operator than the chain drive it superseded. The importance of having a "meddle-proof" construction cannot be overestimated when one considers that many companies who disposed of their horses and wagons in favor of motor vehicles employed mechanically inexperienced drivers for operating their trucks. This was the logical thing for these firms to do inasmuch as their old drivers were undoubtedly more familiar with their peculiar business conditions than new and perhaps more mechanically proficient employees would be.

It is stated that the London General Omnibus Company has operated something like 3,000 large worm driven busses on the streets of London and has found it utterly impossible to strip the gearing, due to the unusually strong form of tooth presented to the high tooth pressure necessary in driving these heavy vehicles. As far as endurance is concerned, it is important to note that an average of 80,000 miles has been covered before any appreciable wear was discernible in the worm gears.

Worm gearing is not only enduring and noiseless, but is remarkably efficient, as actual tests have demonstrated that from ninety to even as high as ninety-seven per cent of the horse-power applied to the worm driving shaft has been delivered to the road wheels. The sectional view at Fig. 568 and other illustrations clearly shows the method of supporting the worm shaft by anti-friction bearings and the way the worm gearing is applied. In all cases the worm is made of hardened steel and is either triple or quadruple-threaded, having a lead angle sufficiently acute to provide the factor of reversibility, which is essential in automobile service. To one familiar with mechanics it will be apparent that, while it is possible to exert great power and secure a great ratio of speed reduction with a gradual pitch worm, the construction would be almost irreversible. This factor of irreversibility, while very desirable in such mechanism as automobile steering gears, would not be practical under those conditions where the worm wheel must become the driver as in coasting.

The worm gear assembly, which is ordinarily combined with the differential gearing, is nearly always attached to a carrier member which fits into the main axle housing. Such an assembly is shown just above the sectional view of the worm gear at Fig. 568. The reason for this construction is that it is essential that the worm gearing be accurately adjusted and that this adjustment be maintained. It is not only important that the worm should mesh properly, but the center line of the worm must coincide exactly with the center line of

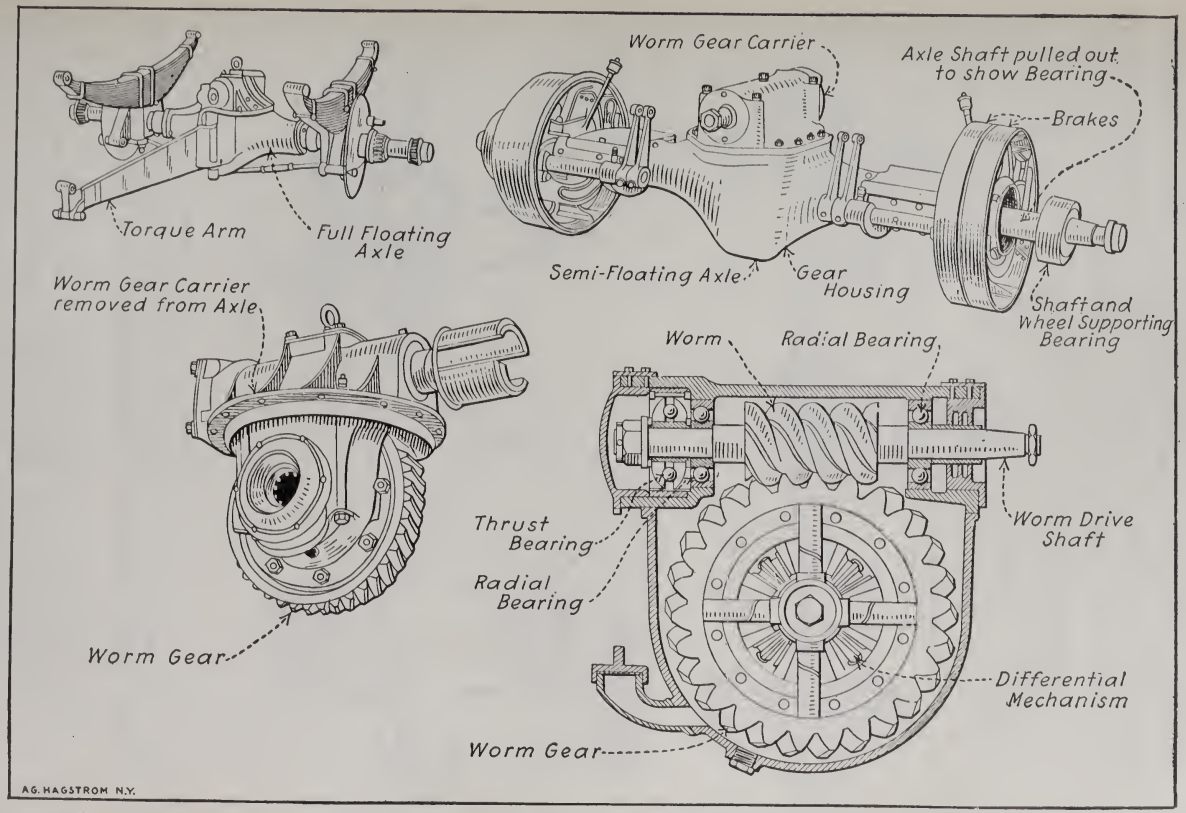


Fig. 568.—Latest Models of Worm-Driving Axles, Showing Method of Mounting Worm Gearing in Removable Carrier Member.

the worm gear or considerable friction and actual depreciation will ensue. It was fortunate, indeed, that in the automobile applications the gear ratios desired, ranging from a reduction of eight to one in the lighter trucks to fifteen or sixteen to one in the heavier vehicles, were not so low as to demand gradual pitch single-threaded worms.

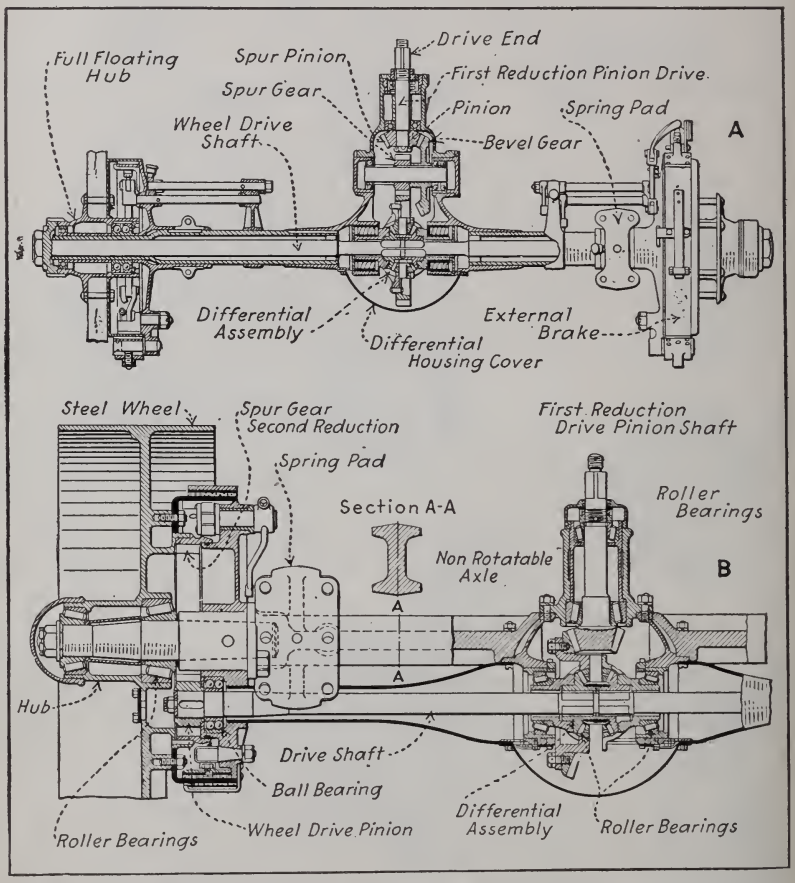


Fig. 569.—Two Forms of Double Reduction Live Axles. A—Combination Bevel and Spur-Gear Drive Forms. B—Internal Gear-Drive Truck Axle.

As the worm gearing is invariably carried in a casing that may be filled with lubricating oil, and as there is no opportunity for grit or dirt to enter, it will be apparent that long life is assured.

Another form of final drive system that is receiving considerable attention at the present time is a double reduction axle of the type in which a primary reduction in speed is obtained between bevel gears,

while a secondary and final reduction in speed is secured by driving the wheels through the medium of internal gearing. It is conceded that internal spur gearing is the most efficient form, and when it is applied properly to rear axle construction one obtains advantages that are worthy of consideration. An internal gear-driven axle, as can be readily ascertained from inspection of the part sectional view, Fig. 569, B, is a form in which the jackshaft, which is ordinarily placed on the chassis frame in the chain and sprocket drive system, is attached to the axle—in this instance a non-rotating member on which the wheels revolve freely. Instead of sprockets at the end of the live axle shafts small spur pinions are mounted which mesh directly with the large internal gears bolted to the brake drums, which in turn are securely fastened to the wheel hubs. The worm axle is a built-up form and must be made very strong because the housing for the driving gearing and axle shafts must be heavy enough to carry the load as well as enclosing the transmission members. On large capacity trucks a live axle construction becomes of necessity very massive and correspondingly heavy.

The double reduction form of axle shown at Fig. 569, A, is popular abroad, much more so than in this country. This follows the usual full floating axle construction as regards the wheel mounting and has the differential assembly driven by spur gearing instead of bevel gears. The first reduction is secured by a bevel pinion which meshes with a bevel gear carried on a short countershaft. A spur pinion on the countershaft drives the spur gear on the differential.

Rear Axle Forms.—In any motor car the rear axle is an important member as it combines two functions, one being that it is depended upon to support part of the car weight and that it must also drive the vehicle. The rear axle forms in common use are known as the "live" or "dead" types. The latter is the simplest and is built on the same principle as that generally utilized in horse-drawn vehicles.

Two types of live axles are shown at Fig. 570. That at A is the simplest form and in this the wheel hubs are mounted directly on the axle shaft, and these members are depended upon to carry the weight of the car as well as to transmit to the wheels the power delivered to the bevel gearing and the propeller shaft. In this construction the axles revolve in roller bearings carried by the axle housing. The form shown at B is known as the "floating type" because the wheel hubs are mounted directly on the substantial housing member which is called upon to support the weight of the car. The wheels can revolve freely on the housing because they are mounted on ball

bearings. The axles float in the housing and are called upon only to transmit power to the hubs and are not depended upon to sustain any of the car weight.

The live axle depicted at A has been adapted to a certain extent on light cars, but the full floating type depicted at B is much more

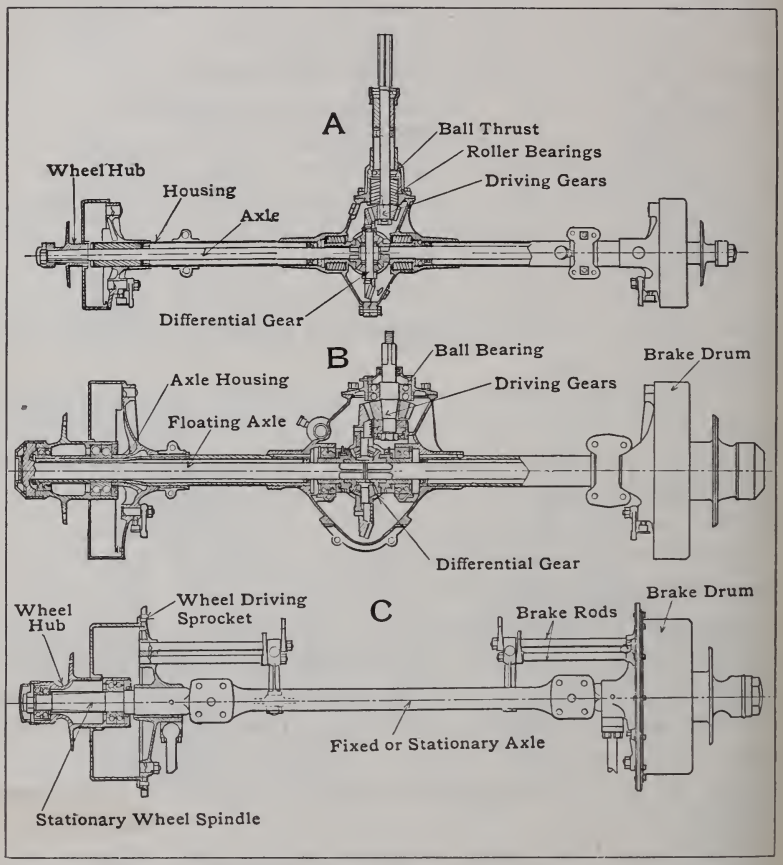


Fig. 570.—Rear Axle Types Generally Used. A—Live Rear Axle Using Shafts which Transmit Power and also Carry Car Weight. B—Full Floating Type Bevel-Gear Drive Axle. C—Stationary Axle with Chain Drive to Free Wheels.

efficient and is used on heavy vehicles. It will be evident that should the simple form of live axle deflect under load the shafts will bind and considerable loss of power will obtain. In the construction outlined at B the substantial housing members have ample capacity to

sustain the load, and as the driving shaft does not become cramped through deflection it will deliver the power to the wheels much more efficiently. A strong advantage of the floating type rear axle is that

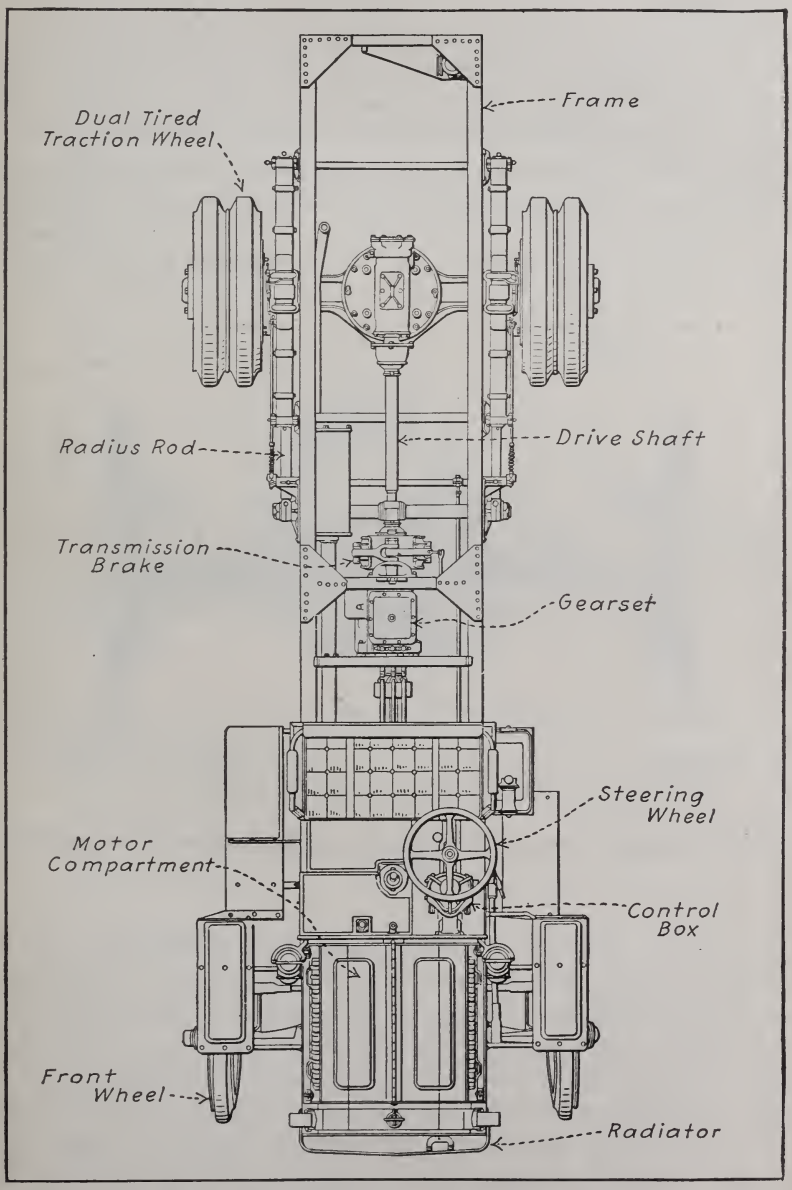


Fig. 571.—Plan View of Typical Motor Truck Chassis, Showing Application of Top Worm Drive Axle and Gear Box Mounted Independently of Power Plant.

the driving shafts and differential gearing may be removed without relieving the housing of the car weight. If it is desired to take the simple live axle shown at A apart it will be necessary to remove it from the car.

The fixed or stationary axle construction is clearly shown at Fig. 570, C. In this the wheel hubs are mounted on ball bearings which permit them to revolve about the fixed axle spindle. The hubs are turned by chain connection with suitable driving sprockets on a countershaft. The advantage of the fixed or stationary axle construction is that it is a much simpler assembly than the live axle forms, and as it may be constructed of few pieces it is apt to be considerably stronger than the built up live axles. It is contended that the lighter

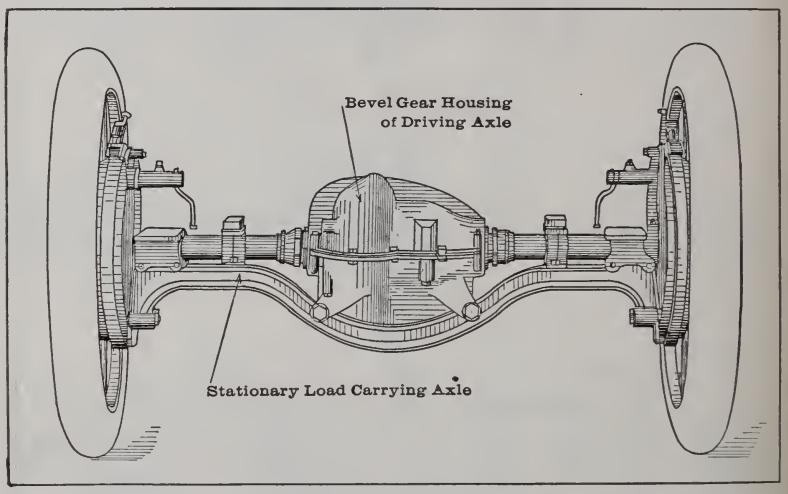


Fig. 572.—Combined Live and Stationary Axle, which Includes Features of Both Types.

axle, which is practically free from any delicate mechanism, is more desirable because there is less weight carried directly on the tires. In the live axle forms some method of driving must be provided and some form of differential gearing must be included in the rear housing. It was contended that while this construction is very suitable for light cars such as roadsters, or touring vehicles, that it would be extremely heavy if it was built of adequate strength to resist the stresses incidental to motor-truck operation. This contention has been disproved by the modern live axles of the worm-drive type which are not disproportionately heavy when compared to the other truck

parts, as clearly shown in plan view of Packard chassis shown at Fig. 573.

In the fixed or stationary axle with the wheels independent of each other, a differential gear must be provided just as much as in the live axle forms. This member is usually driven by gearing and must be installed on some form of a countershaft arrangement which is attached to the frame. It is contended that mechanism supported by the frame which is mounted on resilient springs will not be so apt to get out of order as that which is attached directly to the axle, and which is kept from direct stress of the road shock only by means of the more or less resilient tires with which the wheels are provided.

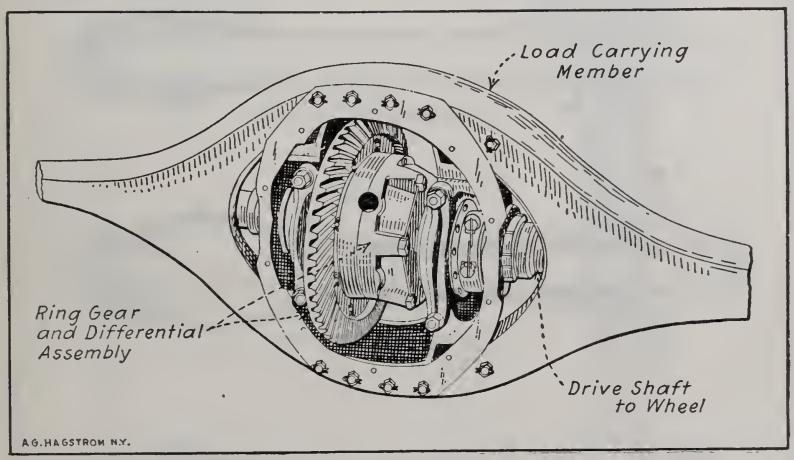


Fig. 573.—How Differential and Drive Gearing is Carried in a Housing Attached to Load-Carrying Member in Stearns Cars.

Axles have been evolved in which engineers sought to combine the strength of the dead axle with the efficiency of the live axle. One of these combinations, designed nearly ten years ago, is shown at Fig. 572. It consists of a stationary load-carrying axle forging on which the wheels revolve, this serving to take the direct load of the car as well as serving as a support for the bevel gear and differential housing that receives the power of the engine and directs it to the wheels by means of suitable shafts extending thereto from each side of the gear box. These composite forms were necessarily considerably heavier than either the live axle or the fixed axle forms, as they were a combination of both, and as they are more expensive in first cost they are used very seldom at the present time. A modified form that is used

on Stearns cars is shown at Fig. 573, but this is made light by the use of pressed steel.

Rear Axle Nomenclature.—The various types of axles that have been used in automobile construction as defined by the chief engineer of the Weston-Mott Company, one of the largest axle

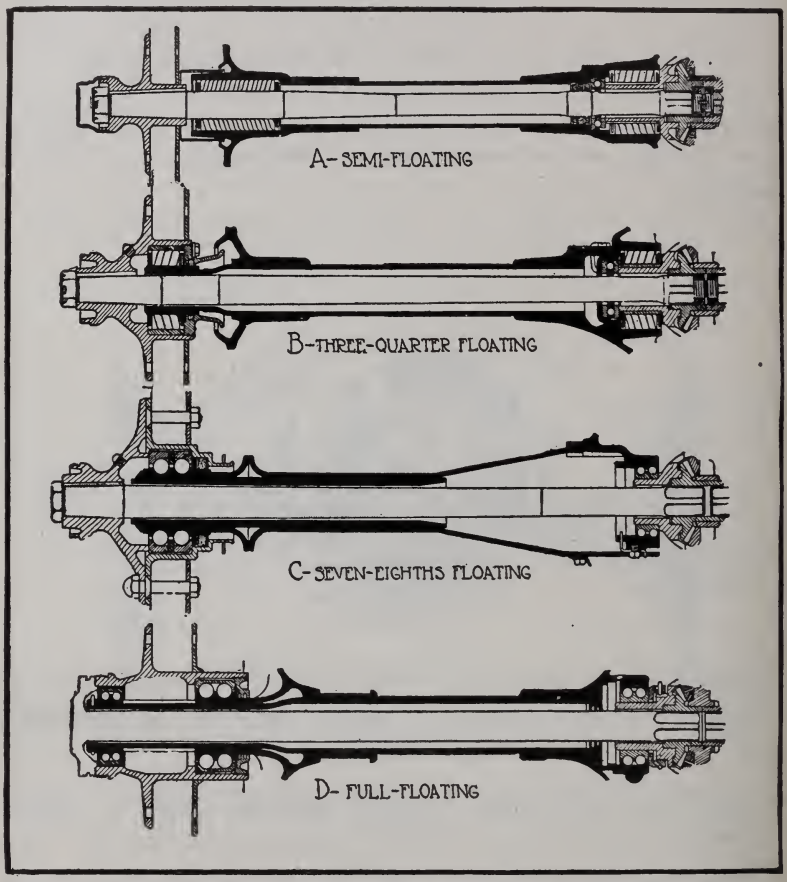


Fig. 574.—Diagrams Defining Principal Types of Weston-Mott Rear Axle Construction.

manufacturers in the world, are illustrated at Fig. 574. This shows the four main classes of axles, which are termed semi-floating, three-quarter, seven-eighths and full floating types, these being designated by the letters A, B, C, D, respectively. While the illustrations are self explanatory to one well versed in automobile construction it may be well to describe the various types in detail for

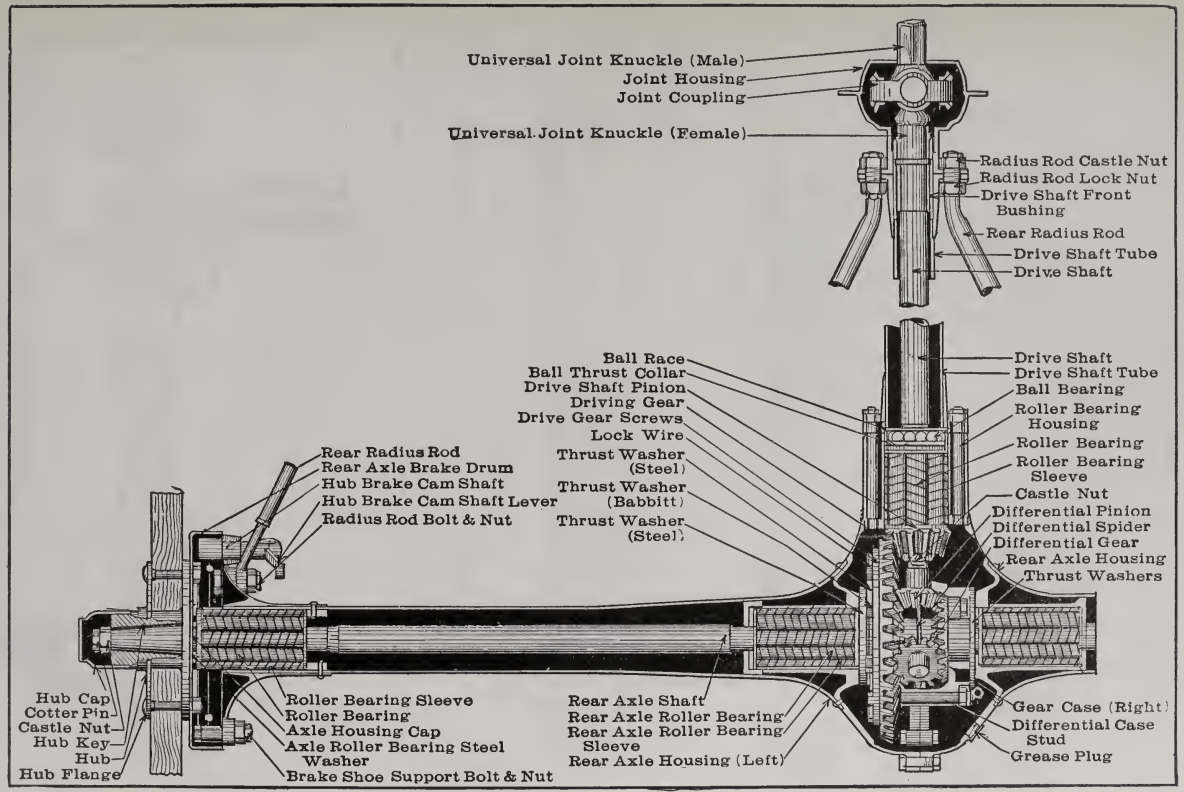


Fig. 575.—Sectional View of Ford Model T Rear Axle, Showing Driving Gears, Differential, Power Transmission Shafts and Supporting Bearings of the Hyatt Flexible Roller Form.

the benefit of those who have not had occasion to take all the various types apart. On the semi-floating axle, as shown at A in diagram form and in actually applied forms at Figs. 575 and 576, the

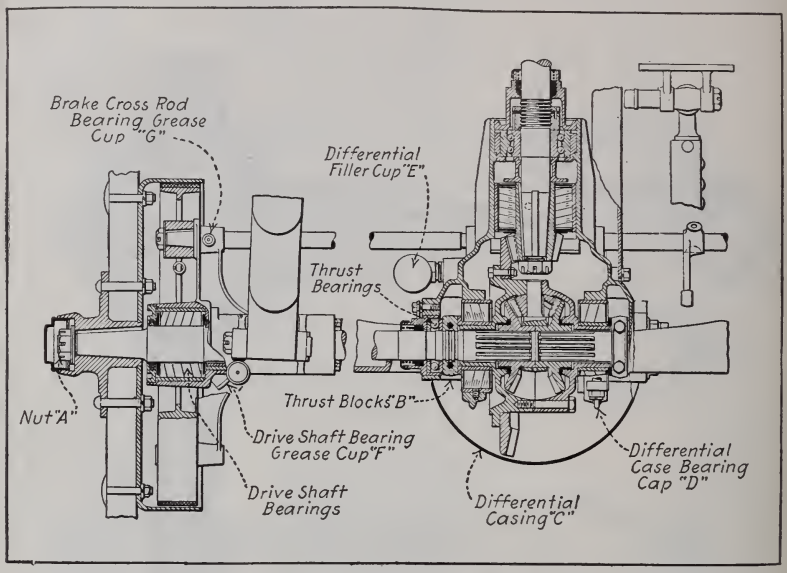


Fig. 576.—Semi-Floating Axle Used on Stearns-Knight Automobile.

entire weight of the car comes upon the axle shafts which also are depended on to transmit the power from the differential gearing to the wheel hubs. It is said that in time this would have a tendency

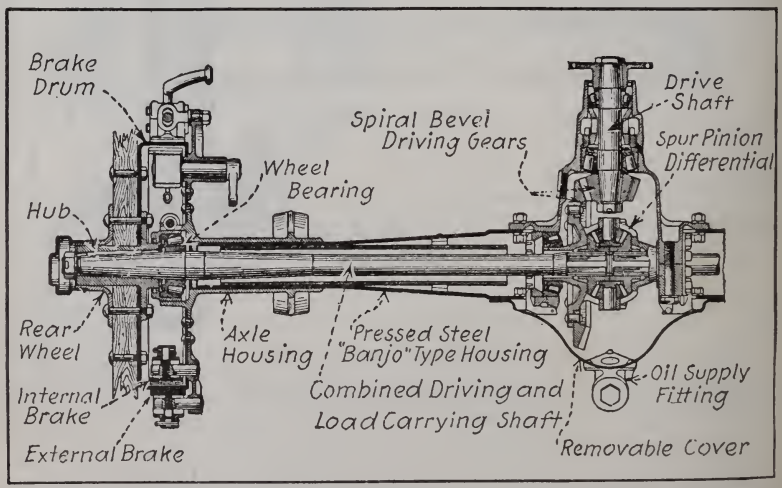


Fig. 577.—Typical Semi-Floating Axle Using Taper Roller Bearings Throughout.

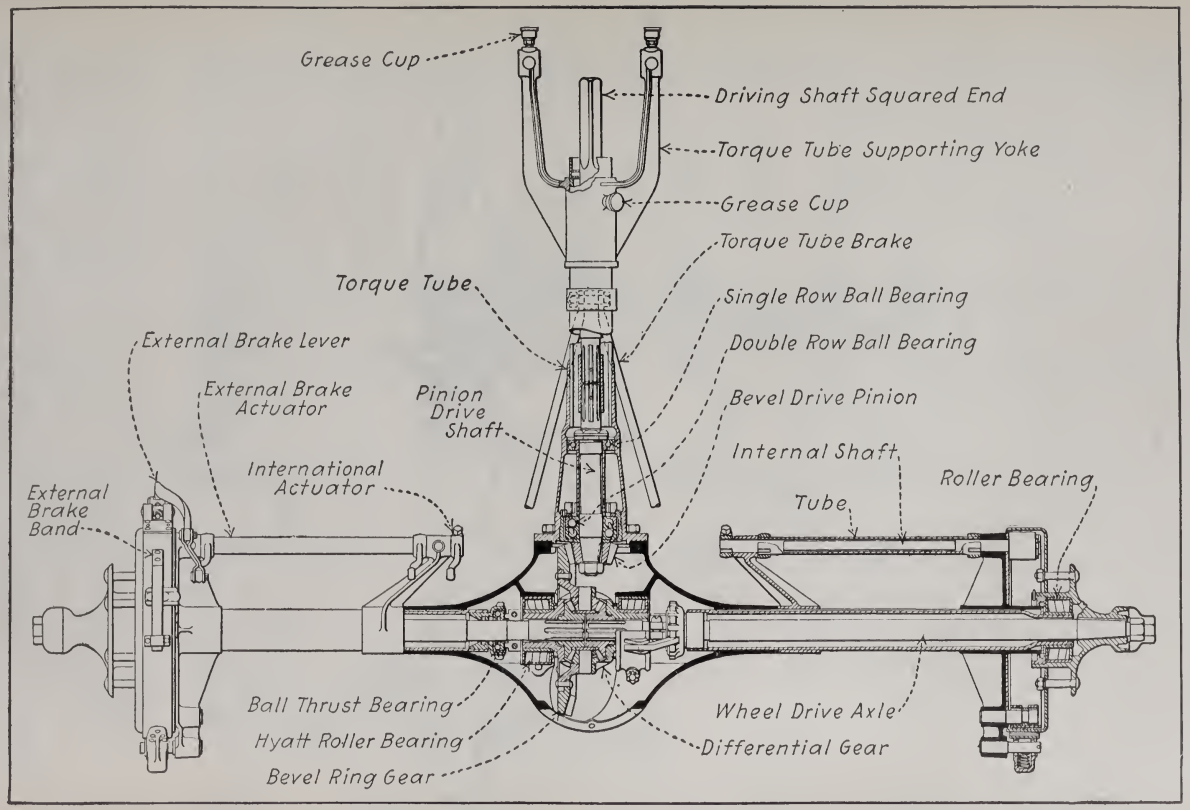


Fig. 578.—Sectional View Showing Construction of Three-Quarter Floating Axle Having Long Third Member Suitable for Light Cars.

to cause the shafts to crystallize and break unless great care is taken in proportioning the shafts so strong that they will resist the stresses imposed upon them. This type of axle is not generally recognized as the semi-floating form as most engineers call it a non-floating live axle. The reason for this is that the axle shaft does not even partially float as it is held in the hub of one of the differential bevel gears by the threaded retention members in most forms. In order to be a semi-floating axle it would be necessary to utilize a bearing type at the wheel end that would take end thrust and keep the wheel shaft in place while the part of the axle that projected into the differential would not be held by any threaded nut.

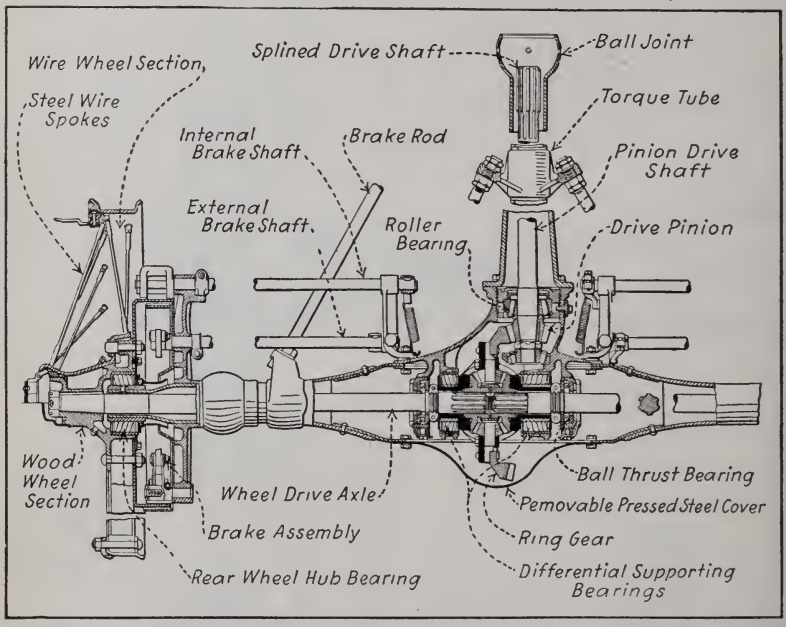


Fig. 579.—Three-Quarter Floating Axle Employed on the Case Model 40 Automobile.

A true semi-floating axle should be of such form that the axle may be readily withdrawn without necessitating the complete disassembly of the rear construction. The axle shown at Fig. 576 is semi-floating to a degree, however, because the differential gear is carried by bearings which are outside of the differential case bosses instead of bearing directly on the axle shaft, as is the case with light axles of such cars as the Ford, shown at Fig. 575. The three-quarter floating axle shown in diagram form at B and at Figs. 578 and 579 in

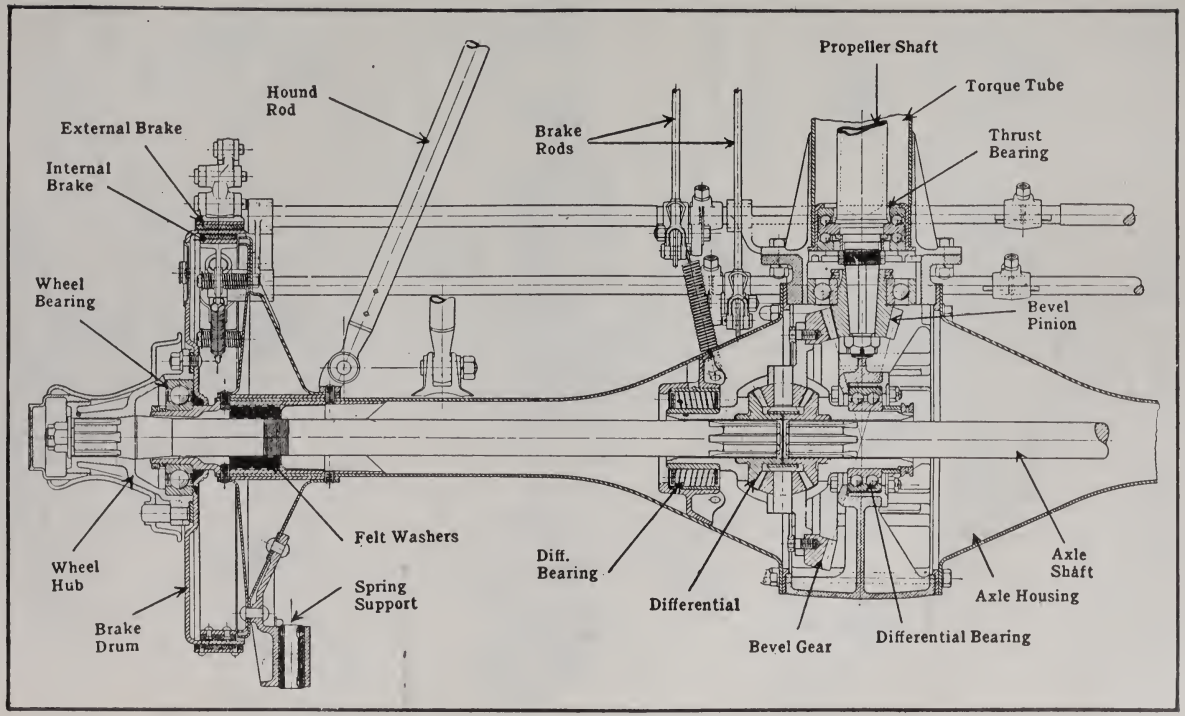


Fig. 580.—Sectional View of Marmon Three-Quarter Floating Rear Axle, Showing Relation of Various Parts.

actual cross section is a design in which the axle shaft is subjected only to torsional strains or to a twisting action due to the power applied to drive the car. The wheel bearing is mounted in the axle housing instead of inside of that member, as shown at A. This brings the

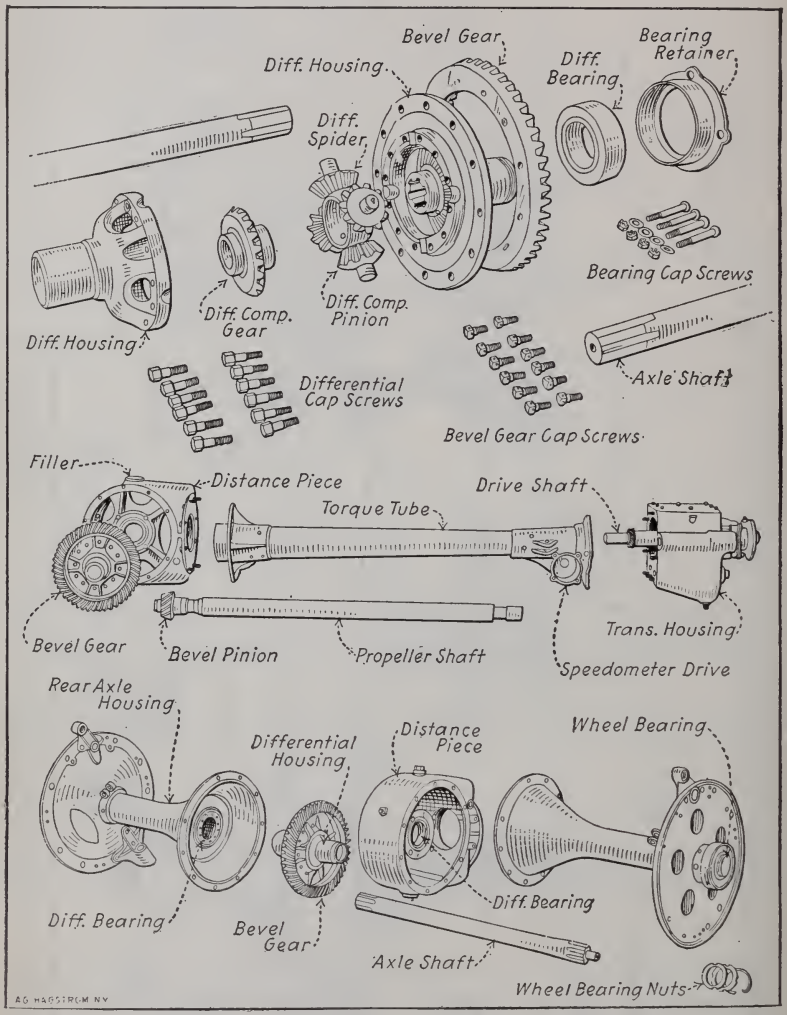


Fig. 581.—Showing Parts of Dismantled Marmon Axle Construction Depicted in Sectional Assembly at Fig. 580.

strain due to the weight of the car in the non-rotating axle housing instead of on the shaft as in the type shown at Fig. 577. The type shown at Fig. 574, C, which is termed the seven-eighths floating by

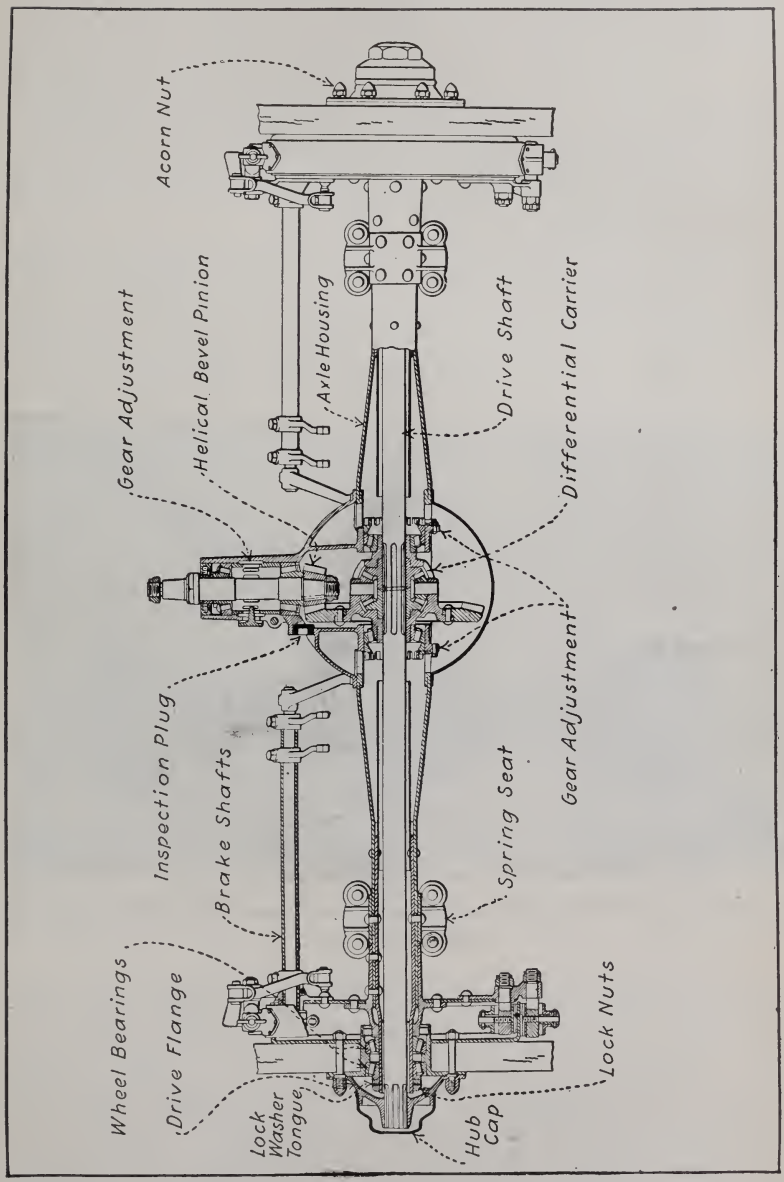


Fig. 582.—Full Floating Axle Employed on National Automobile.

some engineers and which is called a single bearing full floating hub by others, has many of the advantages of the three-quarters floating construction in that the drive axle tends to steady the wheel and also has the advantage of the full-floating type in that the wheel may be removed from the rear construction without taking the differential gearing out of its housing. The cross section of the distinctive seven-eighths floating or one bearing float axle used on 1917 Marmon cars is shown at Fig. 580, while its important parts when the axle is taken apart are shown in Fig. 581.

The full-floating axle construction is not used as widely as it used to be, as the three-quarter floating type is the most popular. It is a very highly developed type now and gives very satisfactory service. The difference between the axle types shown at Fig. 574, C and D, is that the latter has two bearings in the wheel hub and the hub is

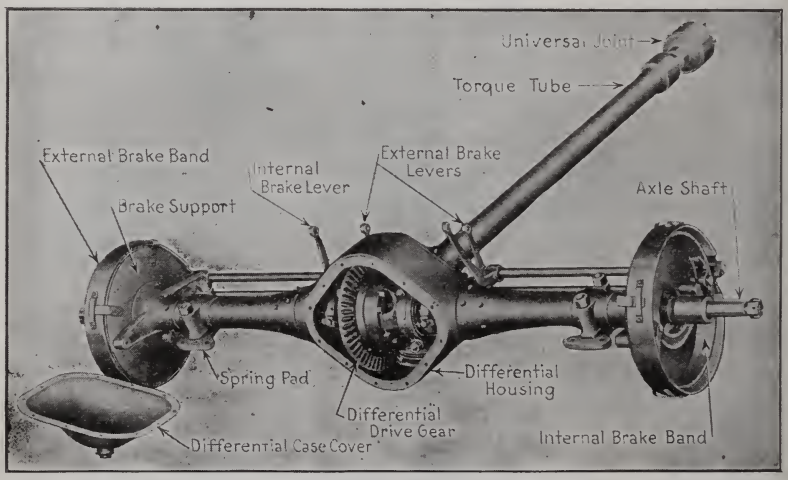


Fig. 583.—Rear Axle with Differential Case Cover Removed to Show Differential and Drive Gearing.

driven by a clutch of the jaw type at the end of the axle drive shaft. This shaft is not called upon to help steady the wheel against end thrust as it is in the three-quarter floating axle, the wheel bearings are spaced far enough apart to resist all stresses coming on the wheel. The shaft may be withdrawn without impairing the strength of the wheel end of the axle. In event of a broken shaft, a replacement is easily made and the car may be towed for any distance, even with a broken drive shaft, without stressing the wheel bearings, a thing that would be impossible in a semi-floating axle and not be advised even with a three-quarter floating type. A typical full-floating axle used

on National cars is shown at Fig. 582. A typical three-quarter floating axle with the wheels removed and the cover of the differential housing taken off to show the differential assembly and ring gear is shown in photographic reproduction at Fig. 583. The drive shaft is housed in a long third member, which acts as a torque member as well as the propeller shaft housing.

Purpose of Differential Gear.—One of the most important elements of any form of automobile-driving system is the differential gear, but as this is usually placed at a point where it is not easily seen by the motorist and as but very little trouble is experienced from this mechanism, many owners of cars are not aware of its existence and do not realize the important work performed by this relatively simple component. Without a differential gear it would be difficult to control the machine when driving around corners, so this really performs an important function with both steering and driving systems.

When turning corners with a four-wheel vehicle the outer wheels must turn at a higher rate of speed than the inner ones because they are describing a larger arc of the circle. The more sharply the vehicle is turned the greater the difference in velocity between the inner and outer wheels. In a horse-drawn conveyance all the wheels are independent of each other and may all revolve at different speeds if necessary, without interfering with each other or impairing the action of the conveyance. In an automobile different conditions prevail because while the front wheels are usually independent of each other, the driving wheels must be connected together so that each will receive its share of the energy produced by the motor and will perform its quota of the work incidental to propelling the vehicle.

In order to permit one of the driving wheels to turn at a lower speed than its mate in rounding a corner the balance or differential gear is used. Its simplest application is shown at Fig. 584. From this it is patent that the driving axle is split in the center and that the wheels are mounted on and driven by distinct shafts. At the inner end of each shaft a bevel gear is carried, these being firmly secured to the axles so they revolve with them. The main bevel-driven gear, which is actuated by the driving pinion turned by the engine shaft, is mounted independent of the axles and is coupled to them by means of small bevel pinions which are applied so that they will drive the gears on the axle shafts. Assuming that all the gears are in mesh, as outlined, and that power is being applied to the driven gear, and that the resistance to traction is the same at both rear wheels, the entire assembly comprised of driven gear, the differential pinions attached to it and the axle shafts revolve as a unit.

If the resistance against the driving wheels varies so one wheel tends to revolve faster than the other, the differential pinions will not only turn around on the studs on which they are mounted, but at the same time will run around the gears on the axle shafts, because the bevel-driven gear is carrying the studs on which the differential pinions revolve forward. When turning a corner the outer wheel must turn so much faster than the inner member that it is just the same as though one of the wheels was held stationary and the other turned. If both wheels are turning forward at the same speed, the differential pinions remain stationary and act simply as a lock which forms a driving connection between gear No. 1 on axle shaft No. 1 and gear No. 2 on axle shaft No. 2. This will mean that both wheels must turn in the same direction as long as the work is uniformly distributed. Just as soon as the resistances are unequal the differential pinions will turn on their supporting stud, and one member may turn at comparatively slow speed while the other revolves at a much faster rate.

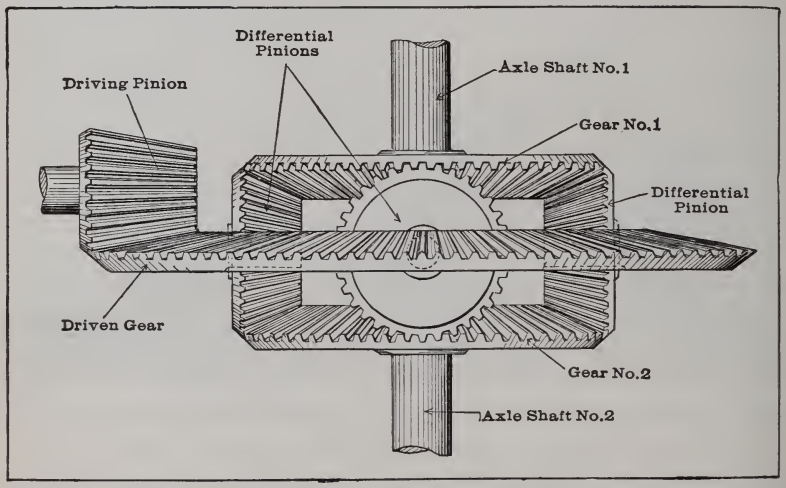


Fig. 584.—Illustrating Differential Gear Action when Applied to Bevel-Gear Drive Axle.

The action of the differential pinions may be clearly understood by reference to Fig. 584 and giving due consideration to the following principles: The same resistance at the point of contact between the driving wheels and the ground prevents the pinions from revolving on their own studs, and in this case they are carried around by the supporting members and the ring gear. If the resistance upon

axle shaft No. 1 is greater than that on axle shaft No. 2, the ring gear will rotate forward with the wheel offering the least resistance and the differential pinions will turn on their studs and run over the surface of the gear which tends to remain stationary, this being the one against which there is the greatest resistance. The differential pinions can thus turn independently of one gear wheel and run over its surface without turning it, and at the same time act as a clutching member of sufficient capacity on the other gear and axle to carry

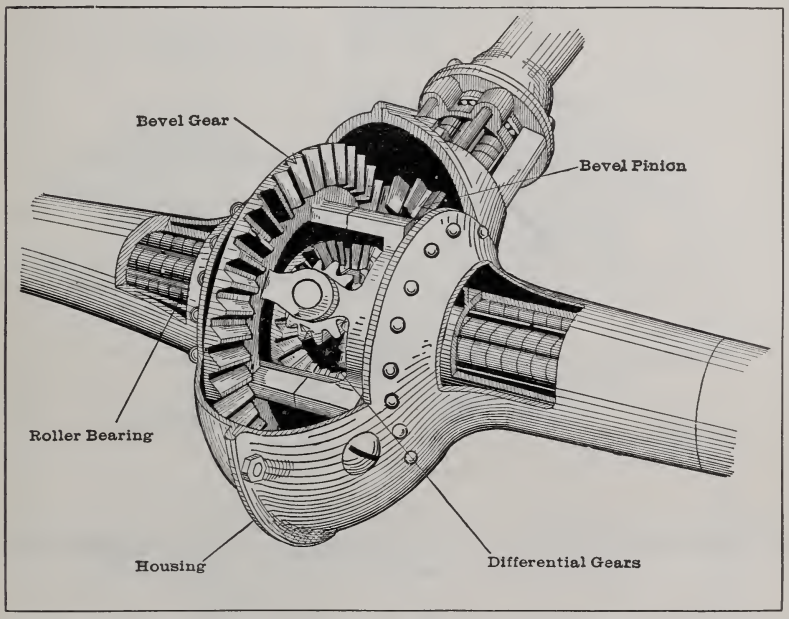


Fig. 585.—Bevel-Gear Drive Assembly of Model T Ford Cars Mounted on Hyatt Roller Bearings.

them in the same direction as the ring gear and at a ratio of speed which will depend upon the difference in resistance between the driving members and the ground.

While the differential gear described is of the bevel pinion type, other forms have been devised in which the differential action is obtained by means of spur gearing which utilizes the same principle of compensation. Various friction and leverage combinations have been adapted in an endeavor to secure a differential action, but these have eventually been displaced by the simpler and more efficient geared forms. The differential gear which utilizes bevel pinions is the form that is more generally used, and has proved to be the most

efficient and enduring. The differential gear is usually incorporated in the rear axle if the drive is by shaft or single chain, and in the countershaft if transmission is by means of side chains. The construction of typical differential gears and bevel-driving gear assembly is clearly shown at Figs. 585 and 586; the former is utilized on light

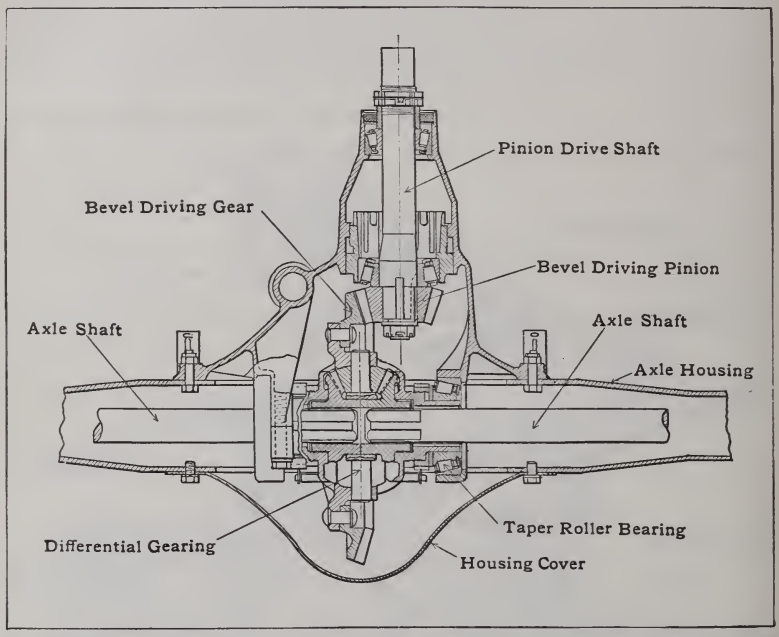


Fig. 586.—Bevel-Gear Drive Assembly Mounted on Timken Tapered Roller Bearings.

vehicles and is mounted on flexible roller bearings, while the other construction is a type more suitable for heavier cars and is mounted on tapered roller bearings.

Differential Substitutes.—In a paper read before the S. A. E., D. B. Ormsby discussed the features of the various substitutes for the conventional differential gearing as follows:

The conventional differential rather than being inefficient is on the other hand too efficient in that it differentiates for all differences, whereas the automobile engineer wants it to take care only of the unequal velocities of the rear wheels. It becomes inefficient as a means of transmitting the power to the rear wheels if the wheels have unequal traction. It is to correct this defect of differentiating for unequal traction of the wheels that a great many intended substitutes for the present types of differential have been invented.

The substitutes can be divided into four classes: The free-wheel type, crank and eccentric, spiral differential, and the solid axle.

Fig. 587, A, shows the Hedgeland solid anti-skid automobile axle, of which little has been heard for some time. As the name indicates, this axle was constructed with a continuous or solid axle, having a thread cut on both ends. To these threaded ends were attached cone

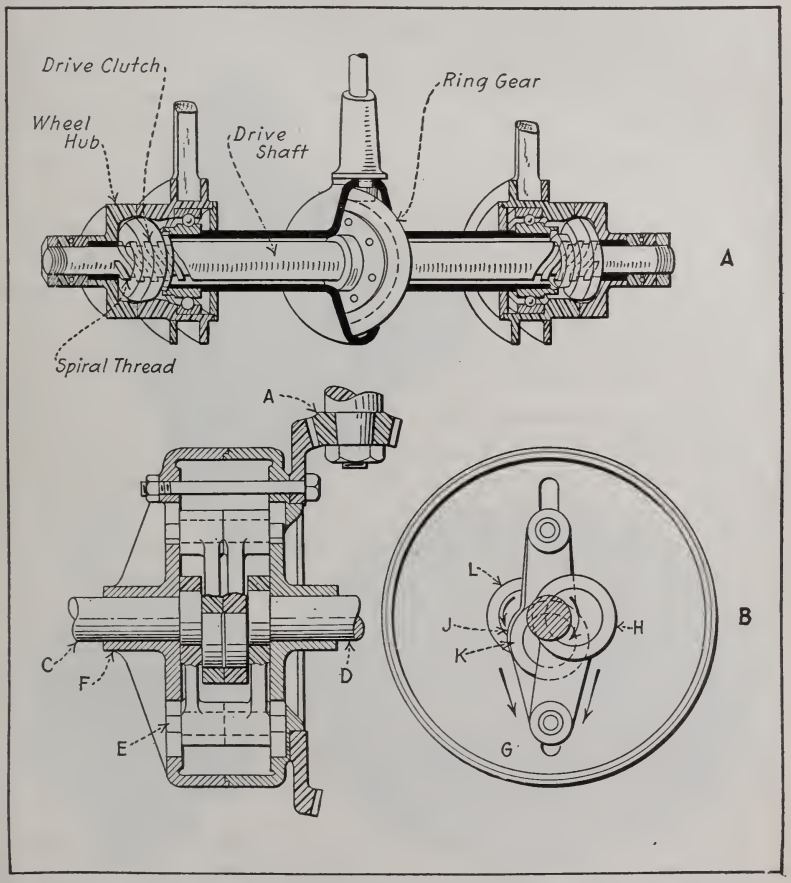


Fig. 587.—Unconventional Differential Gears. A—Hedgeland Differential Substitute. B—Crank and Eccentric Type.

clutches having a double taper, so that when the power was applied to the axle these clutches were forced one way or the other by means of the thread on the shaft and they gripped a cup which was attached to the wheel, thus transmitting the power from the shaft to the wheels. When a car equipped with this device was making a turn or diverging

from a straight course, so that the outer wheel was obliged to travel faster than the inner wheel, the outer wheel was automatically declutched much more rapidly than the inner wheel. There is considerable shock when it slows down to a point slower than the inner wheel, and the differentiating mechanism is obliged to pick it up.

The second type of differential substitute is shown in Fig. 587, B. For convenience we will call it the crank and eccentric type. I was unable to obtain the name of the inventor of this differential and believe it has not been tried out to any great extent. It is an interesting device composed of two axle shafts designated as C and D in the reproduction. At the ends of these shafts are turned two eccentrics, to which are attached four cranks, designated H, K, J and L; H, K being attached to the eccentrics on shaft D and J, L to the eccentrics on shaft C. These cranks carry bosses which are bored and through which are passed sliding pins E and I, upon which the cranks are centered and oscillate. The cranks L and H are attached to sliding pin E and J and K to sliding pin I. These pins are allowed to slide in slots in the case F, which is made in two halves bolted together. The action is as follows: The power applied to the bevel driving pinion A is transmitted to drive gear B, which is attached to and therefore rotates the case with the gear. When the car is traveling in a straight line the sliding pins E and I rotate with the case, and the whole differential mechanism is rotated. When the car diverges from a straight line and the wheels have unequal velocities, the outer wheel speeding up oscillates the cranks by means of the eccentrics on the shaft, the cranks being allowed to oscillate around the center of the axis of the shafts and the eccentrics placed at such an angle in relation to each other that the required reverse direction of motion of the shafts is obtained. This allows the outer wheel to speed up and the inner wheel to become retarded, but because the angles of the eccentrics are so sharp, when one wheel loses traction it does not spin.

The third type, which has received considerable attention, is the spiral gear. This differential is similar to the conventional type, except that its differentiating gears are made up of a train of spiral instead of bevel or spur gears. Its action is the same in principle as that of the bevel or spur gear types, but the spiral gears are placed in such a manner as render the differential train inefficient, so that it is impossible to spin one wheel without rotating the other. Fig. 588 is a perspective sectional view of the type. It seems that a design of this nature should be the ultimate solution of the present differential problems.

New Positive Drive Differential.—A new type of worm differential which is of exceedingly simple design, and which has the meritorious feature of driving both wheels, regardless of the traction condition of either, has been put on the market under the name of the Walter positive drive differential. The differential consists of two pairs of spiral gears mounted in a two-part housing as shown in the accom-

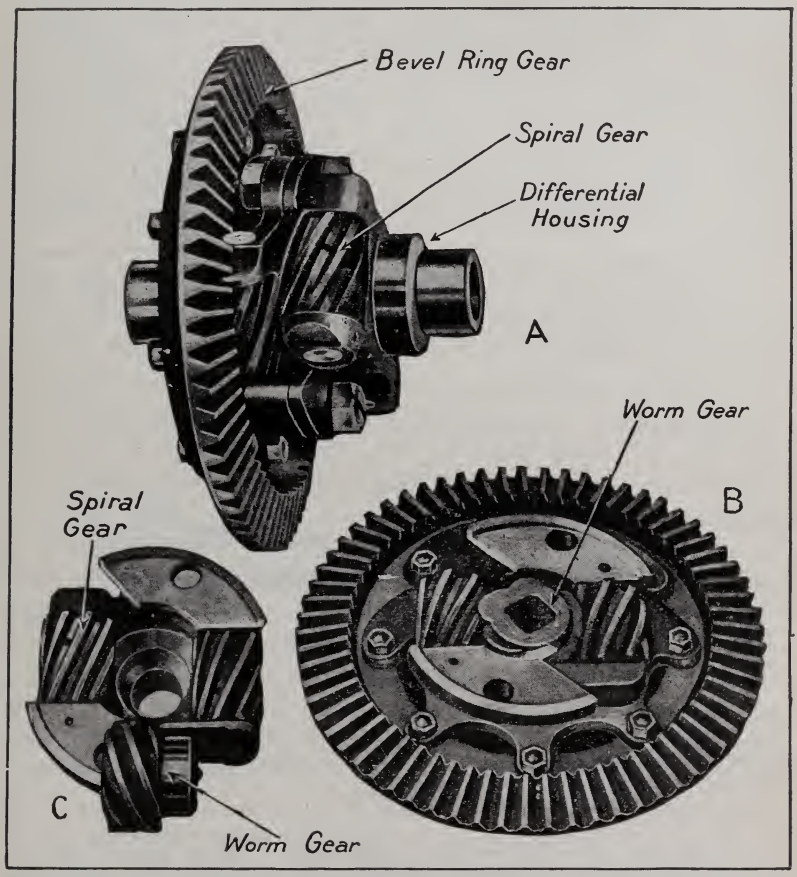


Fig. 588.—Assembled View of Walter Positive Drive Differential at A. View of Ring Gear, Differential Parts and Worm Gearing at B.

panying illustration, Fig. 588. The two pairs of spiral gears mesh together and also mesh with worms mounted in the housing and on the drive-shaft. The housing is in halves which are alike except for the flange for the bevel gear. The two bolts which hold the housing

together set one ahead of the other in order to bring the spiral gear pairs into direct mesh.

The worm can be given any desired pitch within the limits of good practice, but in the standard design they will have a 22.5 degree lead angle, as this has been found to be the best in practice. The construction is not limited, however, to any special spiral angle. With this construction, the operation will be as follows: The driving resistances of the wheel tend to rotate the spiral gears on their pins in opposite directions. When one wheel has a greater resistance the inequality of force cannot drive the other wheel faster as the spiral gear cannot drive the worm on account of the relationship of the pitch angle to one another. The result is that both wheels are positively driven. When turning, the outside wheel rolls faster and so permits the inside wheel to turn correspondingly slower, giving a compensating differential action.

Worm gearing has been chosen because it provides strength, while at the same time giving a smooth and pliant action. The flexibility of the worm gearing is very effective in diminishing the shocks trans-

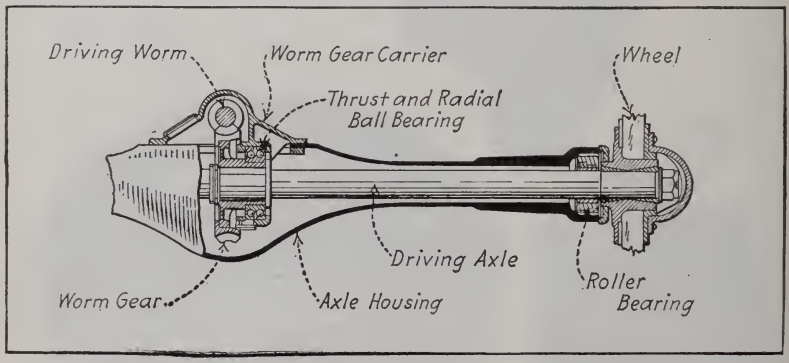


Fig. 589.—Experimental Worm-Drive Axle, in which Differential Gearing is Eliminated.

mitted through the differential mechanism. Five advantages are claimed for this type of differential. These may be briefly summarized as follows: 1—The car will not stall if a single wheel alone has traction. 2—The motor power is used more effectively, as both wheels are steadily driven. 3—Skidding is eliminated in many cases, due to the steady driving of both wheels. 4—More even pulling is secured on a rough road for the same reason. 5—The wear and strain on tires due to an accelerated or spinning wheel recovering the road is eliminated, a notable advantage for economy.

As will be noted from the foregoing description, this differential is different in construction and principle from the 45-degree type and the ratchet differentials which have an overrunning action. The widest difference between the 45-degree and this is that it is a positive drive in the first place, and, secondly, it is irreversible, whereas it is the nature of 45-degree gears to be perfectly reversible. The distinction between the Walter differential and the ratchet differential is twofold as far as operation is concerned. In the first place, it has not an overrunning action, and, secondly, instead of driving the wheel of most resistance, the two wheels are given equal power.

Experiments have been made with solid axles, eliminating the differential as shown at Fig. 589. These are only suitable for slow-speed trucks using solid tires and operating on good roads. The experiments made do not show any advantages in either trucks capable of moderate speeds or pleasure cars capable of running at high speeds. There is considerably more wear on tires and cars are harder to steer than when a differential gear is employed.

Worm-Gear Driving.—A number of designers have used worm gearing in connection with shaft-driving systems instead of the bevel gears so generally adopted. The greatest development of worm driving has taken place abroad, and very efficient and enduring mechanisms have been evolved. The advantages of the worm gear are more apparent in motor-truck construction than in pleasure-car practice, though it has been used to advantage in both classes of vehicles. A high degree of efficiency has been obtained by using worms of peculiar tooth formation which have a spiral angle often approaching 45 degrees. Such worms may have from six to ten or twelve threads, and they are perfectly reversible, when contrasted to the single-threaded worm used in steering gears, which are an irreversible form. Obviously the worm employed for driving an automobile must be perfectly reversible to be practical, as very often conditions will be such that the rear wheels and worm gear to which they are attached must turn the worm and driving shaft, as in descending hills, with the rear axle overrunning the engine.

This form of gearing offers many inducements and has positive advantages which commend it as a means of direct final drive. Any range of reduction that would be likely to be needed may be obtained with but a single pair of worm gears, and reductions of twenty to one may be as easily accomplished as securing the higher ratios without the efficiency of the combination being affected. It would not be possible to obtain as low speed reduction as possible with worm gearing by the use of a single set of bevel gears or a single pair of sprockets

and chain connections, because the driven member would have to be of such large size that it would be difficult to place it within the confines of an ordinary axle. It is for this reason that most motor-truck manufacturers use a combined bevel gear and chain drive and a double reduction of speed between the engine and the rear wheel.

Among some of the advantages advanced in favor of worm gearing may be cited: It is silent in operation; when properly designed it will transmit eighty-five to ninety per cent of the engine power to the rear wheels on direct drive, and it is extremely enduring. Its efficiency under ideal conditions is equal to the most accurately machined and finely adjusted bevel gearing, and instead of the efficiency becoming less as the gearing wears, it actually becomes more silent and freer running with use.

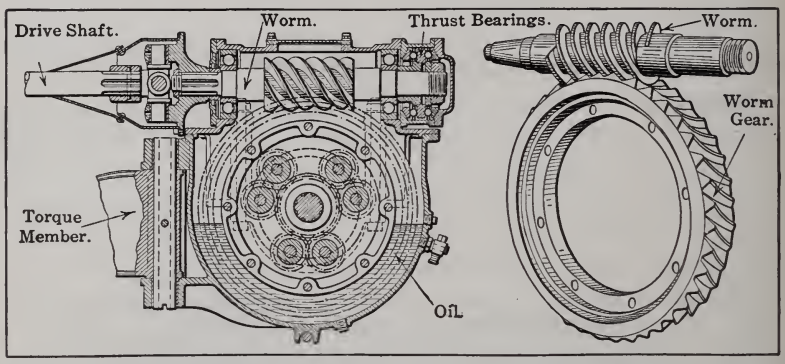


Fig. 590.—Worm-Gear Driving Assembly Utilized on Pierce Motor Trucks and Form of Worm and Worm Wheel Utilized in Power Transmission.

Many of the more progressive manufacturers of motor trucks are giving the worm and worm-gear drive that consideration which means its eventual adoption. It has been used with success in European and American pleasure-car applications, but its greatest field of usefulness will undoubtedly be the commercial vehicle industry because of its undoubted superiority over all other forms of gearing from which considerable reductions in ratio are demanded and where the efficiency of the transmission system should be conserved as much as possible. A typical worm-gear assembly and the method of mounting the worm in connection with the shaft drive is shown at Fig. 590, while the illustration at Fig. 591 shows clearly the application of worm and worm-wheel drive in a live or floating axle construction.

The arrangement of a worm-gear driving axle of English design

is clearly outlined at Fig. 592, with all parts shown in correct proportion. As this is reproduced directly from an engineering drawing it will prove useful in showing the actual relation of the various parts to each other. The worm is mounted above the worm gear and is supported by two single-row ball bearings of the annular type which take the radial stresses. As there is also a large end thrust, due to the angle of the worm teeth, it is necessary to use a double ball-thrust member at the rear end of the worm to take the end thrust which is present whether the worm gear is being revolved to drive the vehicle forward or backward. As will be seen by the longitudinal sectional

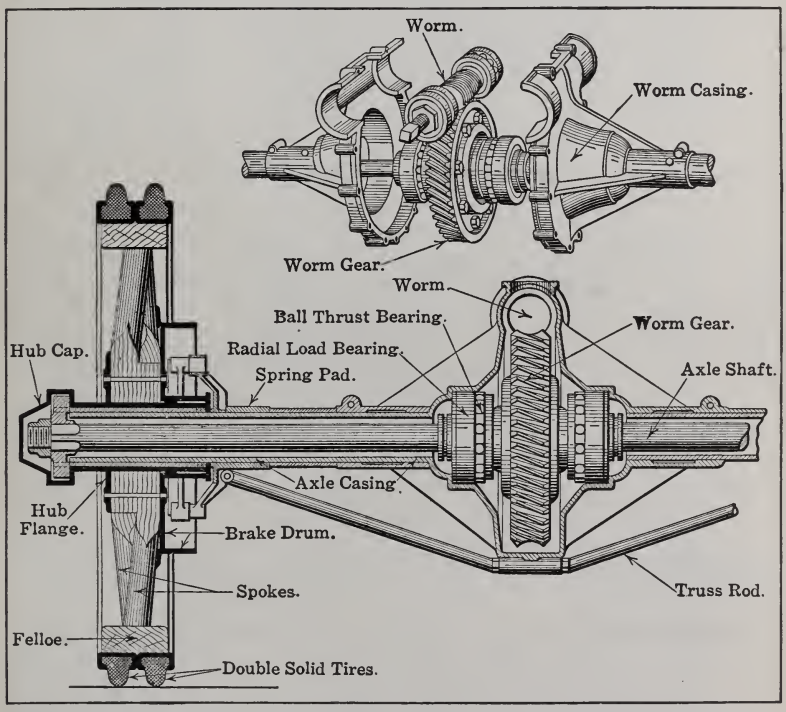


Fig. 591.—Worm-Gear Driving Axle Used on Dennis (English) Motor Cars.

view through the rear construction, the worm-drive assembly is used in connection with a live axle, and the worm gear is attached directly to the case which houses the differential gears. The differential assembly is supported on large single-row annular ball bearings, while end-thrust bearings of the ball type are provided to hold the differential assembly in place positively so that the worm and worm wheel cannot be forced out of correct engagement by the end thrust exist-

ing on the worm gear. The drive from the differential to the wheels is by conventional live axle shafts.

An American application of the worm driving system, in which the driving worm is placed below the worm gear instead of above it,

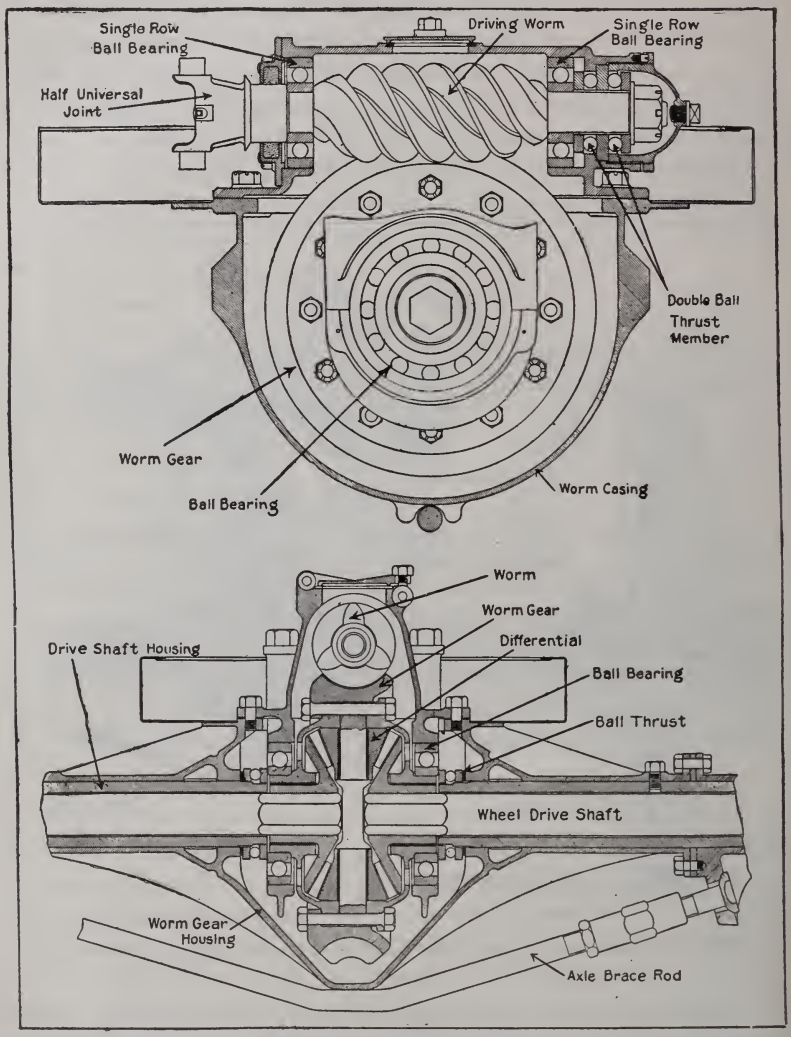


Fig. 592.—Practical Application of Worm-Gear Drive to Live Axle of English Design.

is outlined at Fig. 593. The automobile depicted is a Lyons-Knight, which utilizes a sleeve-valve motor as a power plant. The drive from the motor is through a clutch of conventional construction to a uni-

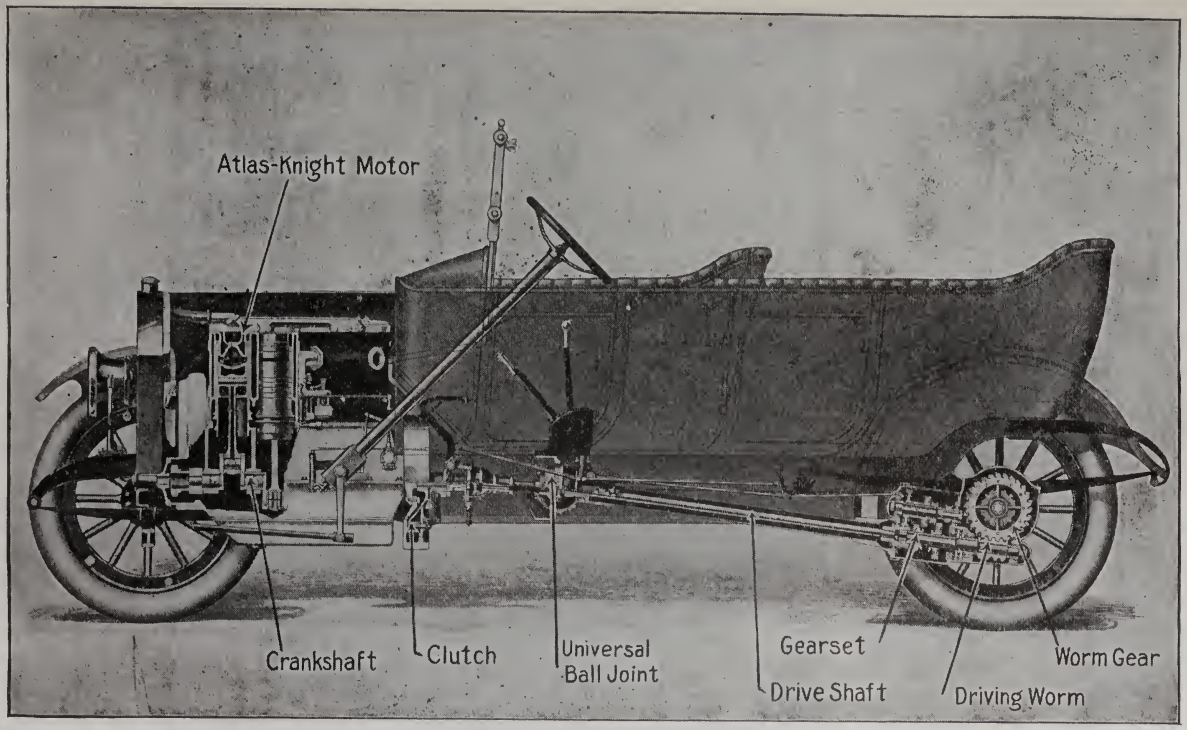


Fig. 593.—Part Sectional View of Automobile, Showing Practical Application of Knight Motor and Worm-Gear Drive Axle.

versal ball joint which is held in place on one of the frame cross members. This ball joint encloses a universal joint which is mounted at the front end of the drive shaft that takes the motor power from the clutch to the main member of the gearset. This is of the three-speed sliding-gear type and has the countershaft mounted above the main shaft. An extension of the main shaft carries the driving worm which meshes with the worm gear on the differential casing that is employed to drive the wheels. The thrust bearings are mounted at the front end of the worm and are housed in an extension of the transmission case. It is said that the location of the worm at the bottom of the worm gear insures positive lubrication as long as there is any oil in the driving worm casing.

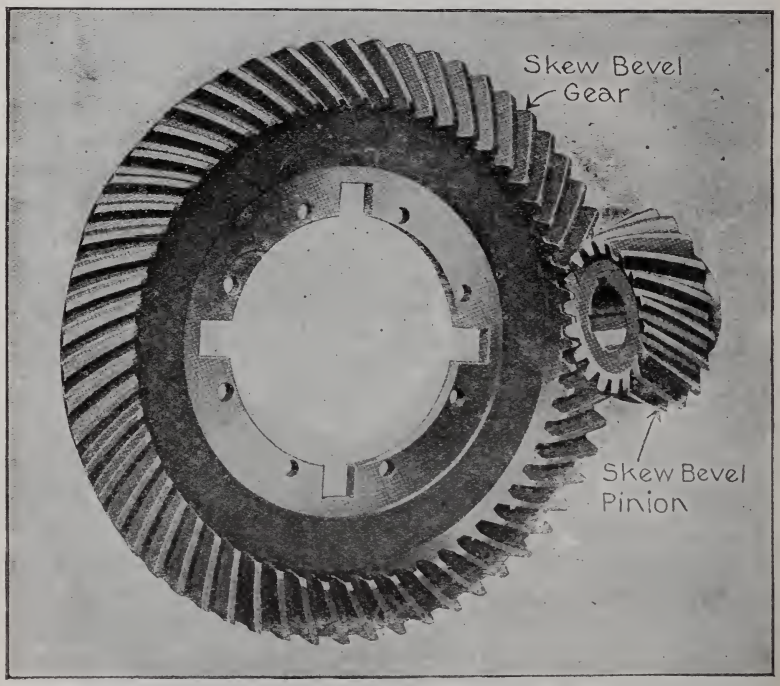


Fig. 594.—The Packard Skew Bevel-Driving Gearing, a Type that is Quieter Than the Usual Straight Bevel.

Skew Bevel-Drive Gearing.—The skew bevel or worm bevel, as it is sometimes called, differs from the regular form of bevel gear in that the teeth on pinion and ring gear are cut on an angle, as in worm gearing. The construction of typical skew bevel driving gears detached from the differential casing is shown in illustration, Fig. 594. It is

claimed that the skew bevel produces increased quietness of drive, as backlash or looseness between the teeth, which is a common cause of noisy action of conventional bevel gearing, is entirely eliminated by the angular teeth. It is also claimed that whereas ordinary bevel gearing has a straight line contact that the worm bevel with its curved teeth has one set of teeth constantly meshing while the next set is becoming disengaged. This affords a continuous contact, in some degree the same as accomplished with worm gearing.

Two-Speed Direct-Drive Axle.—This is an axle construction of recent development and is called the two-speed direct-drive axle because, in place of a single bevel pinion and ring gear used in the ordinary construction, there are two bevel pinions and two ring gears attached to the differential casing. A typical assembly of this nature is shown at Fig. 595. The drive pinion B is integral with the drive shaft and always revolves with it, while the larger drive pinion A only revolves with the drive shaft when the sliding clutch A is engaged with the corresponding clutch member attached to the pinion. When the sliding clutch A is shifted into position, the actuating bell crank shifts another sliding clutch attached to the differential gear case which releases ring gear B and allows the engine to drive the differential casing and the gearing it contains through the medium of drive pinion A and ring gear A.

When the other ratio is desired, the positive clutch-shifting lever is moved so that it brings sliding clutch A out of engagement, which causes a simultaneous movement of sliding clutch B so that ring gear B is clutched to the differential casing. It will be apparent that the drive is through only one set of gears at a time, the set that is not in use revolving idly on suitable bearings. This construction affords two gear ratios, each driving direct from the engine to the wheels without any intermediate gearing other than the regular driving gears ordinarily employed in a one-speed axle.

It is contended that no one single gear ratio can be just right for all vehicle speeds and all road conditions. The usual gear ratio of a single direct-drive axle ranges from 3.5 to 1 to 4 to 1, according to the weight and power of the car. If a car is geared low, high speeds can only be obtained by racing the engine, but its hill-climbing abilities on the high are excellent. At the other hand, if the gear ratio is such that the car can be operated at high speed without racing the engine, it will be a poor hill climber and the low gears will have to be resorted to on any gradient of magnitude. In the axle shown there are two gear ratios, one of which is low, and which is especially adapted for city driving, where starting, stopping, and slowing down

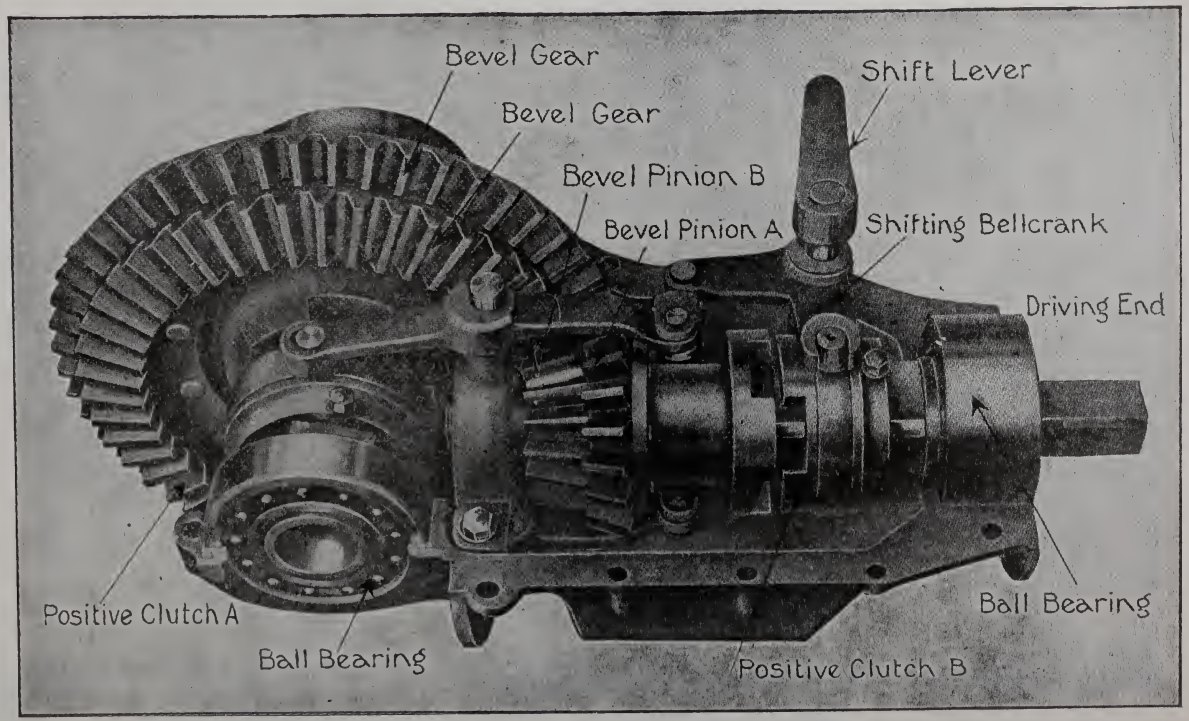


Fig. 595.—Outlining Construction of the Austin Two-Speed Direct Driving Gearing Used on Rear Axle.

are frequent and where cautious operation is necessary. When conditions are more favorable, the higher direct-drive gearing may be brought in action, and higher vehicle speeds are possible without a corresponding increase of engine revolutions.

For example, with the lower direct-driving gears in operation, an engine speed of 700 revolutions per minute would mean a car speed of approximately 20 miles per hour, whereas if the high direct-drive gears are used the car will travel approximately 30 miles per hour, with no increase in engine speed. This increase in car speed without a corresponding increase in crank-shaft revolutions means that there is a decrease in fuel consumption for a given mileage. A given quantity of gas is utilized to greater advantage and produces more actual power at the rear wheels than with the engine turning over more rapidly on the low gear ratio. Friction and wear of power plant and transmission gearing are also materially reduced, because the parts are operated more slowly. When a low gear ratio is employed a car will vibrate very much at high vehicle speeds on account of the great speed at which the motor is operating, while with the higher ratios there is comparative freedom from vibration, because the power plant is not operated at excessive speed.

Differential Locks.—Under some conditions it is undoubtedly a great advantage to be able to temporarily lock the differential of a truck against action. Whenever one wheel is so situated that it slips readily while the other is on ground affording good traction, the truck can generally be moved if the differential is locked. This condition is sometimes met when one wheel is in a mud hole or on a wet spot of pavement, and it is most acute in the winter when the streets and roadways are icy so that one wheel may get on ice and obtain practically no traction.

Differential locks have been known at least since 1903, when they were applied on one steam freight wagon built in this country and on an English steam lorry, but they have not been very extensively used on trucks so far.

Among the advantages which the differential lock offers may be mentioned that it frequently obviates the necessity of using chains, mud hooks, and similar devices, because when any vehicle is unable to obtain traction it is generally found that only one of the wheels is slipping. This advantage would be more apparent when a trailer was being used, because it is harder to get sufficient traction to draw a trailer. It would also be more important if wood block or metal tires were used. Of course it takes considerable time to put on chains and to remove them in order to get out of a difficult position, while

if the chains are left on they unnecessarily consume power, and, moreover, they wear out quite rapidly so as to cause considerable expense.

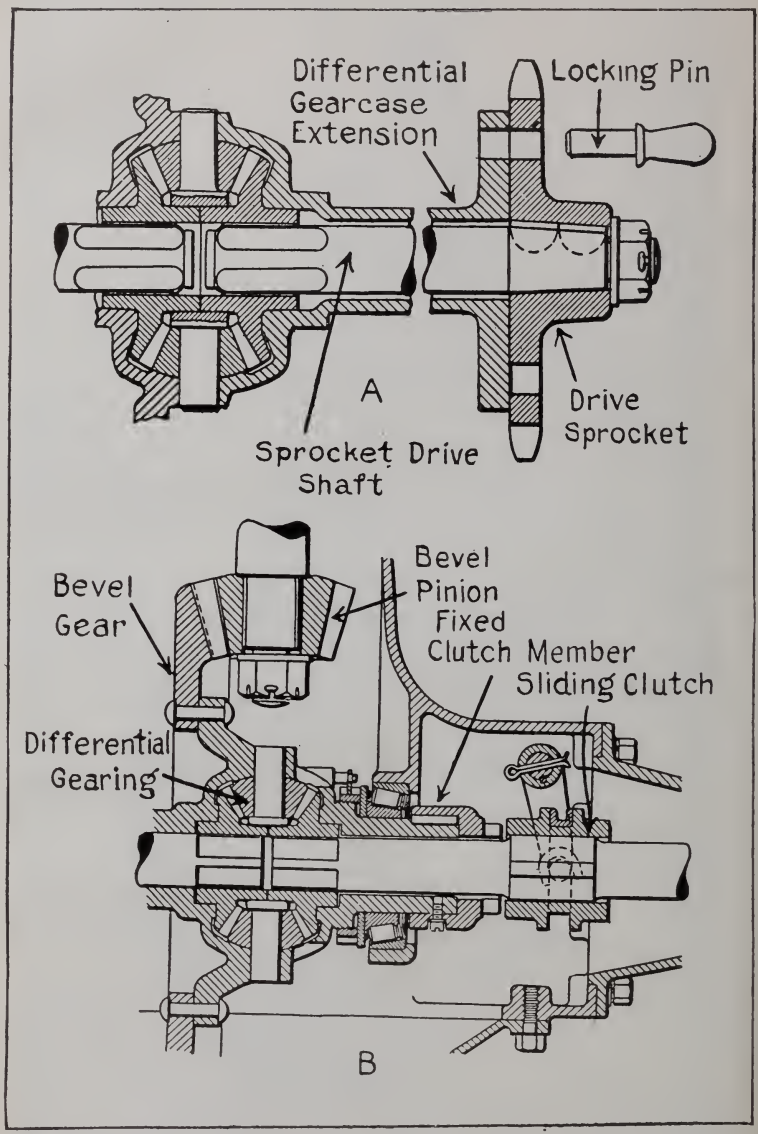


Fig. 596.—Outlining Two Practical Methods of Locking Differential Gear.

Also, in case of breakage of the chain or other driving members, it might be possible to complete a trip before repairs were necessary.

The chief disadvantages of the differential lock are as follows: First, added expense and complication due directly to its application, and also to the necessity of providing additional strength in the differential shafts, differential, and other driving parts. Second, the troubles which follow carelessness of the driver in leaving the differential locked after the difficulty has been passed. Of course continued driving with the differential locked causes unnecessary strains on all the driving members between the differential and the tires, and considerable additional wear to the tires in case there are corners or curves in the route traveled. It is also easy to see that where the traction is exceptionally good and a curve is encountered, immense stresses are imposed upon the differential, and this is probably the main reason why the differential lock was abandoned by some makers of trucks who formerly used it.

Two forms of differential lock are shown in Fig. 596. That depicted at A is the simplest form, inasmuch as it is merely necessary to lock the drive sprocket to the differential gear-case extension by inserting a locking pin through holes in sprocket and a flange at the end of the differential case. The other form, outlined at B, operates in a similar manner, except that the differential case is locked to one of the shafts to which the driving sprockets are attached by a sliding jaw-clutch member, as indicated. Either of the locks described will make the entire differential assembly revolve as a unit.

Axles Employing Double Reduction Gearing.—The simplest form of axle in which two gear reductions are necessary is the stationary or dead axle, but it must be used with the jack-shaft combination previously described. There is one gear reduction by means of bevel driving gearing in the countershaft assembly, and the ratio between the driving sprockets and the driven members attached to the wheel may be altered so a wide range of speed may be obtained. The use of a separate countershaft assembly is favored by the majority of builders of motor cars who find it necessary to use two speed reductions in the driving gearing, and one of the objections which has been advanced against the use of exposed driving chains has been overcome in many designs by the use of oil-tight chain cases that protect both chains and sprockets from grit and dirt and insure efficient operation because the chains operate in an oil bath.

If a driving chain is kept properly adjusted and remains clean and well oiled its efficiency will be very high, and chain cases are very desirable attachments to attain these ends. The usual form of chain case is depicted at Fig. 597. In this construction the case proper is composed of an aluminum casting which is also utilized as

a distance member to maintain a fixed relation between the front sprocket and that on the driving wheel. When the cover is in place the assembly is oil-tight and the chain and sprockets always receive adequate lubrication, which tends to greater endurance and maintenance of efficiency.

Some engineers do not favor the chain-driving method, and when a double speed reduction is necessary between the motor and the driving wheels it is incorporated directly in the rear-axle structure. A combination axle of this type, known as the "Torbensen," is depicted at Fig. 569, B. This is in reality a combination of the live and dead axle forms and has been designed specifically for application in

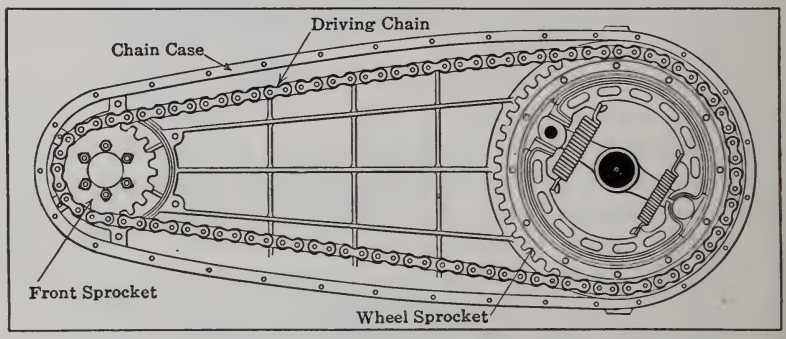


Fig. 597.—Method of Enclosing Driving Chain in Oil-Tight Casing to Secure Efficient Driving and Long Life to Mechanism.

motor-truck work. The differential gear is carried in the casing attached to the back of the fixed axle and receives power from the engine through the drive shaft and a pair of bevel gears. The wheels are mounted directly on the ends of the fixed axle and are driven from the differential gear by means of axles extending therefrom and carrying driving pinions of the spur type which mesh with internal gears attached to the wheels. It will be evident that one reduction of speed is obtained at the bevel gearing, and this would be further reduced by the difference in ratios between the spur-driving pinions and the internal gears carried by the wheels.

The live-axle form shown at Fig. 598 is that used on some of the Peugeot (French) cars and also uses bevel and spur reduction gears. In this case, however, but one spur gear is used to drive both wheels, this being attached directly to the differential gear case, and the wheels are turned by live floating axles. The first speed reduction is by means of the bevel gears, one of which is driven by the motor, the

other being attached to the countershaft, which also carries the small spur-driving pinion, which meshes with the large gear on the differential case. The efficiency of either of these axles will be about the same as that of the combination countershaft and side-chain drives, but those who favor the latter construction advance the argument that combining a double reduction on the axle makes for greater unsprung weight than is desirable, whereas carrying the countershaft on the frame makes it possible to support it on springs, just as the greater part of the power-generating and transmission mechanism is.

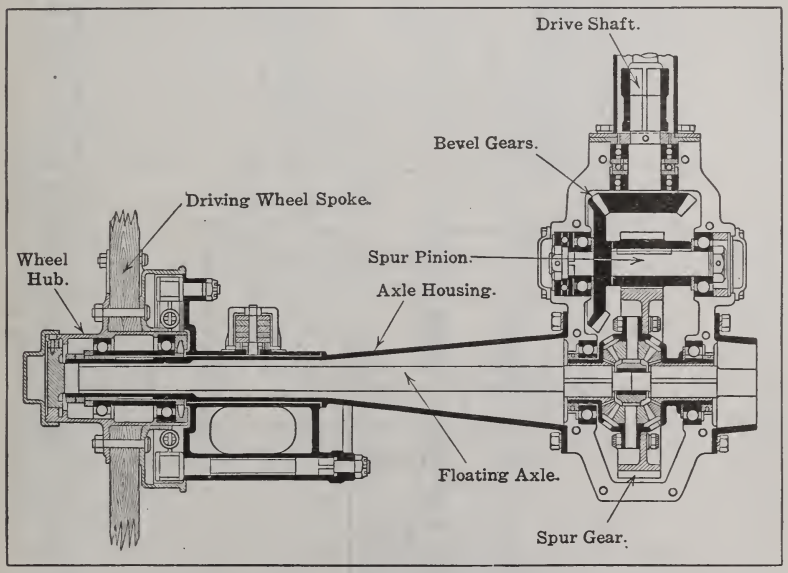


Fig. 598.—Peugeot (French) Live Rear Axle for Trucks, with Combined Bevel and Spur-Gear Final Drive.

Single-Chain Drive.—While the single-chain drive is used very seldom at the present time in large-size automobiles, it is being adopted to some extent on the lighter vehicles of the cyclecar type. The chassis at Fig. 599 shows clearly a modern application of the one-chain system when employed in connection with friction-drive gearing. The power plant is located at the front end of a subframe member and drives a friction driving disc located approximately at the central point of the frame by a suitable drive shaft. The driven friction wheel, which is a metal member provided with a rim of strawboard fiber, is adapted to slide laterally on a cross-shaft carried by the subframe member. One end of the cross-shaft extends outside

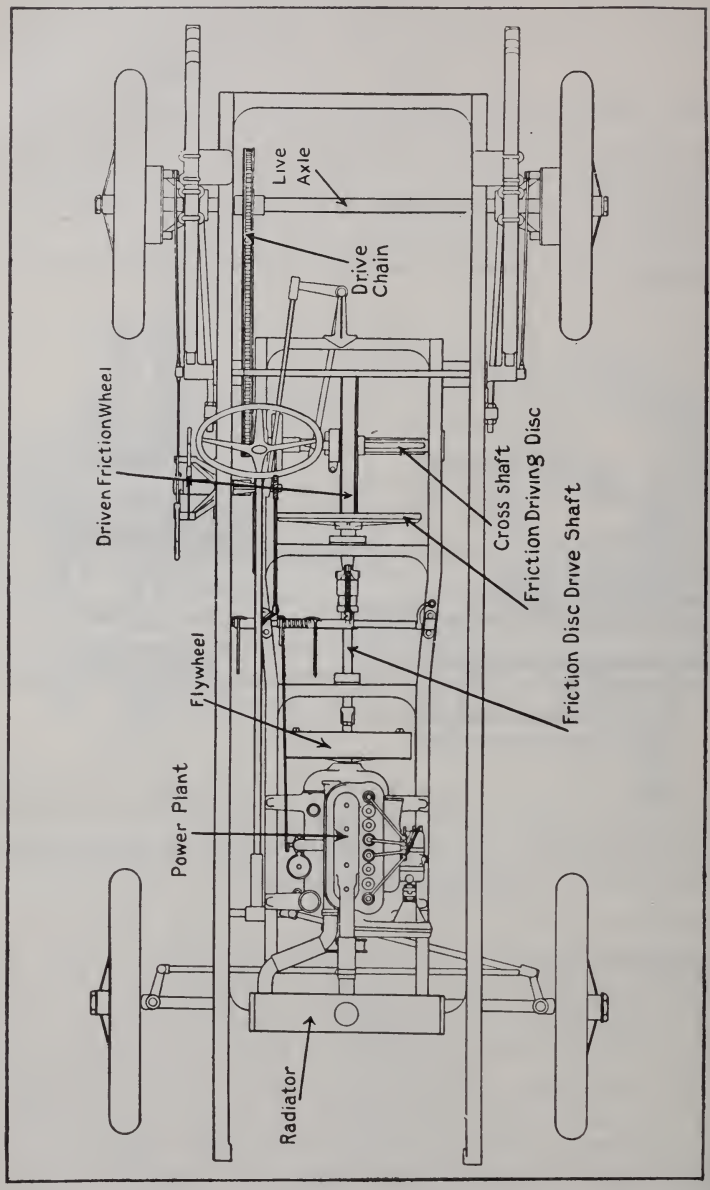


Fig. 599.—Plan View of the Pilot (English) Light Car Chassis Utilizing Friction Disc Change-Speed Gearing and Single Chain Drive to Live Rear Axle.

of the subframe member and carries a sprocket. The drive from this to a larger sprocket on the live rear axle is by a roller chain. The axle construction differs somewhat from that generally employed, inasmuch as the entire axle revolves in suitable anti-friction bearing boxes attached to the rear springs.

Four-Wheel Drive and Steer System.—Gasoline automobiles have been designed where the drive is through all four wheels which combine directive and tractive functions. A side elevation of the new Jeffery four-wheel drive motor truck with important parts depicted is clearly shown at Fig. 600. In this the power is obtained by the regular Rambler power plant driving through a dry disc clutch to a change-speed gear of special construction mounted on the chassis frame about midway between the front and rear axles. One drive shaft extends from the front end to the front axle, while a similar member transmits power to the rear axle, which is a duplicate of that used at the front of the car.

The special form of gear box necessary is outlined at Fig. 601. In this the drive is through gearing at all speeds, there being no direct drive clutch, as is true of conventional gear sets. The transmission provides four speeds forward and a reverse and in addition to the usual countershaft carried below the main shaft, a quill is mounted below this which carries a differential gear. From this differential two drive shafts provided with universal joints transmit the power to two auxiliary differentials located on the front and rear axles respectively. The differentials on the axles in turn drive the wheels and as the wheels are movable to steer the vehicle, as well as rotatable to drive it, it is apparent that the final drive shafts which transmit power to the wheels must have universal joints to compensate for wheel movement when set at an angle to direct the vehicle.

One of the universal joints employed at the wheels is shown at Fig. 602. The universal joint is a regular double yoke and cross type enclosed in a housing that protects it from the dirt and grit and which permits of considerable movement of the drive shaft without allowing the lubricant with which the universal joint is packed to escape. One end of the universal joint is attached to the drive shaft which runs to the differential on the axle, while the other yoke drives a spur pinion which is well supported by a taper roller bearing placed at each side. This spur drive pinion engages with an internal spur gear carried within the body of the wheel and applies the power near the wheel rim, thereby gaining the greatest driving leverage possible. The internal gear of the wheel and the pinion driving it are well housed

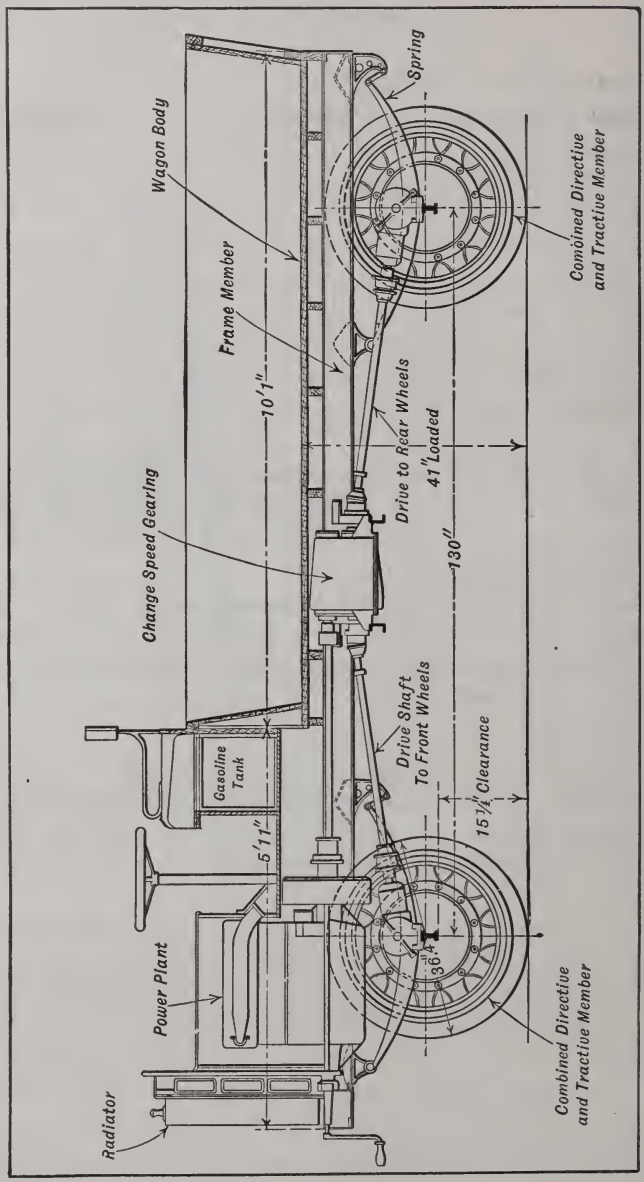


Fig. 600.—Side Elevation of the Jeffery Four-Wheel Drive Truck, Showing Method of Drive from the Change-Speed Gearing to the Axles.

to exclude grit and retain lubricant, and this housing at the same times serves as a brake drum.

The wheels, one of which is shown at Fig. 602, are interchangeable. The two drive axles with their universals are duplicates of each other and the three differential gears, consisting of that in the gear box and those on the axles, are all alike. The differential is a special Wayne type, which differs from the common construction in that it automatically drives the wheel which has the greatest resistance and which has traction, and this feature, coupled with the use of four driving wheels, makes it possible to propel the truck if any one

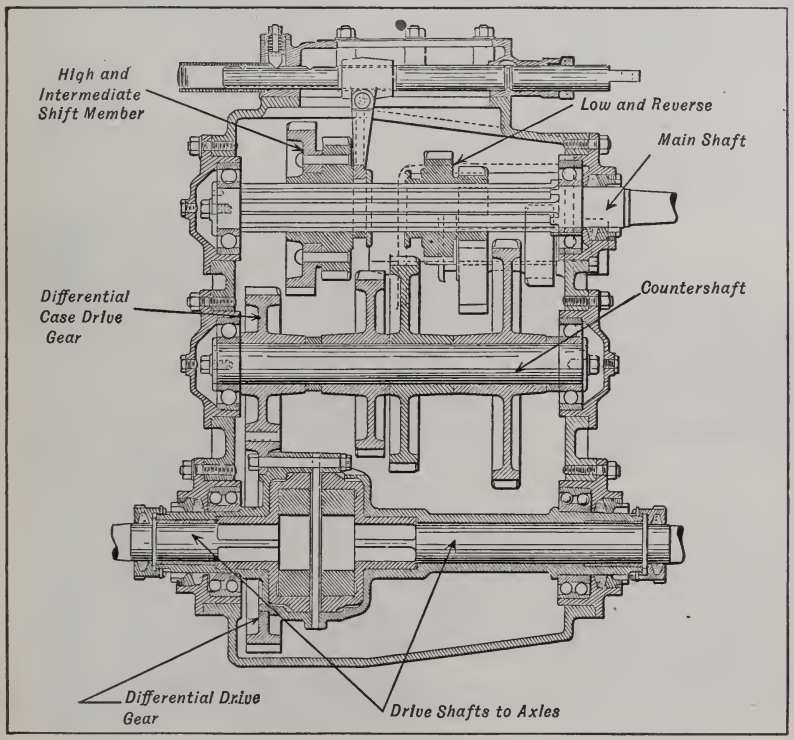


Fig. 601.—Details of Special Gearset Used on Jeffery Four-Wheel Drive Truck.

of the four wheels has traction. It is claimed that while the truck has 120 inches wheel base, it will turn in a circle of twenty-two feet radius, which is accomplished by the four-wheel steering feature. There are four ample brakes, one on each wheel, and it is claimed that either set of two brakes is sufficient to hold the loaded truck

on a 30% grade. The wheel revolves on taper roller bearings carried by the wheel spindle. The steering knuckle is a special form of the inverted Elliot type, and not only carries the wheel spindle, but the frame supporting the spur driving pinion as well. The loaded front axle is supported by a taper roller bearing at the lower end of the steering knuckle which makes it possible to turn the wheel with minimum exertion on the part of the operator. When the wheel

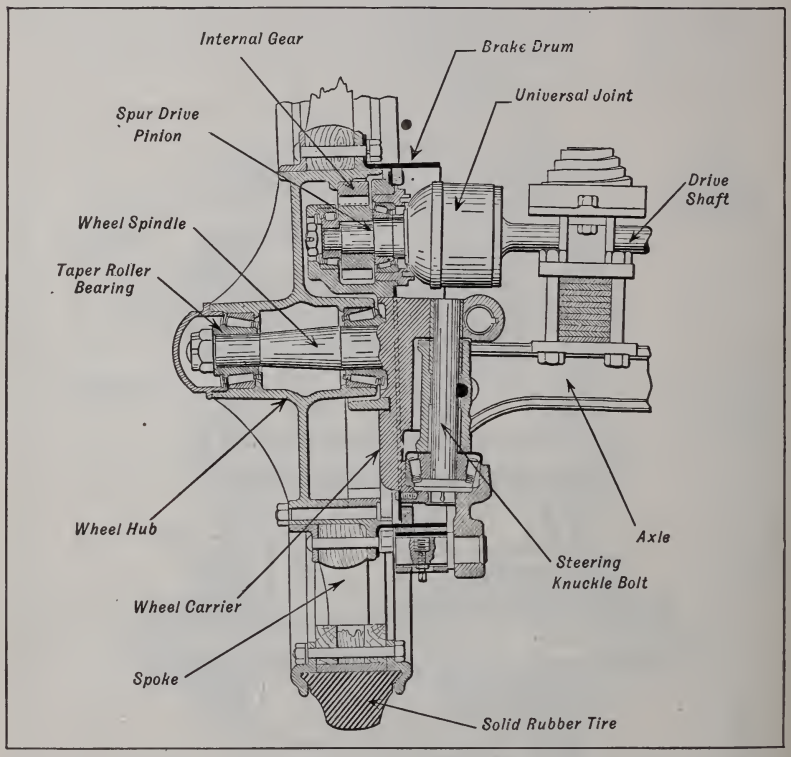


Fig. 602.—Sectional View of Wheel of the Jeffery Truck, Showing Method of Drive by Internal Spur Gearing.

is moved by the steering knuckle the frame carrying the spur drive pinion turns as well, but owing to the universal joint the drive is not interrupted and the wheels are all driven regardless of whether they are in a straight-ahead position or at an angle to steer the car. Other vehicles have been evolved and applied as tractors for fire department service where the drive is through the front wheels only, these members being very similar in construction to the form described.

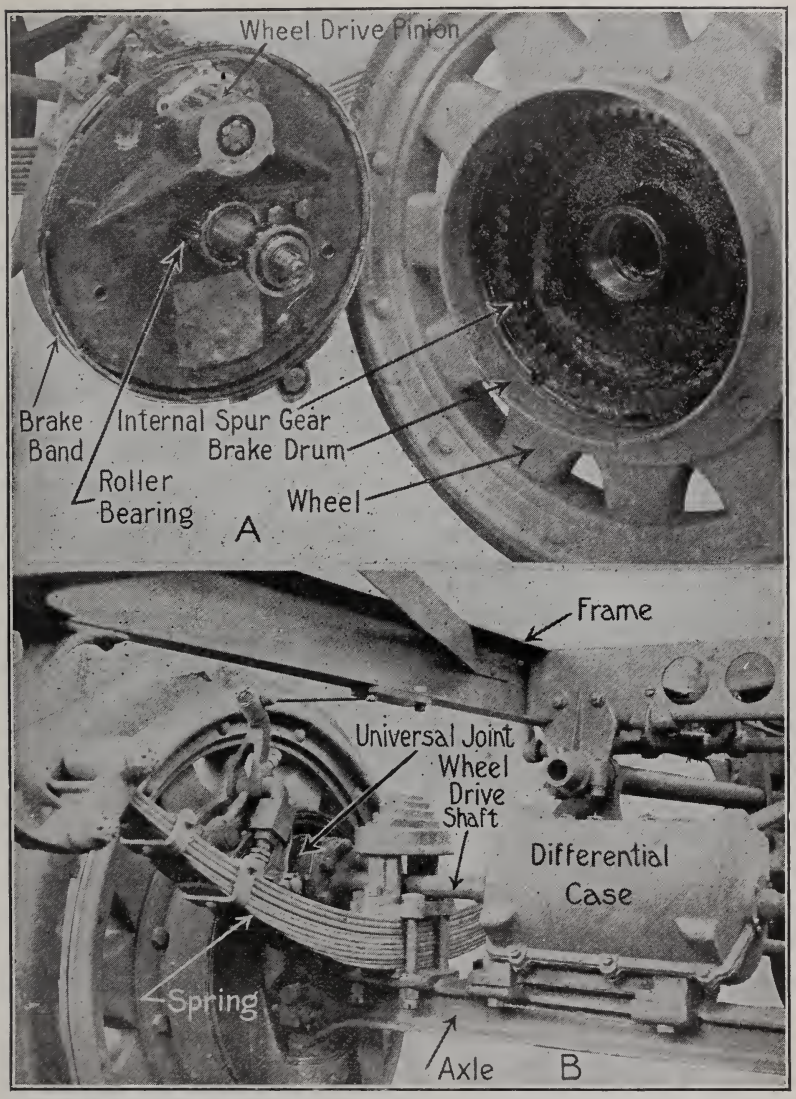


Fig. 603.—Details of the Jeffery Four-Wheel Drive Construction. A—Axle End with Wheel Removed, to Show Driving Pinion and Driven Gear. B—Arrangement of Differential Case and Universal Joints on Drive Axle.

Front Wheel Drive System.—In some forms of vehicles the front wheels only are employed for driving even when the power is derived from a gasoline engine and transmitted to the wheels by some form of mechanical transmission instead of by a more flexible medium,

such as electric current. The front end of a truck of this nature is clearly outlined at Fig. 604, and this is really a tractor that becomes an integral part of the vehicle to which it is joined. The power is derived from the conventional form of four-cylinder water-cooled motor which delivers its power to a gearset combined with a countershaft which is shown in the plan view at Fig. 604, A. As far as the

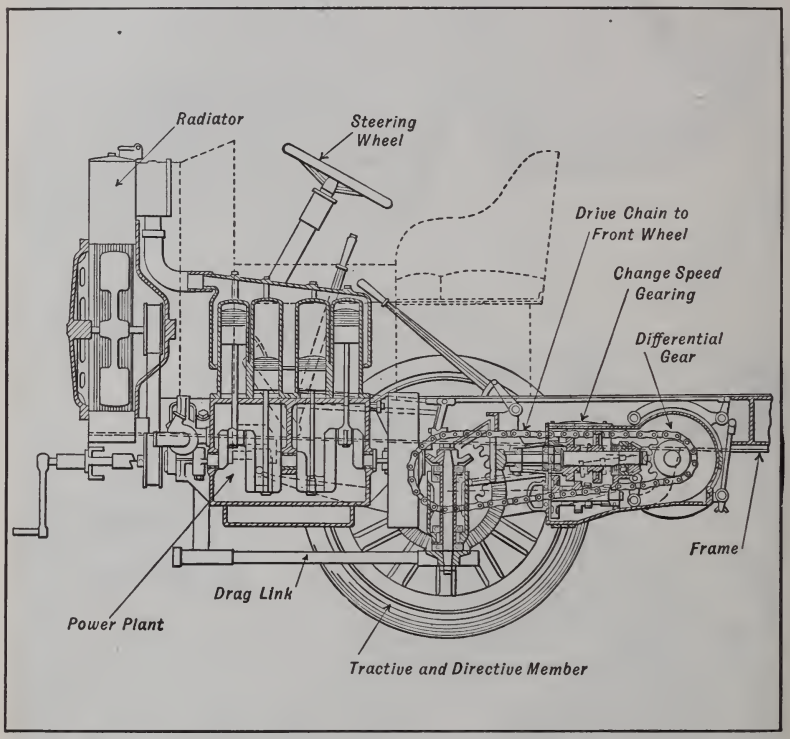


Fig. 604.—Sectional View of Front Portion of Foreign Motor Truck Chassis Employing Front-Wheel Drive.

location of the power plant and gearset goes and the method of coupling these members together, the construction follows conventional practice. The difference is that instead of the drive being from the sprockets at the end of the countershaft member to the rear wheels, the chains go to the front end of the car and drive the front wheels, which form part of an axle of peculiar design.

One end of the distinctive axle construction is shown at Fig. 605, and in this the wheels are mounted in such a way that the steering is not interfered with while the power may be transmitted efficiently, re-

gardless of the degree of inclination of the wheel. The axle consists of a substantial forged member having the wheel carrier mounted in a knuckle of the Mercedes type. The knuckle spindle bolt is in reality a driving shaft having bevel pinions at each end. The upper of these bevel pinions is in mesh with another member of the same size carried by a bearing member attached to the axle which serves

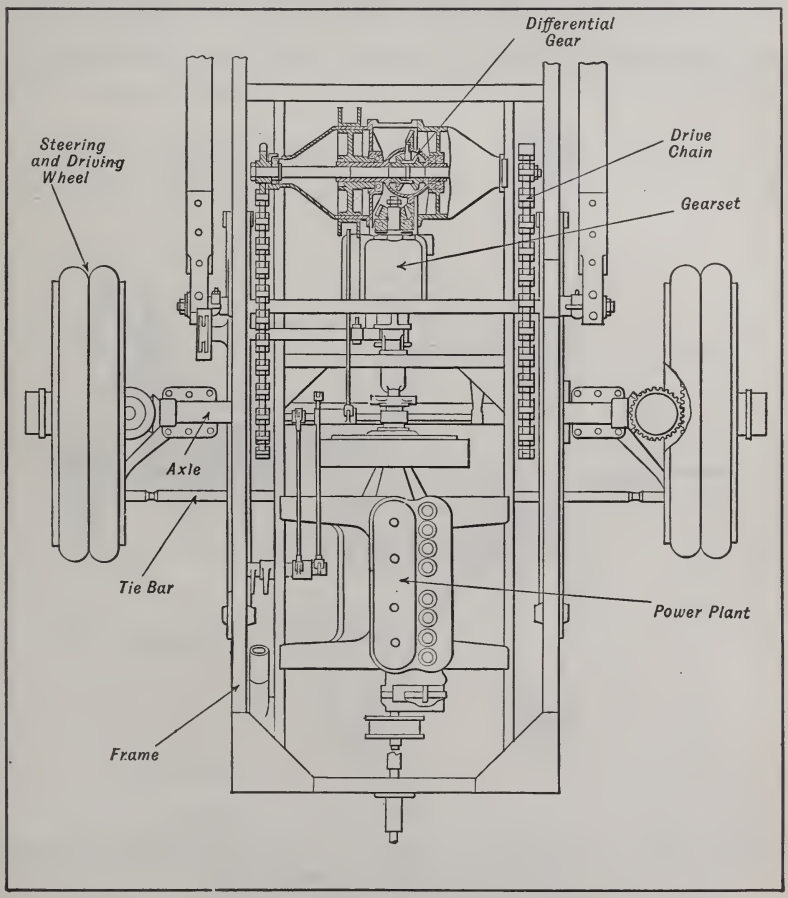


Fig. 604A.—Plan View of Front-Wheel Drive Truck, Showing Location of Power Plant, Countershaft Assembly and Other Parts.

to support a driving shaft which joins the sprocket at one end to the bevel gear at the other. The wheel is driven by a bevel gear which is rigidly secured to the wheel hub, and which meshes with the bevel pinion at the lower end of the intermediate drive shaft that forms the steering knuckle bolt. The power is thus transmitted from the

sprocket, rigidly mounted on the axle through the medium of the bevel gearing and intermediate shaft to the driving member attached to the wheel hub. It will thus be apparent that the bevel gears on the intermediate shaft transform the rotation of the horizontal shaft to an equivalent rotary movement of the vertical intermediate drive shaft.

With the gear construction described it will be possible to transmit power without interruption and with no more loss when the wheel

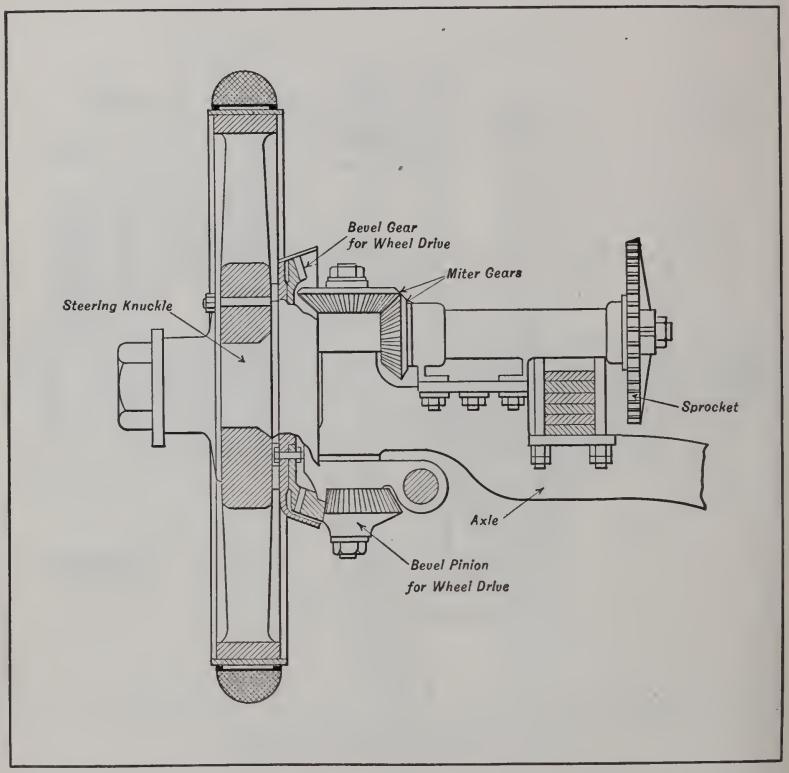


Fig. 605.—How Power May Be Transmitted to a Combined Driving and Steering Wheel Without Using Universal Joints.

carrying member is at an angle than when it is in the straight-ahead position. When the steering knuckle is turned by the arm bolted to it, which is controlled by the usual form of tie-bar and drag-link, as in conventional constructions, the driving gears do not vary their relationship because the vertical intermediate drive shaft is mounted in such a way that it is independent of the movement of the wheel carrying member. It is claimed that the opportunity for power loss is con-

siderably less with this system when the wheels are placed at an angle for steering than is the case when the drive is through universal joints. The advantage of driving a vehicle by the front wheels is that liability of skidding is considerably reduced, and that the wheels serve to pull instead of push the vehicle. The front wheel drive system may be applied to chassis forms where it would be extremely difficult to use the rear wheel mechanical drive on account of having a very low carrying platform, as would be the case in vehicles designed to carry bulky and heavy merchandise. The front wheel drive system permits one to attach a low gear directly to the tractor frame and obtain in this way an efficient and effective motor vehicle for carrying heavy loads.

Utility of Motor-Car Brakes.—One of the most important of the components of the motor-car controlling system is usually carried

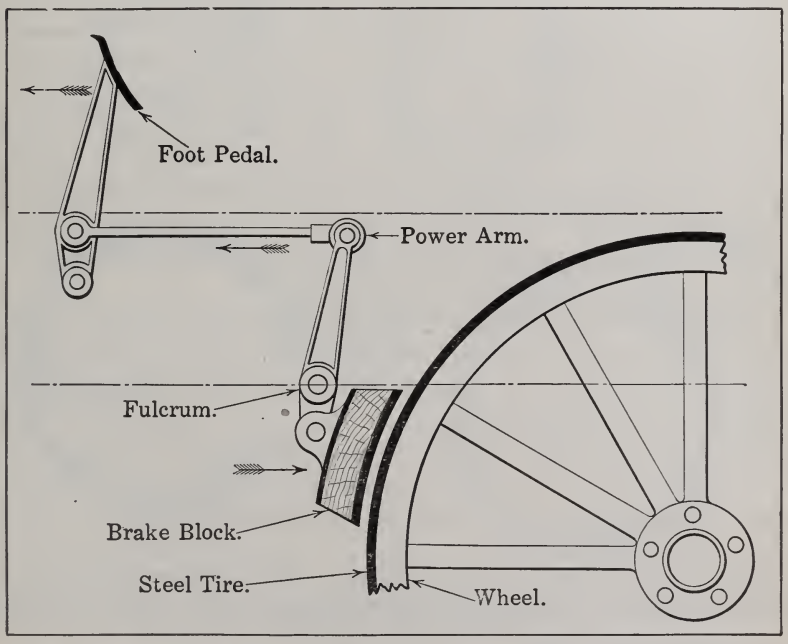


Fig. 606.—Simple Form of Shoe Brake Used on Horse-Drawn Vehicles.

with and forms part of the rear construction, this being the braking means which is utilized to bring the vehicle to a stop when it is desired to arrest forward or backward motion. It will be evident that in a horse-drawn vehicle the animal drawing it can be used as a brake, but that in any form of self-propelling conveyance it is essen-

tial that some means of stopping be included in the construction. Even if the clutch was operated in such a way that the motor was disconnected from the driving wheels the conveyance would continue to move because it had acquired a certain momentum which would increase in value with the weight of the car and the speed at which it was driven.

On some forms of horse-drawn vehicles, particularly those of large capacity, some form of supplemental retarding member must be provided to assist the braking effect of the animal, which may not be sufficient to stop the vehicle when descending grades or when operated with some degree of speed on the level.

A simple form of shoe brake, such as used on a horse-drawn conveyance, is shown at Fig. 606. This consists of a brake block of wood or other material carried at the end of a fulcrumed lever, which in turn is joined to a pedal by a connecting link. When it is desired to bring the vehicle to a stop, a moderate degree of pressure at the foot pedal will bring the brake block in contact with the periphery of the wheel, and but a very moderate amount of pressure suffices to lock the wheel in a positive manner. This construction could not be very well applied to motor vehicles, because the action of the shoe against the rubber tire would be apt to produce rapid depreciation of these costly elements. For this reason the brakes of automobiles are especially designed so that they will wear instead of producing deterioration of the points to which they are applied.

Forms of Motor-Car Brakes.—The braking members generally used on automobiles may be divided into two classes, each of these depending upon the property of frictional adhesion between substances held together by considerable pressure. The usual construction is to attach a drum to some portion of the change-speed mechanism, to the differential gear or to the wheels themselves. At the present time most engineers favor applying the brakes directly to the driving wheels, and pressed-steel drums are usually fastened to these members, against which the brake acts. The retarding effect may be obtained either by an internal expanding shoe brake or by an external contracting band brake.

The principal forms are outlined at Fig. 607. That at A consists of an internal expanding member consisting of two shoes which conform to the arc of the brake drums. These are spread apart and brought into forcible contact with the drums by means of a simple lever and toggle linkage. Another method of expanding the internal band so it will engage the inner surface of the drum is outlined at B. In this the toggle linkage is replaced by a cam which is

rocked by the lever to force the brake shoes apart when it is moved in one direction, and permits them to close up and release the drum when it is rocked the other way.

The brake shown at C consists of a steel band which is lined with some friction material possessing considerable resistance to heat, such as asbestos-wire fabric. The band is attached to a double-bell crank lever in such a way that it will be brought into forcible engagement with the external surface of the drum if the end of the lever is moved in the direction of the arrow. Another form of band brake is depicted at Fig. 607, D. This is a much more efficient form than

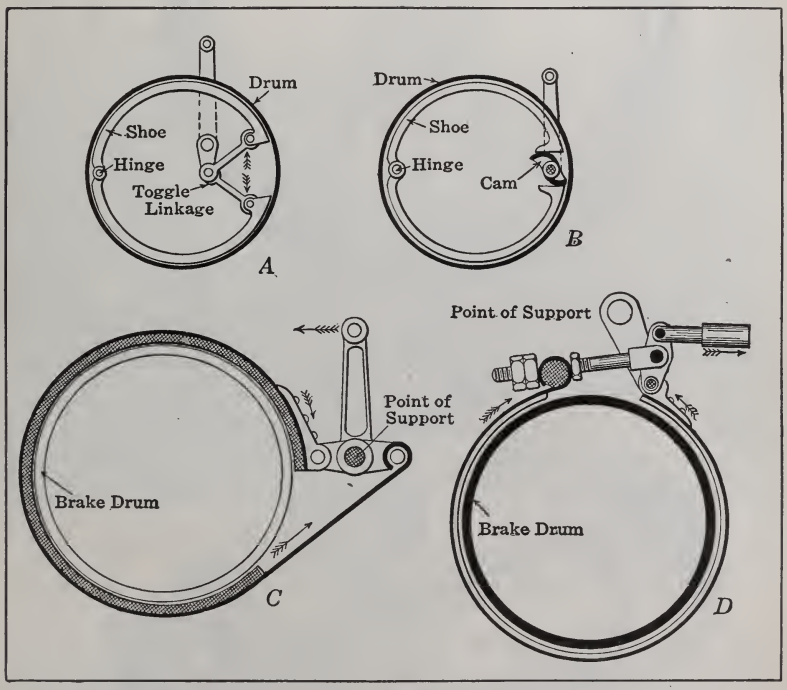


Fig. 607.—Diagram Showing Simplified Internal and External Band Brakes Used on Motor-Car Wheels.

that outlined at C and it has great holding power. The band may be adjusted as the friction material wears, and thus the brake may be always kept in perfect adjustment. Two typical brake assemblies are shown at Fig. 608. In that shown at A, two sets of internal brakes are used; in the group outlined at B, the usual combination of inside and outside brakes is shown. The photographic reproduction at

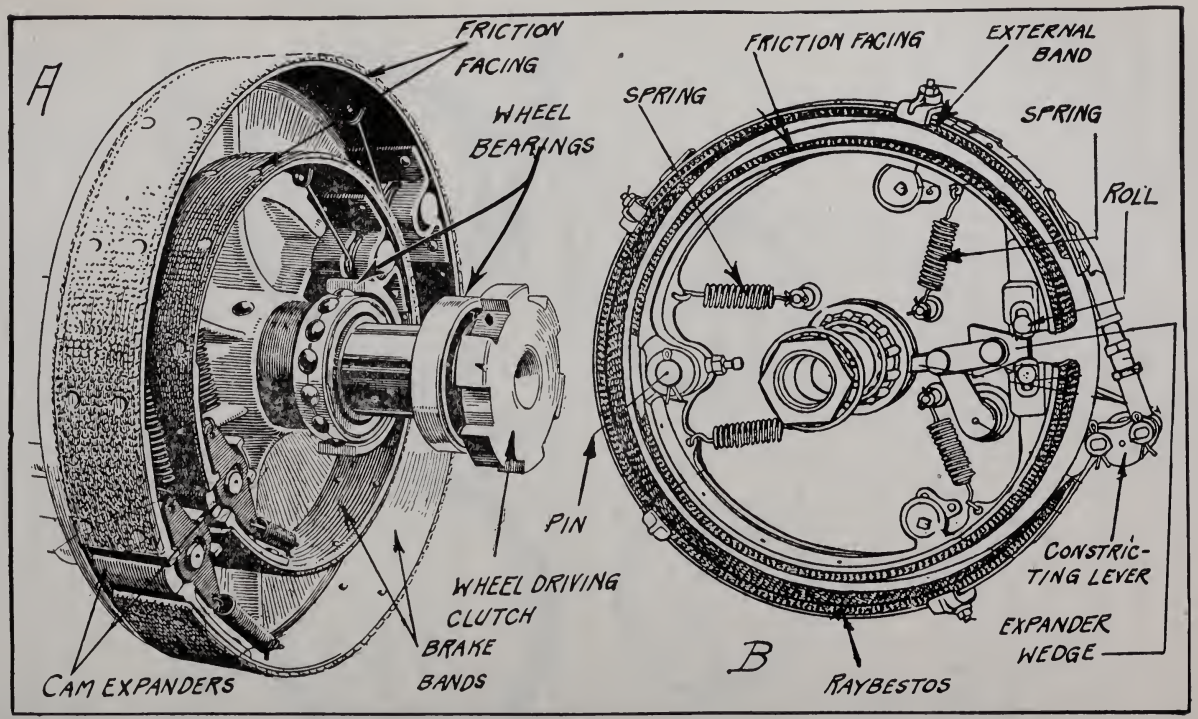


Fig. 608.—Illustrating the Construction of Practical Motor Car Brake Assembly. A—Two Internal Brakes. B—Internal and External Brake Combination.

Fig. 609 shows the brake assembly as it actually looks when the wheel is removed from the axle to gain access to the internal band.

The methods in which the brakes are usually mounted in automobiles are clearly shown at Fig. 610. At A two internal expanding bands are mounted inside of each brake drum, one pair of these being connected to a pedal and used as a service brake, while the other is attached to a hand lever and is depended upon as an emergency or auxiliary braking member. The cast shoes are hinged at their lower end and are faced with friction material. They are spread by means of cam expanders, and when the shoes are spread apart they engage the inner portion of the brake drums with considerable force and

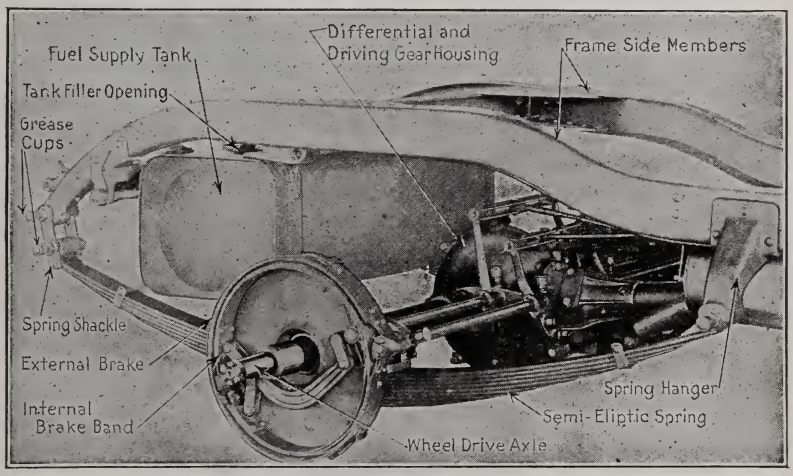


Fig. 609.—View of Axle End of Typical Light Car with Wheel Removed, Showing Internal and External Band Brakes.

retard its motion. The brakes shown at B are similar in operation to those outlined at A, and the assembly is presented merely to show the relation of the brake shoes to the axle on which they are mounted. A combination of internal expanding and external constricting brakes is shown at Fig. 610, C. This is a very common method of construction and is found on many cars. The inner brakes are usually depended on for emergency service, while the outer brakes, which may be more easily applied, are used for braking under ordinary conditions. A common brake drum serves both brakes, as the expanding member will engage the inner periphery, while the external band will contract around the outer face of the drum. The method of installing the brake on a typical motor-car rear construction is also shown

at Fig. 611. The usual methods of adjusting an external constricting brake band and its actuating mechanism is clearly shown in Fig. 612. The adjustment provided in adjusting the hand operated propeller shaft brake of the King Eight car is clearly outlined in Fig. 613.

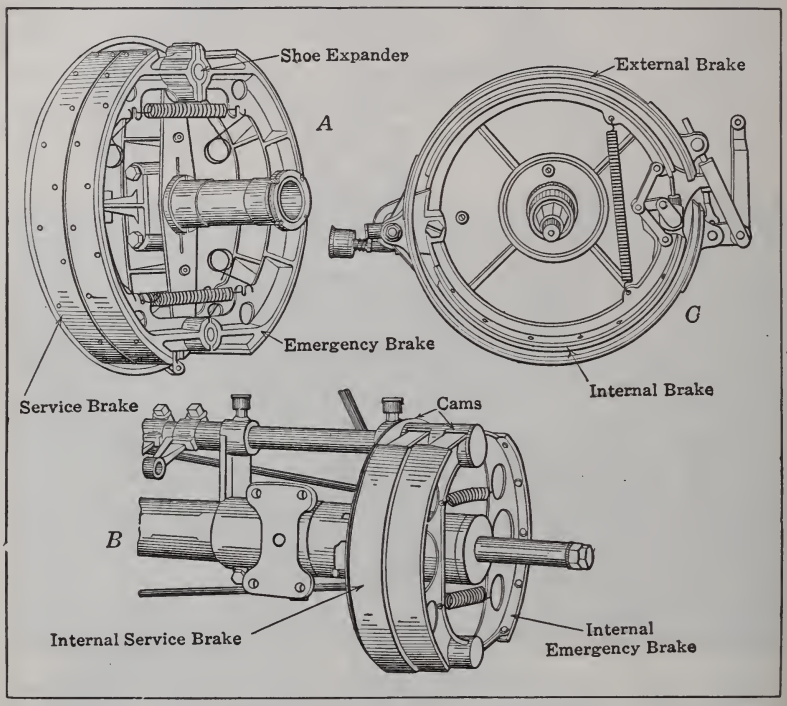


Fig. 610.—Typical Automobile Brake Forms. A—Two Internal Expanding Brake Shoes. B—Another Double Expanding Internal Type. C—External and Internal Brake Combination, the Conventional Construction.

The braking members in automobiles have been mounted on both front and rear wheels, on the jack shaft of a double-chain driven car, or on the propeller shaft of a bevel- or worm-gear drive arrangement. Brakes are not always of the internal or external band form, some designers having used other combinations to obtain the same results. The multiple-disk brake employed on the Metz car is shown at Fig. 614. In this a series of disks is attached to and revolves with the wheel hub, while another group is fixed to the stationary axle. Pressure is brought to bear against one of the fixed disks by means of pressure pins passing through one of the wheel-supporting cones,

and this is in turn communicated by each disk to its neighbor. The same object is attained as in a multiple-disk clutch and a larger amount of braking surface is obtained by using a comparatively large number of small diameter disks instead of two larger members, which might not have as much effective surface. Multiple-disk brakes have been used to some extent on foreign cars, but this is the only instance to the writer's knowledge where they have been applied on a domestic product.

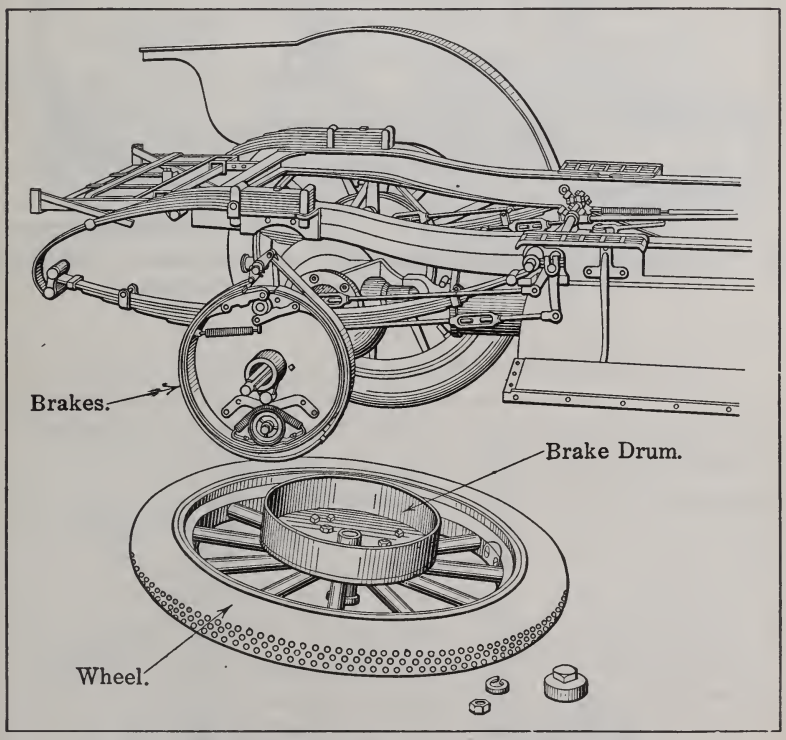


Fig. 611.—Typical Automobile Brake Assembly Shown by Removing Rear Wheel from Axle End. Note Application of Brake Drum to Wheel Hub and Internal and External Bands on the End of the Axle.

Side slipping or skidding is one of the dangers of motoring on highways which may have a slippery surface. If one turns the corner of a wet asphalt, macadam, or clay pavement a certain amount of side-slipping action will be evident, and if the brake be applied at this time this skidding tendency will be accentuated. The skidding tendency of a self-propelled vehicle is most noticeable when the brakes

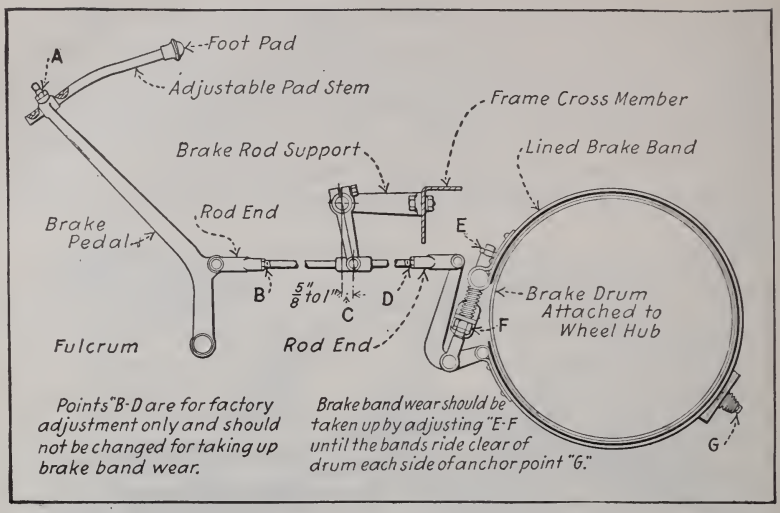


Fig. 612.—Showing All Parts of Typical Foot-Actuated External Constricting Band Brake, with Points for Adjustment Outlined.

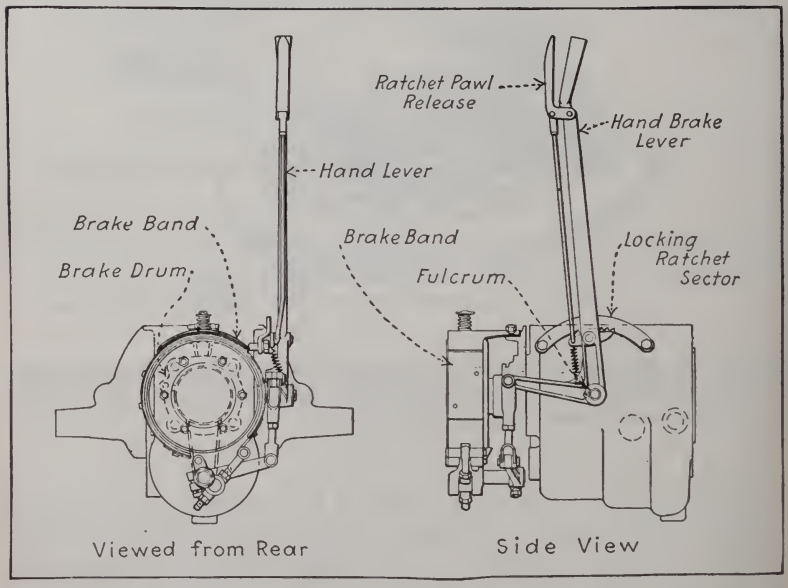


Fig. 613.—Diagrams Showing Construction of Hand-Actuated External Constricting Band Brake Acting on Drum Attached to Driving Shaft at Rear of Change-Speed Gear Box.

are applied suddenly to the rear wheels, and it is evident by a swinging movement at the rear end of the car which tends to bring the braking wheels around to the front in the direction in which the car is moving. Various means have been proposed to eliminate this side-slip action, and numerous forms of tire chains, studded tire treads or treads with knobs or other projections of rubber molded integral with them have been devised to minimize the skidding tendency.

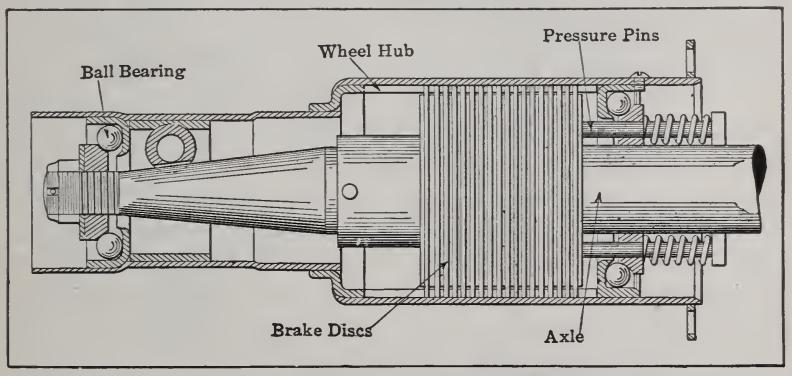


Fig. 614.—Rear Hub of Metz Car Showing Multiple Disc Brake.

Application of Front-Wheel Brakes.—A number of foreign engineers have applied brakes to the front wheels instead of the rear members to reduce the skidding action. It is claimed that the application of brakes to the steering members instead of the driving members will eliminate the skidding tendency, because the braking action would be on the wheels which were already at the front end and pointing in the direction in which the car was moving. There are a number of disadvantages which militate against the general adoption of front-wheel brakes, these being of a nature which makes them extremely difficult to surmount successfully.

In the first place, it is rather difficult to mount the brakes on the steering knuckles and operate them from a fixed portion of the car. Then, again, the usual front axle, as designed at the present time, is not adequate to resist the torsional stresses which obtain when the motion of the car is stopped by arresting the rotation of the front wheel, and some form of torque member would have to be provided to take care of this strain. This would mean considerable mechanical complication which is not necessary, as when the brakes are applied on the rear wheels one common member may be used to take both braking and driving torque stresses, and this member would

be needed, even if the brakes were applied to the front wheels, in order to take care of the driving torque.

If brakes are applied to all four wheels, some arrangement must be provided by which the front-wheel brakes could be applied first to do away with the tendency to skidding, while the rear brakes would

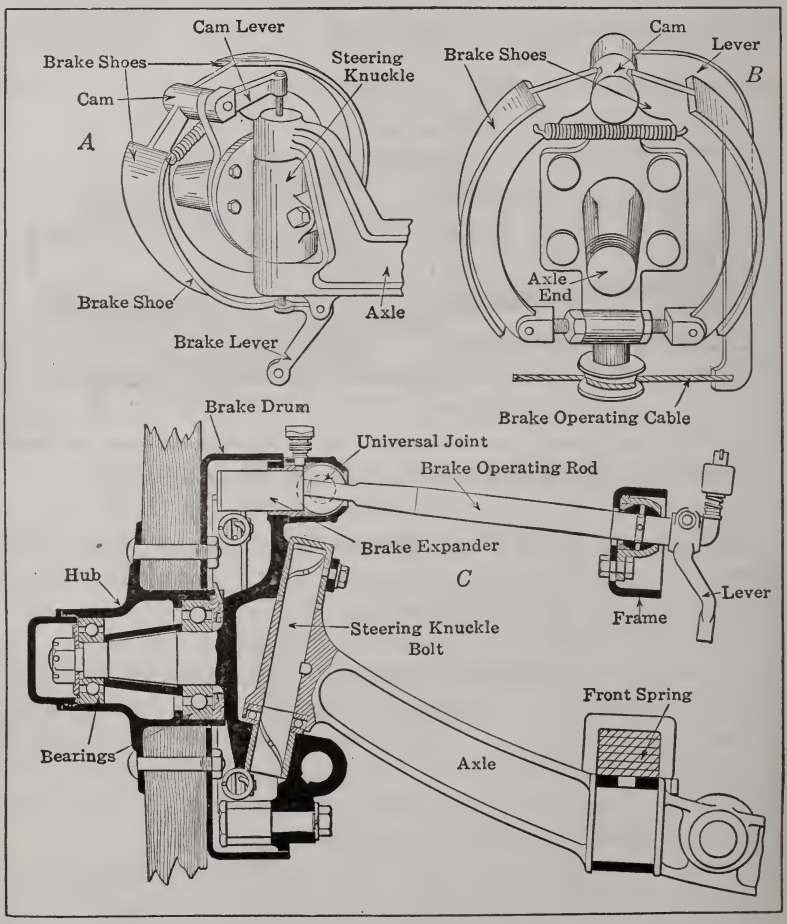


Fig. 615.—Types of Front Wheel Brakes that Have Been Used on British Automobiles Showing Novel and Ingenious Methods of Brake Actuation.

be called upon to add to the braking effort already provided. The principal difficulty in fitting up front-wheel brakes is in the arrangement of the operating parts. These must be attached to the vehicle frame at one end, and must also be supported on the axle at the other, and as the axle is free to move relative to the frame it will

be evident that the problem of providing a flexible and positive braking connection will be made more difficult of solution when one considers that some provision must be made for the angularity of the wheels when turning corners. This would mean that the operating mechanism on one side must shorten, while that at the other side must lengthen in some way to compensate for the difference in angularity of the brake drums. Whatever form of brake actuation is used it must be designed so these members will be applied with equal force and at the same time in each wheel. This problem is not a difficult one when the brakes are attached to the rear axle, but it is not easy to operate front-wheel brakes in a positive manner and insure that each will be applied with equal force.

Various forms of front-wheel brakes are shown at Fig. 615. The design shown at A is a cam-expanded shoe which is mounted on an extension of the steering spindle. The cam is rocked by means of a lever attached to it, which is moved by a pin passing down through the steering-knuckle bolt and resting against the end of a bell-crank form of brake lever carried by the axle. When the brake lever is moved the movement of the end against which the pin rests is transmitted to the cam which spreads the shoe by means of the pin passing through the steering knuckle. Another form of cam-expanding brake is outlined at B. In this the cam is rocked by a lever which passes down to the bottom of the steering spindle, where it is coupled to the operating gear by means of a steel-wire cable passing around a roll at the end of the steering-knuckle bolt designed to give a certain degree of universal motion. The shoes are kept from rubbing against the inner face of the drum by a coil spring joining the upper extremities of the shoes to keep them in contact with the cam face. The brake shoes are supported at the bottom in adjustable yokes which may be moved out to compensate for wear of the brake-shoe surfaces.

The method outlined at C is that used in the Argyl (Scotch) motor car. In this form the brakes are operated directly from the frame side instead of by bell cranks or wire cables attached to the axle. The brake is a cam-expanded shoe type, the cam being moved by a brake-operating rod, extending from the frame-side member to the top of the fixed member employed to carry the brake band which forms part of the steering knuckle. The brake-operating rod is provided with a pair of double ball-and-socket universal joints and is operated by means of a small lever attached directly inside of the frame-side member.

Front-wheel brakes have not been used to any extent on stock

American motor cars, but they have been applied in quite a number of instances abroad. The advantages advanced by the English designers for this peculiar form of brake are chiefly centered around the factor of eliminating skidding and of being more accessible and easier to adjust than the rear-wheel brakes. Against these advantages one may advance the disadvantages of complicated operating mechanism, the possibility of unequal braking effort, and the interference with positive and correct steering should some one of the universal operating rods become stuck in such a way that it would not permit the wheel to turn as it should.

The Vacuum-Operated Brake.—No one familiar with current mechanical engineering practice will deny that the airbrake so widely

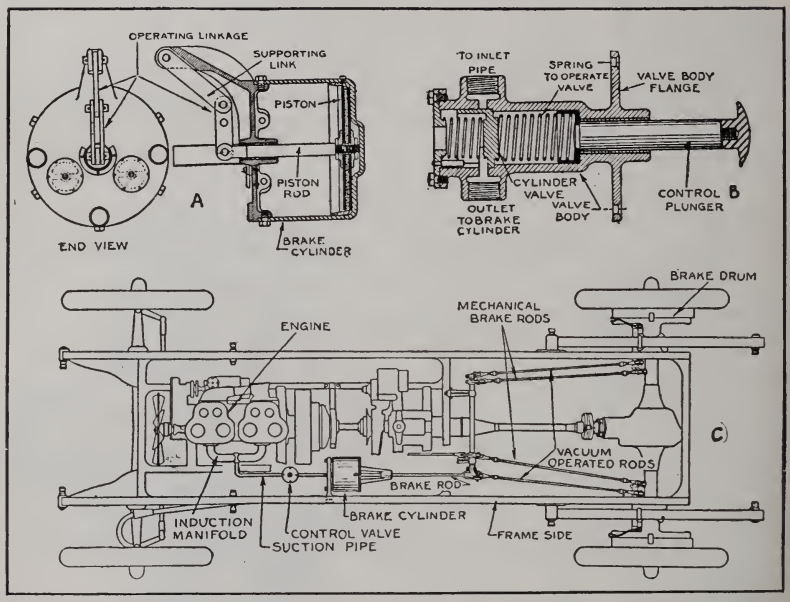


Fig. 616.—Diagrams Outlining Construction and Application of Vacuum Brake System. A—End and Sectional View of the Brake Cylinder. B—Sectional View of the Control Valve. C—How the Brake System is Installed in Automobile Chassis.

used in railway work is the best form for this purpose and one that makes it possible to control a heavy moving mass, with minimum exertion on the part of the operator. The idea of using an airbrake on automobiles is not new, as various modifications of the Westinghouse braking system have been designed and fitted to cars in an experimental way. A new form of brake actuated by vacuum or

engine suction and shown at Fig. 616 has been worked out that makes it easy to control the speed of the largest and heaviest automobile with very little exertion. As it is being marketed by an accessory manufacturer of national reputation after severe tests it is evident that this system of braking should be given some consideration. The idea of the brake operation is the using of suction prevailing in the intake manifold while the engine is running. While the reduction in pressure is but a few pounds per square inch, this may be converted to a useful force by using a piston of large area. The inventor states that a force of about ten pounds to the square inch is available as a rule, and as the diameter of the piston is seven inches and its effective stroke four inches, it will be evident that a considerable force for brake actuation is available at the piston-rod. This is joined to a system of reducing levers which reduces the travel of the brake-rod and multiplies the operating force considerably. The construction of the air-brake cylinder, the control valve, and the methods of installing the various units in the frame of a typical automobile are clearly outlined in illustrations at Fig. 616.

A control valve of a simple construction is interposed in the pipe line joining the intake manifold and the brake piston chamber. This valve may be operated either by hand or foot as is most convenient. The internal construction of the valve is such that the brake may be applied with different degrees of pressure. As the pull on the brake-rod is determined by the depression in the brake cylinder, any thing that will lessen or increase this depression will correspondingly alter the braking force. The valve does this automatically. When the control plunger is depressed, this compresses a spring which moves the cylinder valve and provides a passage between the suction pipe and the brake cylinder and also prevents the entrance of air. Just as soon as the pressure back of the valve is reduced, the pressure of the air on the other side forces it up against the spring, closes the suction passage and in this way the amount of vacuum in the brake cylinder is controlled by the degree of movement of the control plunger. The spring is of such strength that if the plunger is fully depressed the valve will not be opened by air pressure. As soon as the operating lever is released the valve cylinder moves back to the position shown in the drawing, cutting off the suction opening and providing a by-pass so that the outside air goes into the cylinder, releasing brake.

The cylinder construction is similar to that used in braking railroad trains. The cylinder is of pressed steel and the head is a steel casting. The weight is but twelve pounds. The simple steel piston uses a leather-cupped washer packing. As long as the engine is run-

ning, or rather turning over, whether the motion is produced by the explosion of gasoline in the cylinders or by the overrunning action of the rear wheels when descending a grade, which, of course, drives the engine through the axle driving gears and propeller shaft, a full application of the brakes is possible. The method of installation consists of connecting the brake cylinder to the intake manifold by a length of tubing in which the control valve is interposed. Instead of connecting the brake linkage to a foot pedal or hand lever, it is attached to a link operated by the piston-rod, which is clearly shown in the detailed drawing of the brake cylinder. It is said that sufficient power is obtained to slide the wheels even if the car is running at a speed of but one-half mile per hour. In tests this very slow speed was obtained by driving the car through the medium of the electric starting motor.

Knox Hydraulic Brakes.—A novel method of actuating the rear wheel brakes on the 1916 Knox tractor is shown at Fig. 617. Instead of the usual mechanical leverage the brakes are applied by hydraulic pressure. The hand lever works a pump plunger which forces oil into the cylinder of a brake actuating member carried on the radius rod. When the applying lever is worked back and forth, it acts as a pump-handle, and forces liquid into the braking cylinder. By having a difference in size between the pump plunger and that actuating the brake a great increase in power is obtained and the brakes may be applied with very little exertion. When it is desired to release the brakes, the lever is thrown way forward, which opens a bypass valve which allows the oil to flow back into the container, relieving the pressure against the brake actuating plunger. This is then drawn back by the brake release spring and forces the liquid out of the braking cylinder. The brakes of the usual friction band form.

Ball and Roller Bearings.—The plain bearings which have received wide application in all forms of machinery are not as popular in automobile construction, because in the self-propelling mechanism it is important that the power generated by the motor should be delivered to the traction members with as little loss as possible. Plain bearings consume considerably more power than do the anti-friction types, and because of this, the latter are employed generally throughout the power transmission system and wheels of all types of cars, while they have replaced the plain bearings used on motor crankshafts to some extent as well. Anti-friction bearings are those in which rolling friction is substituted for sliding friction and consume from one-fourth to one-eighth as much power as plain bearing forms of equivalent capacity.

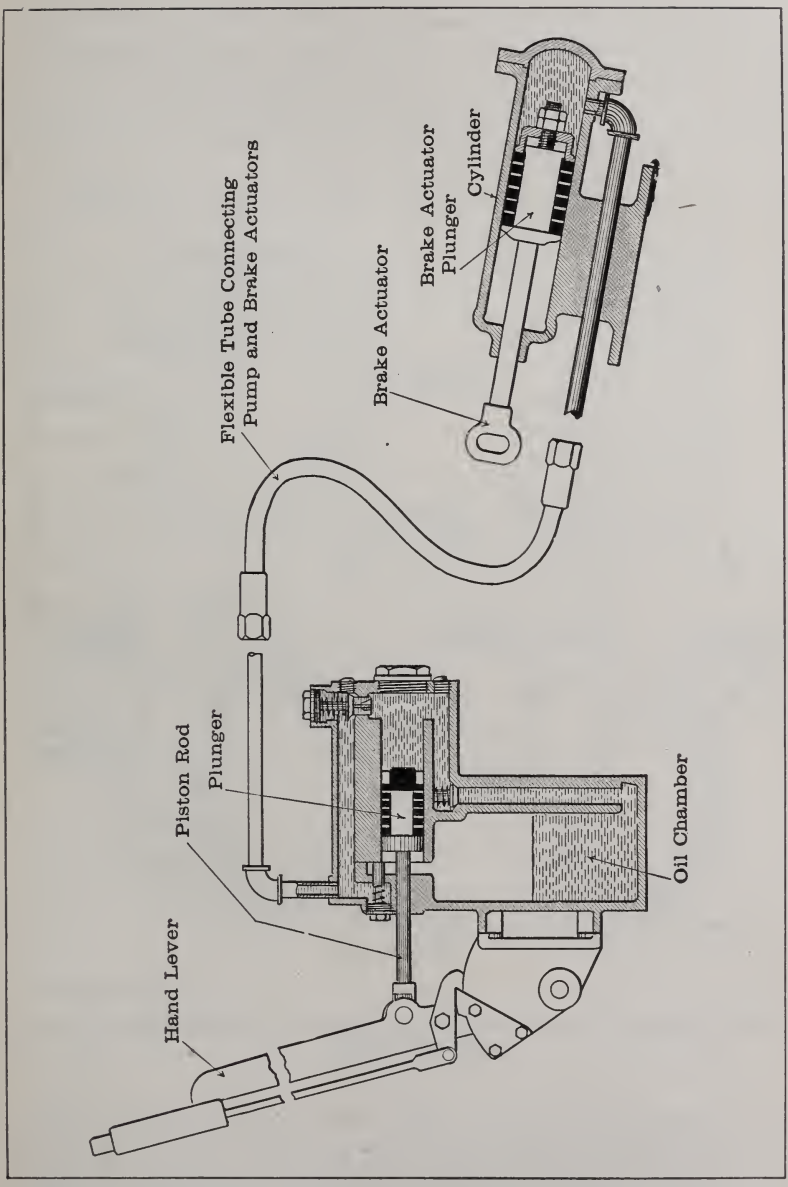


Fig. 617.—Method of Operating Rear Hub Brakes Hydraulically Used on the Knox Tractor.

All anti-friction bearings may be divided in two general classes, those employing balls to carry the load, as shown at *A* and *B*, Fig. 618, and the other types depicted at *C* and *D*, which utilize rollers. The ball bearing depicted at *A* is cup and cone form patterned somewhat after bearings that have received wide application in bicycles and numerous other light machines. This bearing has an angular contact, and is capable of taking radial and thrust loads. A radial

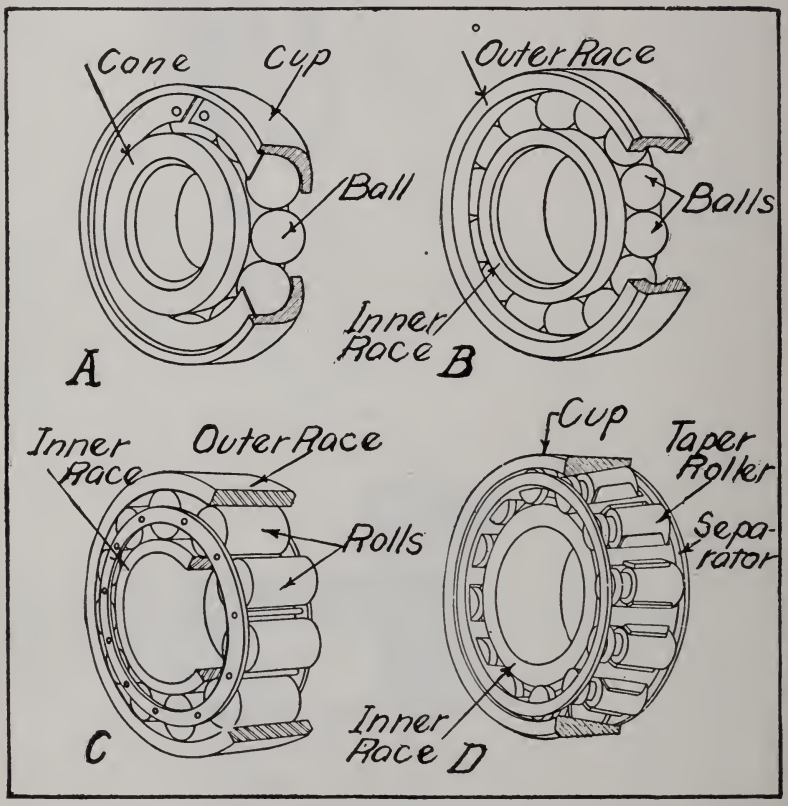


Fig. 618.—Principal Types of Anti-Friction Bearings that Have Been Used in Automobile Work.

load is one applied at a right angle to the centre line of the shaft passing through the bearing cone, while an end thrust is a load that tends to push the cone laterally against the cup. An angular resultant is a load composed of a combination of end thrust and radial stress. A ball or roller bearing having angular line of contact is suited to resist either a radial or thrust load or a combination of the two.

Angular contact bearings, or the cup and cone type, are adjustable to a certain degree, inasmuch as lost motion may be eliminated, if not due to bearing depreciation, by forcing the cup or cone into more intimate contact with the balls, providing the other member is held against a suitable shoulder in the housing or on the shaft. The ball bearing shown at *B* is an annular form having a vertical load line, and is thus adapted only for radial loads and very light end thrust.

The roller bearing shown at *C* is provided with straight rolls, and can only take radial loads just as the ball bearing shown at *B*. The roller bearing depicted at *D*, which employs tapered inner and outer race members and correspondingly tapered rollers, is capable of resisting end thrust as well as radial loads, but as is true of the cup and cone bearing depicted at *A*, the direction of the load must be such that the bearing parts will be forced more closely together. If a straight roller bearing or an annular ball bearing having a vertical line of contact is used at points where considerable end thrust exists, it is necessary to apply another bearing to resist the thrust. A double row form of bearing, which consists virtually of two cup and cone bearings mounted together in a common shell, has received general application because it can take the loads applied from any direction. The load lines are at an angle and diverge from the centre line of the bearing outwardly. A radial load will be resisted by both rolls of balls, while a thrust load from either direction will be sustained by the outer race and balls opposite the point of application, assuming that the outer race is held against an abutment or shoulder in the housing while the load is applied to the cone.

The angularity of a load line of a bearing affects radial and thrust capacity, depending upon the angle the load line assumes with the horizontal or vertical centre lines of the bearing. As a bearing with a vertical load line has the greatest radial capacity and practically no resistance to end thrust, it follows that one with a horizontal load line will have the greatest thrust capacity and practically no resistance to radial loads.

Roller bearings may be made with either solid or flexible rolls. A solid roller should be short in order to prevent deflection or distortion of the roll if the stress is not evenly applied. If long solid rollers are used one end will tend to travel faster than the other, and this is apt to produce friction between the rolls and the retaining cage. It is contended by adherents of the flexible roll construction shown at Fig. 619 that this type adapts itself more readily to irregularities in shaft contour, and thus turns with less friction than do the solid rolls. The flexible roller bearings are made in two types,

one employing long steel rolls, while the high duty type uses shorter rolls of high tensile strength alloy steel and accurately ground inner and outer race members. In the regular or long roll pattern the shaft itself is intended to form one bearing surface, and as this is generally soft, the rolls must be long in order to distribute the load over more surface. Flexible roller bearings are wound from strip stock, so that right and left spirals exist in alternate rollers, and the oil will be constantly circulated from one side of the bearing to the other.

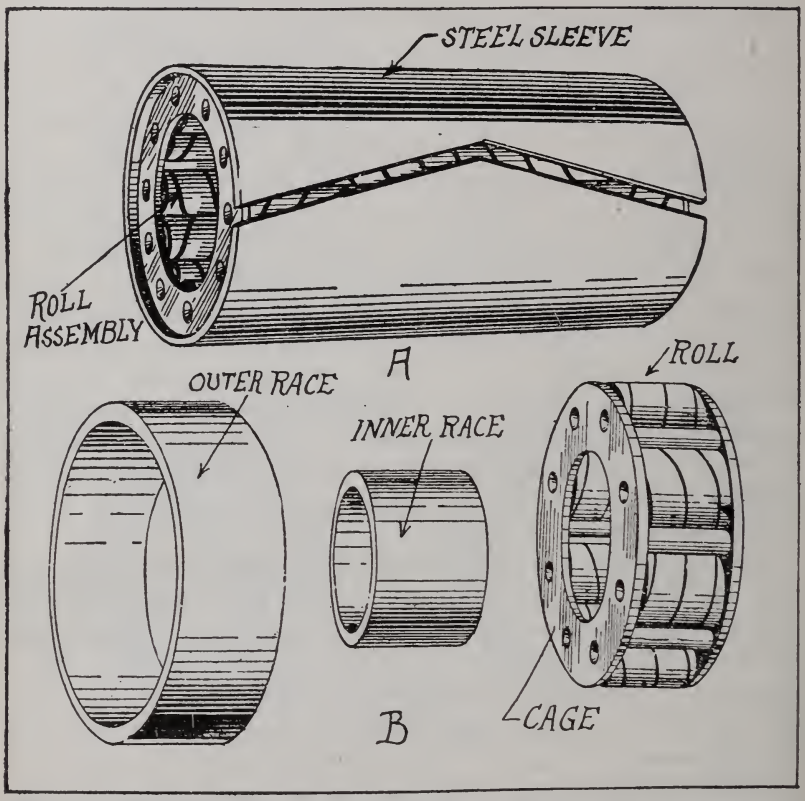


Fig. 619.—Two Types of the Hyatt Flexible Roller Bearing. A—The Standard Form in which Long Rolls Run on Shafts. B—High Duty Type Having Short Rolls and Hardened Steel Inner and Outer Races.

In either ball or roller bearings the effect of the load is to flatten the supporting members a very small amount, so that in a roller bearing the contact between the roller and race-way may be represented by a rectangle having a length equal to the roll, but a width so small

that it is usually considered a line contact. In a ball bearing the flattening of the ball produces an ellipse of such small area that it is usually considered a point of contact. As the reduction of friction depends upon the amount of surface in contact, it can readily be understood that the form having the least amount of surface would have least friction. Ball bearings are generally employed where it is

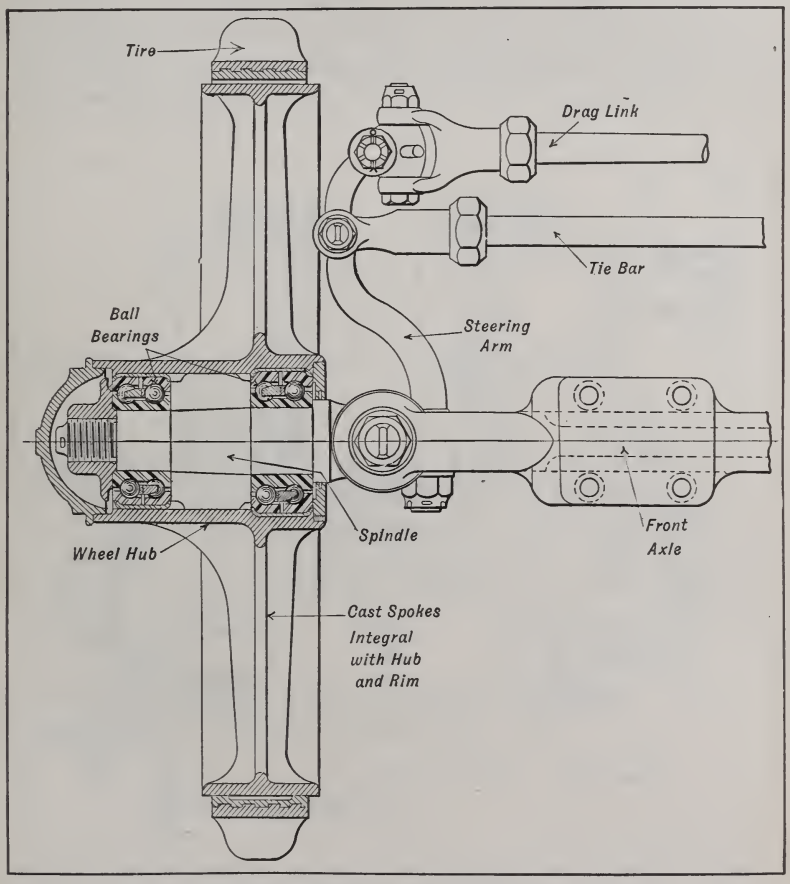


Fig. 620.—Front Wheel of Heavy Truck Mounted on Double Row Ball Bearings.

desirable to reduce friction to a minimum or where bearings must attain high speed. Roller bearings have been widely applied where bearings of relatively small diameter but of large carrying capacity must be used, where the shafts revolve at a comparatively low speed, and where maximum bearing efficiency is not important. The motor truck wheel shown at Fig. 620 is mounted on

ball bearings of the double row form, while the crankshaft of the motor depicted at Fig. 621 is supported by single row annular ball bearings. Many other examples showing the practical application of all types of anti-friction bearings will be found at various points in this work.

Great care is needed to keep anti-friction bearings free from water or grit, and also to keep them adequately lubricated. The lubricant must be a pure mineral substance, and should not contain acid or animal fillers, because the highly polished surfaces of the anti-friction members and races will be roughened by etching or rusting

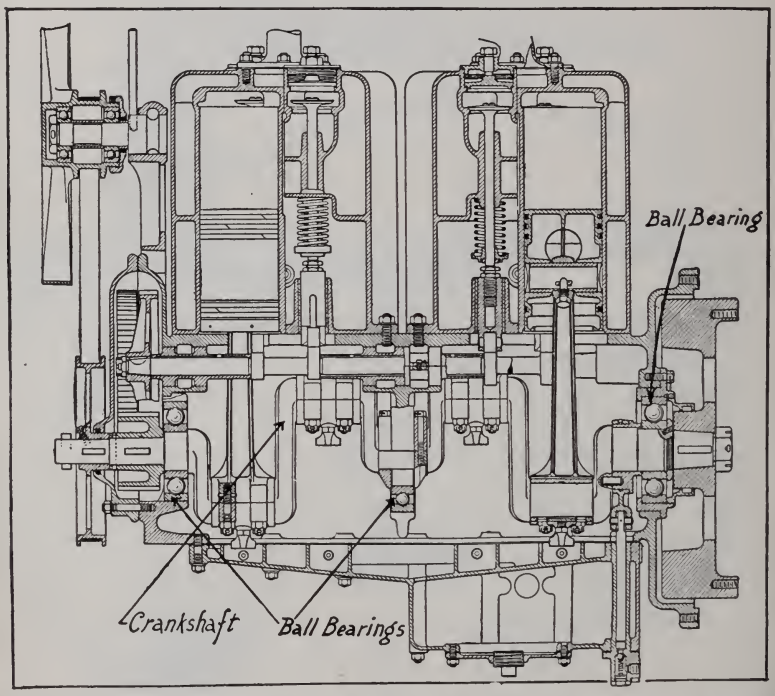


Fig. 621.—Sectional View of Mais Motor Truck Power Plant Design, with Crankshaft Mounted on Ball Bearings.

due to chemical action, and this will interfere with smooth operation and tend to produce rapid depreciation. A heavy bodied lubricant of the semi-fluid type is best adapted for use in bearings subjected to heavy loads and revolving at low speed. Graphite greases having about the consistency of vaseline or petroleum jelly are generally applied for this purpose. If an anti-friction bearing is housed in an

oil-retaining, dust-excluding housing, it is good practice to use a medium grade machine oil and operate the bearings in a constant bath of lubricant. Ball or roller bearings should never be driven in place or removed with a steel drift or hammer, because the races are hard steel and are apt to be cracked unless they are forced in place either with a steady pressure, as by an arbor press, or by blows applied through the medium of a block of hard wood or piece of Babbitt metal interposed between the hammer and the bearing. The blow should always be directed or the pressure exerted against the race member that is being forced in place.

CHAPTER XII

WHEELS, RIMS AND TIRES

Wood and Wire Wheels Compared—Resilient or Spring Wheels—Steel Disc Wheels—Advantages of Pneumatic Tires—Pneumatic Tire Construction Outlined—Forms of Tire Treads—Tire Protectors and Non-Skid Attachments—Demountable Rim Forms—Features of Cushion Tires—Solid Tire Types—Tools and Supplies for Tire Restoration—Faults of Tires and Their Elimination—Apparatus for Tire Repairing.

Before considering the forms of various tires and rims in general use, it will be well to give the subject of wheel construction some consideration. These are a very important element of the motor-car chassis and much of the safety and comfort of the occupants of the vehicle depends upon the proper selection of wheels of sufficient size and adequate strength. At the present time the wood wheel is the most popular form in use in this country, though abroad considerable attention is being paid to the development of wire and metal wheels.

The first form of wheel to be applied to automobiles was patterned after the forms used on bicycles, as it was thought that many of the same engineering principles applied equally well to both forms of conveyances; and as many of the early designers and builders of motor cars were formerly in the bicycle industry, it seems but natural that they should attempt to apply some of the experience gained in that field to the newer one of automobile construction. Wire wheels were soon supplemented by wood wheels of the artillery type, because these were very strong and presented an appearance that was not unconventional because it did not differ very much from the wheels generally used on horse-drawn vehicles.

Characteristics of Wooden Wheels.—Two forms of wooden wheels have been applied to automobile service. The first to be used employed a Sarven type hub which did not prove strong enough, and was later succeeded by the artillery type. The Sarven wheel is the form that is widely used on light carriages and wagons, and in this construction the spokes are forced into suitable holes made to receive them and held in a wooden hub, and the whole assembly of hub, spokes and felloe are held together by shrinking a steel tire around the assembled wheel. This was supplemented by some form of rim

adapted to take a rubber tire when used for automobile work. The Sarven type hub did not prove satisfactory on vehicles of the self-propelling form, except on very light motor buggies where the drive was by side chain to a sprocket attached to the spokes.

Some attempts were made to use this type of wheel on live axles by driving in a metal bushing in which the keyway by which the

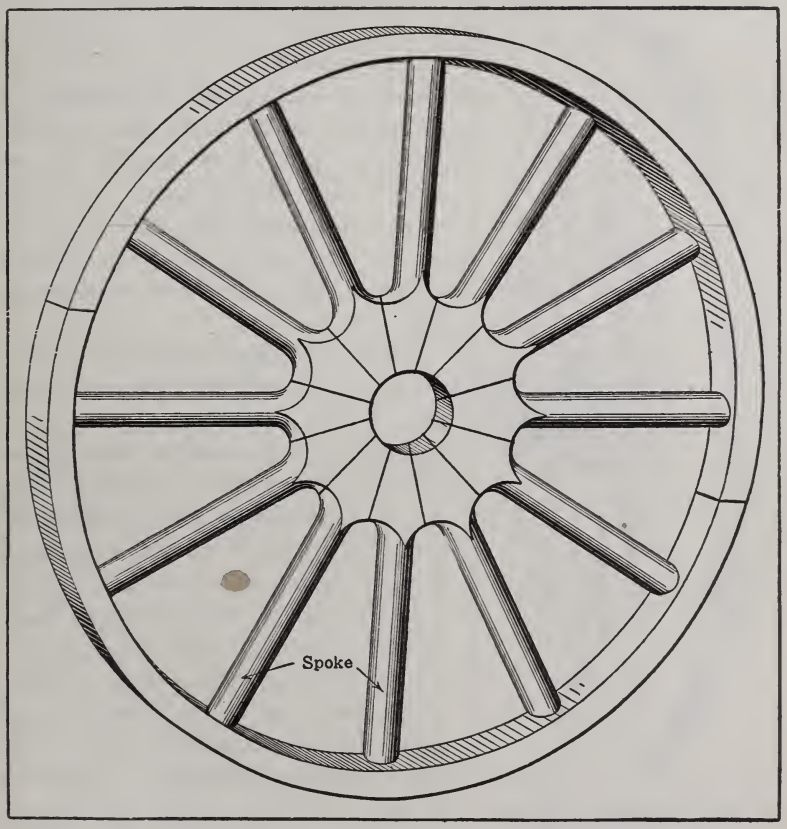


Fig. 622.—Wooden Portions of Artillery Type Automobile Wheel.

wheel was secured to the axle was formed. Considerable trouble was experienced by the metal bushings coming loose in the hubs and failing to drive the wheel. Then, again, the Sarven type wheel was not strong enough to stand the side thrusts of the heavier automobiles, and was soon replaced by the form at present used, in which a metal hub forms the center of the spoke and felloe assembly.

The wooden parts of the artillery wheel are depicted at Fig. 622, while the construction of the hub can be very clearly understood by

referring to drawings in preceding chapter. The ends of the spokes which fit between the hub flanges are wedge shape and are so formed that they will fit closely together when assembled to produce a complete circle of wood which is sandwiched between the wheel-hub flanges, held together by bolts passing through them and the spokes. The outer end of the spokes is turned down to fit holes bored into the arcs that comprise the felloe. The wheel assembly is held together in much the same manner as that employed in carriage-wheel construction, excepting that the steel rim is usually provided with hook section flanges made to hold the clincher tire generally used. A complete wooden-wheel assembly with hub, demountable clincher rim, and pneumatic tire is shown at Fig. 623.

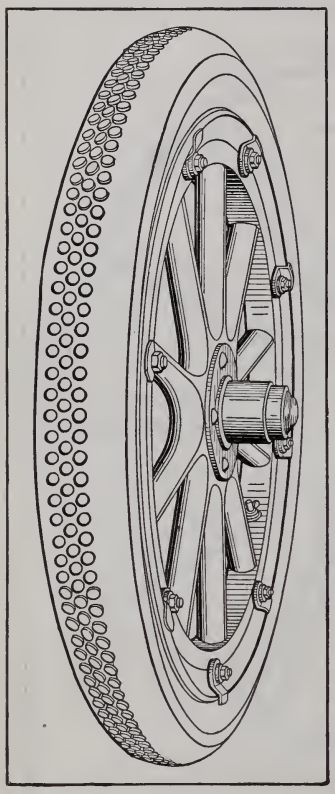


Fig. 623.—Complete Artillery Wheel Assembly.

Wire and Metal Wheels.—At the present time automobile engineers seem agreed that second-growth hickory is the only wood that can be used successfully in automobile-wheel construction, but it is becoming more difficult to obtain this material as the production of automobiles is increased. In England the wood is very scarce, so many designers in that country are returning to the wire-spoke type of wheel which was used on the earlier model cars. Suitable wood for wheels is not easy to obtain, because it must be of such a nature that it will stand both a steady load and sudden shocks. Hickory alone of all common woods combines these two features, and while other trees may furnish lumber that may be stronger or tougher than hickory, in some applications it is the only one which seems to combine the desired qualities. When the supply of wood decreases to a point where it will be difficult to obtain it promptly, it is believed that automobile manufacturers will be forced to use metal wheels.

This has been done by some of the producers of heavy commercial cars in some instances, and the metal wheels which have been applied

may be divided into three types. Those used on the heavier vehicles may be of cast steel, having a spoke and hub construction very similar to that of the present-day artillery wooden wheels, except the hubs and rims are cast integral with the spokes. This forms a very strong wheel assembly; the only objection that can be advanced against them is that while stronger than wooden wheels they are much heavier. Metal wheels are sometimes made by fastening two steel stampings together to form the rim and web portions, these in turn being joined to a separately formed flanged hub member.

Demountable Steel Disc Wheel.—A disc wheel of great simplicity that has many of the advantages of the quick demountable wire wheel and which is much simpler in construction and easier to keep clean is depicted at Fig. 624. But a single disc is used, this being a special form so that the disc is thickest at the center portion where it is attached to the hub and thinnest at the edge where it is attached to the tire-carrying rim. The outer edge of this disc can be fastened to any desired design of felloe band and can be made to carry any type of rim. It is installed on a master hub by clamping it between two plates, driving lugs or dowel pins being provided to drive the discs. The construction of the master hub is such that the outer flange screws tightly against the disc and is provided with a simple lock (not shown in illustration) to prevent it from backing off. The whole wheel may be taken off as easy as a wire wheel and much easier than the usual form of demountable rim. The wheels are mounted on the axle with a concave

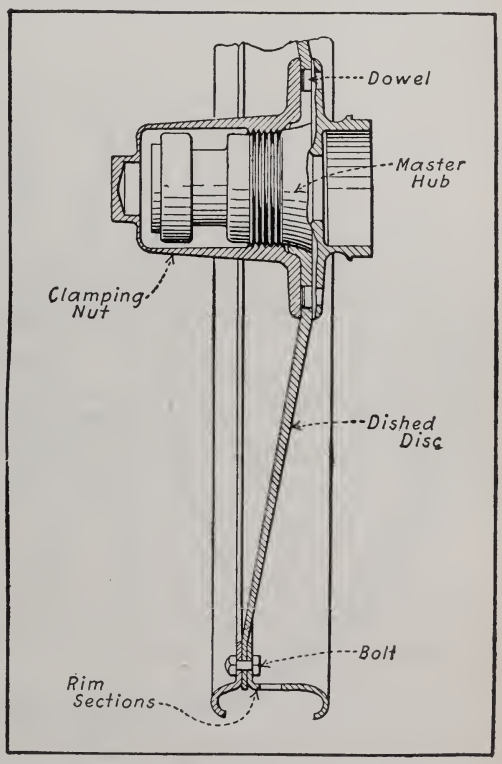


Fig. 624.—Recently Devised Demountable Steel Disc Wheel.

side facing out and it is said they do not have the clumsy look that disc wheels mounted in the opposite way have. Many engineers believe that the disc wheel will be the ultimate type for automobiles, and as a dished disc of the tapering section and form outlined has great strength and will be very easy to keep clean, it is reasonable to expect a wider application when the motoring public becomes accustomed to the unconventional appearance. While wire-spoked wheels are the style now and in great favor, fickle Dame Fashion may elect the disc wheel as a worthy successor. Considered from a practical aspect the disc type has mechanical advantages that make it a desirable form.

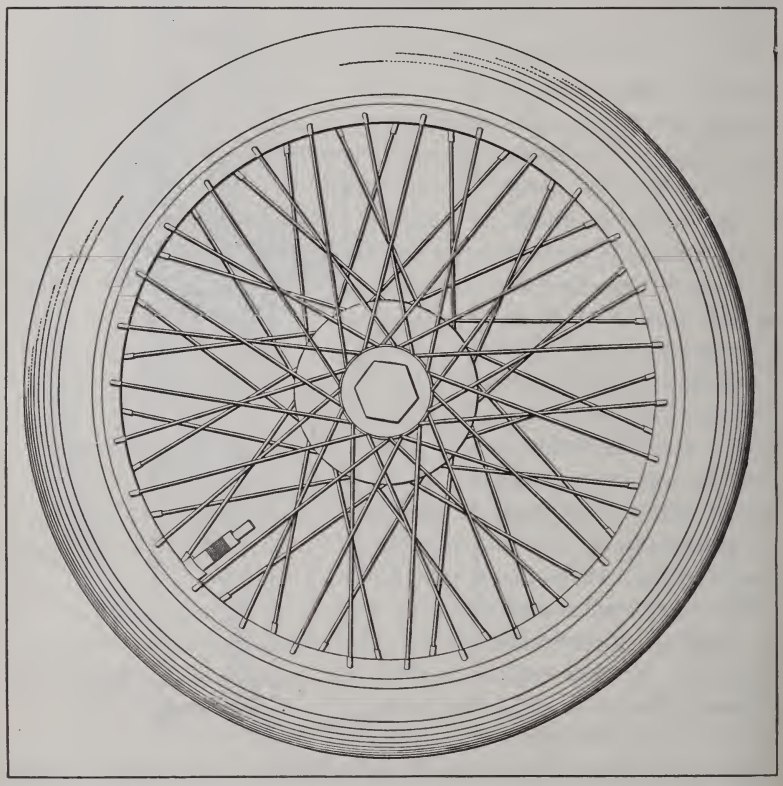


Fig. 625.—Wire-Spoke Automobile Wheel, Greatly Modified from Bicycle Practice.

Wire Wheels Popular.—The metal wheel most generally used, however, is the suspension type so commonly used in bicycles and motorcycle construction. In this the steel hub member is joined to the outer rim by spokes of steel wire interlaced in such a manner that

they hold the hub and rim together firmly. One advantage of metal wheels is that this material may be worked up into any desired form, and, where lightness is desired, one can use wire-spoke wheels and either the built-up pressed-steel forms or the cast-steel wheels for heavy loads. If lightness is desired, light metals which are very strong are available, while maximum strength is obtained by the use of the highly resisting materials in the cast form.

The wire wheel has attained considerable popularity in America, and its gradually widening field of use here as well as in England and on the continent shows that it is a big success, and in its improved forms it has much to commend it for automobile service. The wire wheel is lighter than a wooden wheel of equal strength, there being a saving of at least 33⅓ per cent of weight when wire wheels are employed instead of the artillery type. Advocates of the wire wheel state that it is stronger than the wooden wheel in both vertical and horizontal directions. In a wooden wheel the load is carried on the spokes which are under compression, whereas in a wire wheel the weight is carried by the spokes which are under tension.

A series of tests conducted abroad showed that wire wheels were much stronger and resisted blows of greater definite strength applied to the rim than wooden wheels of equivalent rated capacity. It is also contended that wire wheels are much more elastic and resilient than the wooden supporting members, and that a car equipped with these will be more easy riding and wear the tires less than another chassis of the same weight mounted on wooden wheels. Wire wheels are not used to any extent on heavy vehicles, and when metal wheels are fitted to trucks they are usually of the heavier forms. A typical wire-wheel assembly is shown at Fig. 625, this being a form used to a large extent on touring vehicles in England.

It is claimed that with wire wheels considerably more elasticity is present than in wooden members and that this type of wheel is much easier on tires. Experiments conducted during the past two or three years have served to establish the belief in some quarters that wire wheels double the life of tires as compared to wooden wheels. The main reason advanced is that wire wheels are extremely light at their peripheries and the reduction of weight at this point overcomes the flywheel effect and heavier blows of the wooden wheel rim when it strikes an obstruction in the roadway. The difference between the effect of shock on the tires of a wooden wheel with a heavy demountable rim at its periphery and the wire wheel with its light single rim is equal to the difference between a blow struck with a light hammer and one struck with a hammer weighing six or eight

pounds. Obviously as the wheel revolves the force of the tire striking the surface of the road is almost the same as though a blow were being struck against the tire.

With the wire wheel the weight is suspended from seventy common points. It is never entirely supported on one spoke in compression as is the case with a wooden wheel. When an obstruction is met it is like striking a punching bag between ropes, as the shock is absorbed by the flexible steel members joining the wheel rim to the hub. With wooden spokes a portion of the shock is absorbed by the wood, but a large part of it is transmitted directly to the wheel hub.

Advantages of Detachable Wheels.—Detachable wheels may be either of the wire wheel pattern or of the artillery construction. In all forms of detachable wheels two hubs are necessary: an inner member, which is in permanent assembly with the axle, and a removable outer member to which the spokes and rims are attached. In the Rudge-Whitworth construction, shown at Fig. 626, the steel shell to which the spokes are laced is readily removable from the inner member or hub casting proper. The object of this construction is to permit the motorist to carry a spare wheel with a fully inflated tire, so that in event of puncture or blowout it is possible to remove the entire detachable wheel assembly affected and replace it with the spare member carrying the fully inflated tire which has been provided for replacement purposes. All detachable wheels are constructed so that they may be readily removed from the inner hub member, and the entire wheel assembly may be replaced much easier and quicker than replacing the ordinary form of tire.

Another quality of some importance is the ability of the wire wheel with the spokes laced tangent, to absorb the shock or starting or sudden application of power in the plane in which the wheel rotates. This quality is absent in wooden wheel construction.

It is a well-known fact that the friction between tire and road generated in driving a car at even a reasonable speed results in quick and excessive heating of the tire structure. In the wooden wheel, which serves in a sense as insulation, there is a very slight ability to quickly dissipate heat. Wire wheels requiring only a thin metallic rim, the spokes serving in a sense as cooling flanges, will dissipate this heat almost as quickly as it is generated. This results in keeping the tire at almost normal temperature even in very warm weather.

Spring and Resilient Wheels.—Attempts have been made to build wheels which would have some form of flexible or yielding member to join the rim and the hub, instead of the rigid wood or metal

spokes. Many spring wheels have been evolved, the ultimate aim of all inventors of this form being to provide a supporting member

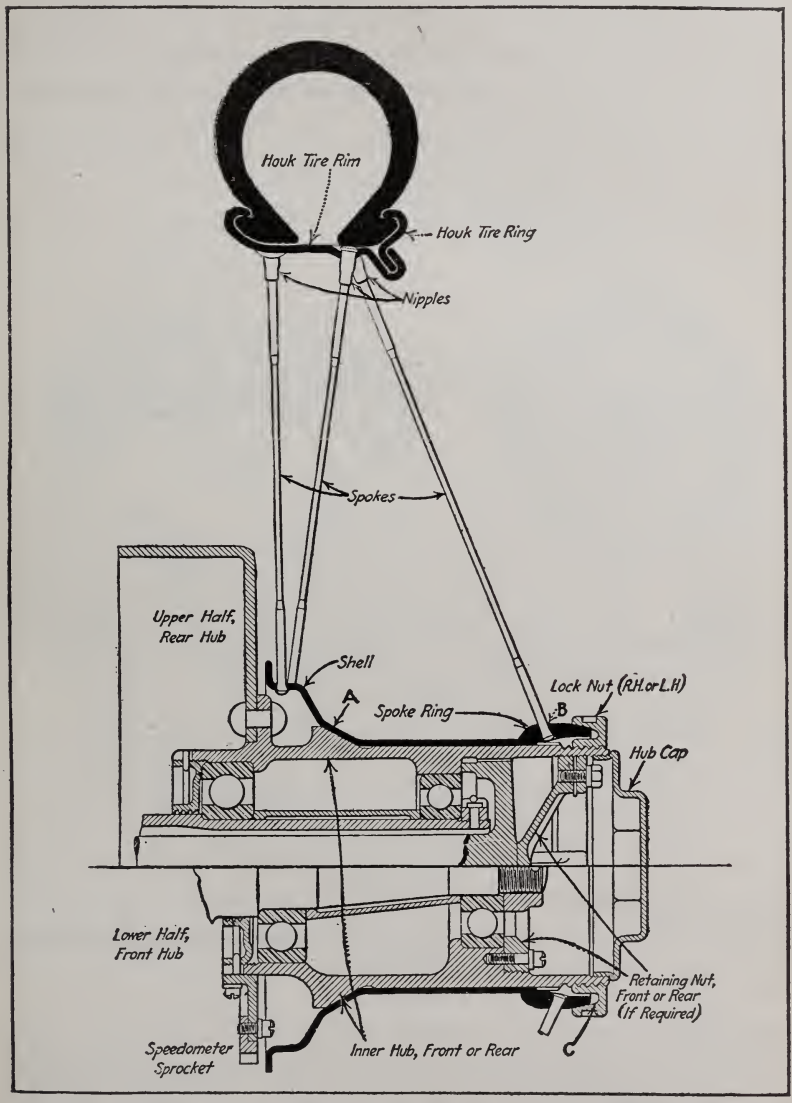


Fig. 626.—Sectional View Showing Construction of Triple-Spoke Rudge-Whitworth Detachable Wire Wheels.

which would have sufficient resiliency so the pneumatic tire could be dispensed with and the troubles incidental to its use eliminated.

The Lipkowski spring wheel is depicted at Fig. 627, this being a fairly good example of the radial coil-spring form which is said to have given fairly satisfactory results in its trials. In this construction the hub and felloe are composed of two members held together by bolts. These retention members form the journals for the loops on the end of the spring, while the spaces between the outer portions

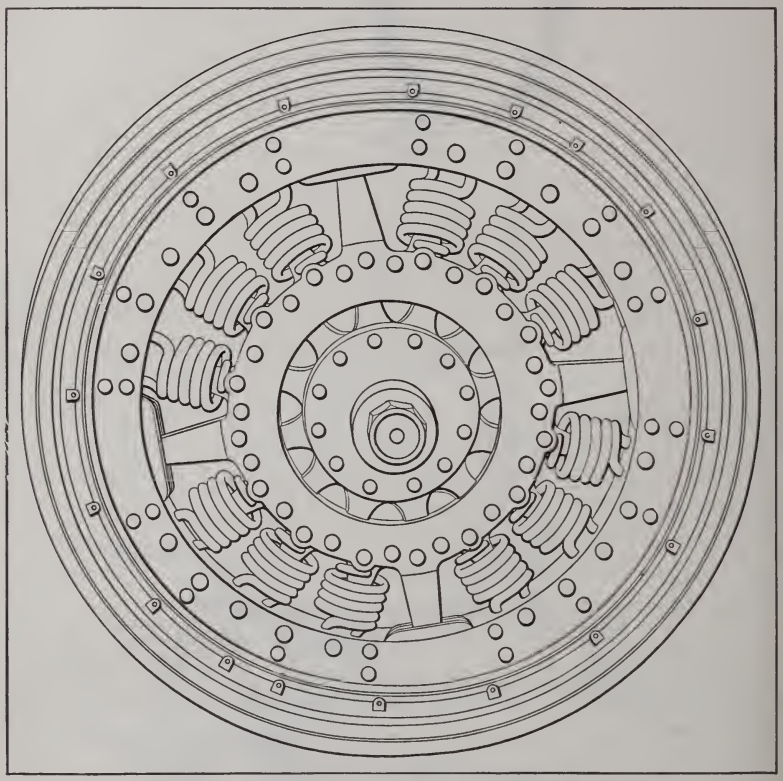


Fig. 627.—Resilient Steel Wheel Having Coil Springs Separating Hub and Rim Members.

of the wheel felloe are a sufficient distance apart to act as a guide for the four solid metal spokes which are spaced ninety degrees apart and which radiate from the outer periphery of the hub member. Twelve springs are used, these being mounted in sets of three, each set occupying the space between the two spokes.

The resilient members are attached in such a manner that they are subjected to alternate compression and tension loads. Those at the top of the wheel are under tension, while those at the lower

portion are under compression. The four rigid steel spokes engage suitable projections on the inside of the felloe and are depended on to keep the wheels steady against side blows and to furnish a positive means of driving when the wheel is used as a traction member. The disadvantage of this type of construction is that the springs are liable to break and that the construction is very heavy when compared to wooden wheels. It is claimed that this type of wheel is fifty per cent heavier than an ordinary wooden wheel of greater strength. Another disadvantage of spring wheels of this pattern is that they are apt to be noisy in action, which is not desirable.

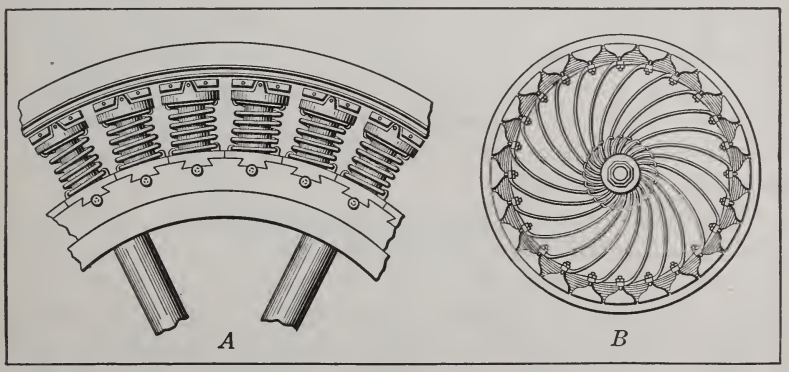


Fig. 628.—Spring Wheels Designed to Provide a Resilient Support for Automobiles Without Using Pneumatic Tires.

Two other forms of spring wheels are shown at Fig. 628. That at A employs a series of radial compression springs which provide the resilient feature, while the strength is obtained by means of the plungers fastened to the upper member which is attached to the wheel rim; these in turn fit the cylinders attached to the outer periphery of the inner wheel. The spring serves to keep these members separated at all times. In the construction outlined at B the spokes are flat springs, curved in a peculiar manner, and join the central hub member with the outer rim. Neither one of the forms shown have been adapted practically, and the illustrations are presented merely to show freak constructions which have but little practical value.

It may be said of all forms of spring wheels that their disadvantages are of sufficient magnitude to make those which are advanced against the pneumatic tire seem simple by comparison. While pneumatic tires may fail on the road, they may be easily restored or repaired and the journey continued with but little interruption. If

members of a spring or resilient wheel should fail in service the work of replacement would entail a degree of mechanical skill not usually possessed by the average motorist. Many inventors have given this problem considerable attention, but it is safe to say that the rubber tire in either of its forms is absolutely necessary to successful motor-vehicle operation, and that there is but little future for resilient wheels depending on springs or other metal resilient members to cushion the shocks met with when traveling over ordinary highways unless it is on very heavy, slow speed commercial vehicles.

Forms of Automobile Tires.—The wheels of automobiles, with but few exceptions, are provided with rubber tires. The simplest is a solid band of rubber composition; next in order we have the various forms of cushion tires in which the band of rubber is perforated with a number of small holes or provided with a series of openings designed to provide greater resiliency and make the tire more yielding than the solid-rubber form. Solid tires are invariably adapted to industrial conveyances.

The most common form of tire, and that generally used on automobiles, is composed of a hollow rubber tube of circular section filled with air and protected from wear by means of an outer shoe or casing. The use of air under compression provides a very resilient medium for supporting the vehicle, and of the various forms of rubber tires the pneumatic form is the one that is the most desirable. The development of the modern automobile may be attributed largely to the advances made in pneumatic-tire construction, as these members made it possible to drive automobiles at high speed over rough road surfaces without stressing the mechanism or causing discomfort of the passengers. While solid-rubber tires and members of the cushion form have a certain degree of elasticity, they do not ride as easy as pneumatic tires, because rubber cannot be compressed, but only distorted. Solid-rubber and cushion tires are suitable where vehicle speeds are low, but are very unsatisfactory for automobiles traveling at speeds over fifteen miles per hour.

A comparison between the action of pneumatic and solid-rubber tires is made at Fig. 629, so the superiority of the latter form may be readily understood. At A, a wheel shod with a pneumatic tire is shown in contact with an obstacle in the road. When the wheel passes over this obstruction, the walls of the tire, which are relatively light, will deflect inward and compress the air inside of the tires. The wheel is not raised from the ground and the vehicle rides over the obstruction without any appreciable upward movement or throw of the chassis. At B a solid rubber tire is shown passing

over the same obstacle. In this case the composition is so stiff that it will not bend in and the wheel is raised from the ground. This throws the vehicle body upward, jarring both mechanism and passengers. The severity of the jolt augments proportionately to the speed of the vehicle. It will be patent that the form of tire depicted at A, which permits the stone to imbed itself into the tire, will be

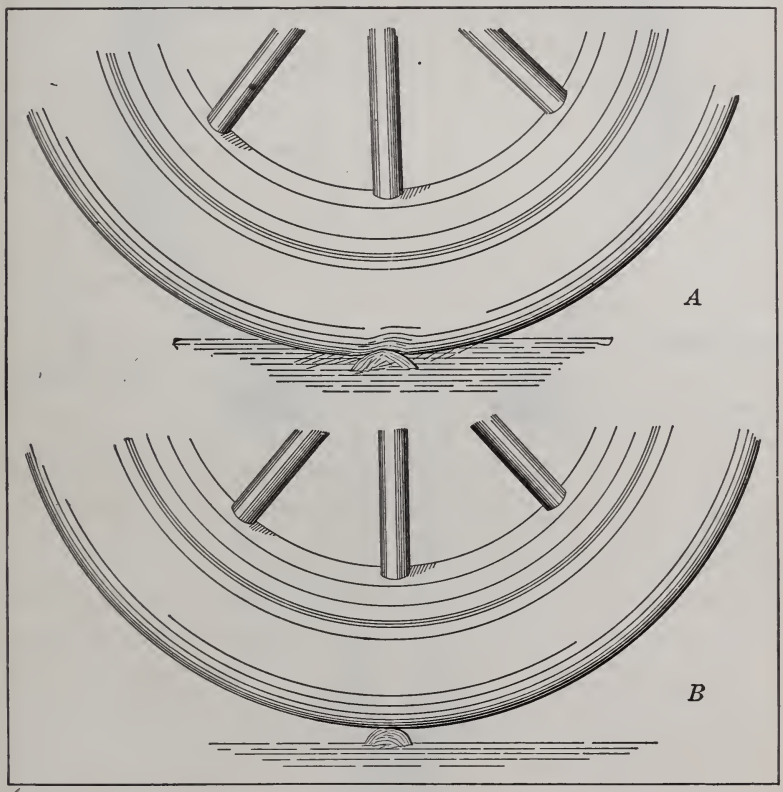


Fig. 629.—Comparison of Action of Pneumatic and Solid Rubber Tires When Wheel Rides Over Obstacle. A—Air-filled Tire Gives to Obstacle. B—Solid Tire Gives But Slightly.

much more easy riding than that form which will ride over the obstacle. The great advantage of a pneumatic tire is that it will give more than ordinary elasticity to the wheel and will absorb most of the minor shocks that would be transmitted to the springs of the vehicle if noncompressible tires were used.

Construction of Pneumatic Tires Defined.—The pneumatic tire of the present day is invariably of the double-tube type and is com-

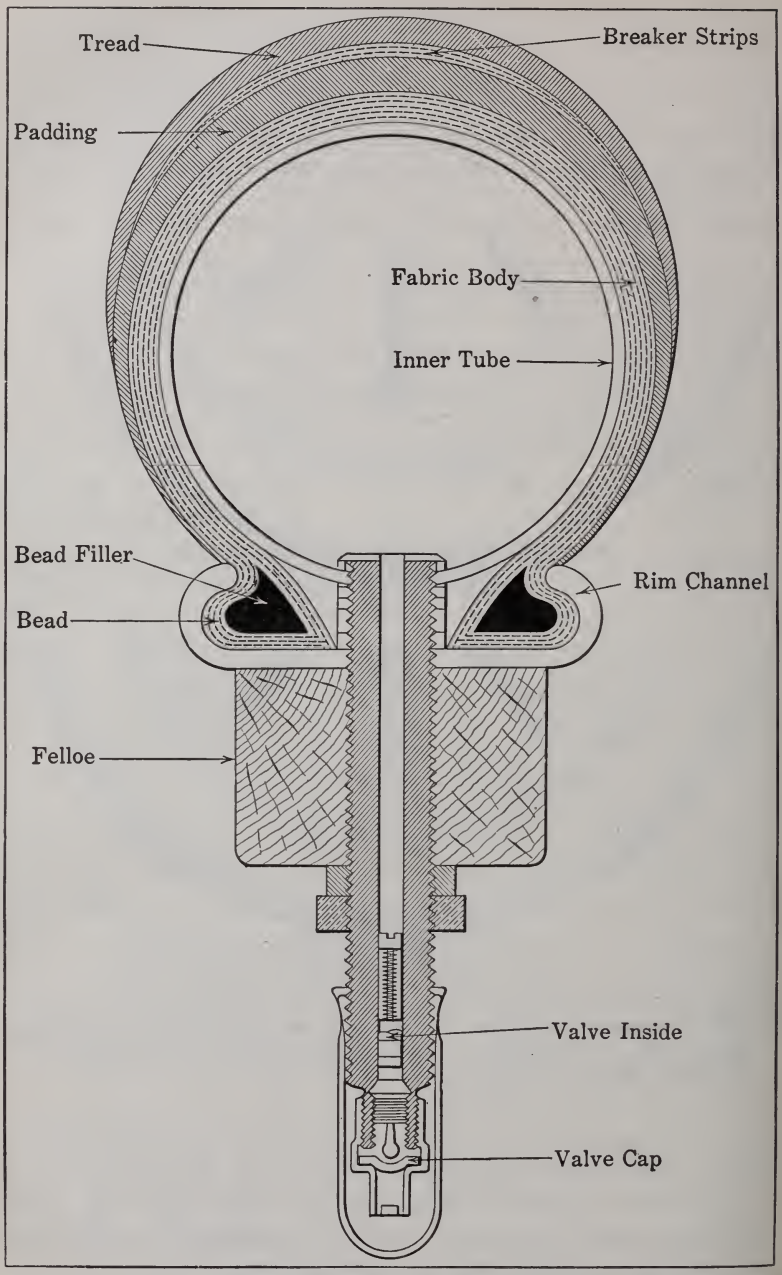


Fig. 630.—Sectional View Outlining Construction of Pneumatic Automobile Tire Fitted to Simple Clincher Rim.

posed of two members, the inner tube and the shoe or carcass. The inner member is utilized to retain the air and is made of a very pure rubber, about an eighth of an inch thick for cars of average weight. While this tube is very elastic and is air-tight, it would not be strong enough or have adequate resistance to be run directly in contact with the road surface; therefore it is necessary to protect it by a shoe composed of layers of fabric and rubber composition. The shoe member is provided with beads on its inner periphery designed to interlock with the rim channel, as shown at Fig. 630.

The main portion of the outer casing is composed of five or more layers of a Sea Island cotton fabric "frictioned" with high-grade rubber composition. This is forced into the mesh of the cloth by machinery so the fabric will be practically waterproof and will join intimately with the other plies by a process of vulcanization when the shoe is cured. Outside of the fabric body a layer of very resilient rubber, approximately of crescent form, known as the padding, is provided to give a certain degree of elasticity to the shoe. Between this member and the tread a number of pieces of heavy fabric called "breaker strips" are interposed to offer a certain degree of resistance to any sharp object that might penetrate the tread and go through the padding and into the fabric body if the breaker strips were not interposed to deflect the puncturing object to one side.

The tread is the part of the tire that is subjected to the greatest stress, as it must resist the abrading influence of the road and, when the tire is used on the rear wheels, the wearing effect of the friction produced by the tractive effort which exists at the point of contact between the driving member and the ground. The tread is of very tough rubber composition and differs from the material used as padding or for the inner tube in that it does not possess a very great degree of elasticity. This quality is sacrificed for that of greater strength and resistance to wear, which is more essential at this point.

The air is introduced into the tire through a simple form of automatic valve which is securely attached to the inner tube. As the inner tube becomes distended by the air pumped into it, it forces the beads of the tire outward and clinches the shoe so firmly in the rim channel that it will be impossible to dislodge it without the use of special tire irons, and then only when the air pressure is relieved from the inner tube. A detailed view of the valve stem in the open and closed position is shown at Fig. 631, and the construction of this simple fitting can be easily understood. The valve is held against its seat by a tension spring and will only open when the valve stem

is depressed by the hand or from the pressure of the air forced against it when it is desired to inflate the tire. While the air pressure from the pump will be sufficient to force the valve from its seat, the air pressure from the inside of the tire only serves to hold it more firmly in place.

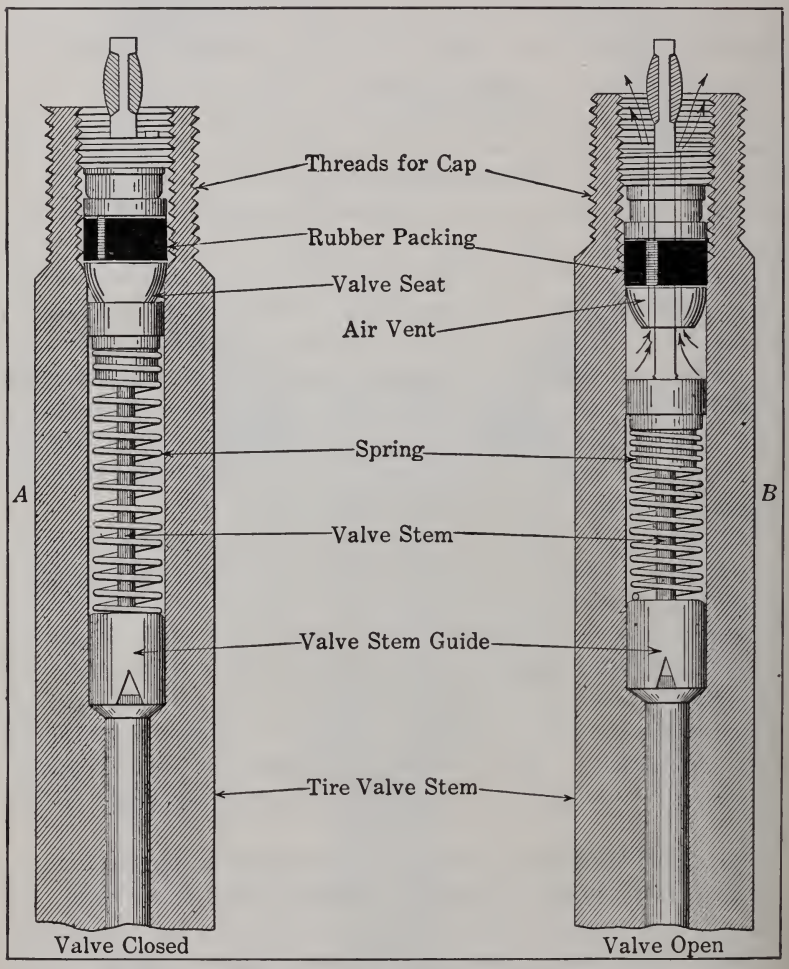


Fig. 631.—Construction of Shrader Universal Tire Valve.

The general design of practically all outer casings is the same though there are minor differences of structural detail. For example, some makers will use finer fabric and more layers than others, and each manufacturer has his own specific formulæ for compounding

rubber to the best advantage. Some tires are made with a straight side at the lower end instead of the clincher bead, whereas others are adapted to be secured to the rim by means of bolts. There are also differences in the thickness of the tread and of the padding and breaker strips. Some makers build their tires by what is known as the moulded process while others favor the wrapped tread construction. In the first mentioned method, after the various layers of material of which the tire is composed are assembled together on the core, the assembled tire is clamped tightly in a mould and vulcanized. In the wrapped tread construction, instead of curing the rubber in a mould the finished tire assembly is wound tightly with narrow strips of webbing to hold the parts together while the curing process takes place. The various members of which the tires are composed are vulcanized by being heated with steam, and sulphur is included in the rubber compounds in proper quantities to permit them to become firmly welded to the friction fabric layers between which they are placed.

The Cord Tire.—A method of tire construction that is becoming popular because of its easy riding qualities but which is a difficult

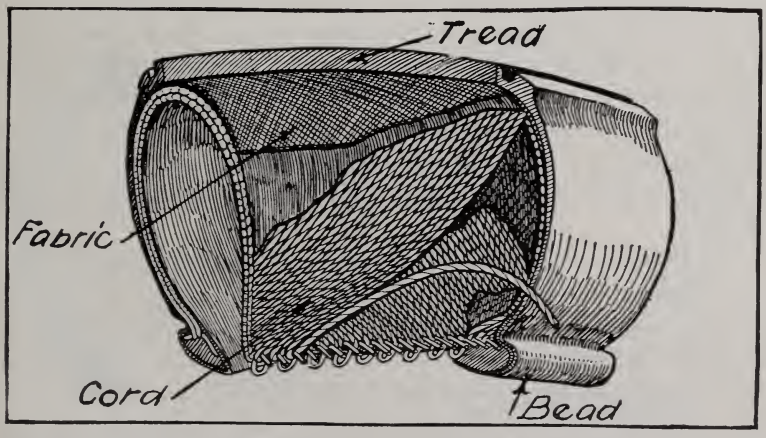


Fig. 632.—Part Sectional View of Tire Showing Palmer Cord Construction.

form to repair is shown at Fig. 632. Instead of layers of fabric the main portion of the carcass, or casing, is composed of cores which are passed around small wires at the base of the tire and which are wound very tightly in order to secure intimate contact between the various layers of cord. Sheet rubber is placed between the cord layers and fabric breaker strips are placed between the tread and the cord body in the usual manner. When the tire is vulcanized the spaces

between the layers of cord become filled with the rubber, and the whole mass is firmly bound together. The wires project into the bead portion of the tire and are vulcanized firmly in place. Owing to the construction a cord tire cannot be as easily repaired as the fabric type because it requires a very expert knowledge of cord tire construction to replace injured portions due to a blowout. Tires of this construction are much more resilient and are capable of giving considerably more mileage that the stiffer form comprised entirely of fabric. For this reason they are often used on electric automobiles, but as they are more expensive in first cost they are used more on expensive automobiles than on popular price jobs.

Rim Forms.—Pneumatic tires are not always of the clincher form. Various other constructions have been devised, some to facilitate a more ready removal than the clincher construction permits, while others have been designed to make for a more secure attachment by some mechanical means. Various forms of quick-detachable rims and the tires adapted for use with them are shown at Fig. 633. In the ordinary clincher tire it is necessary to force the bead over the channel when it is desired to remove the outer casing, and while this can be accomplished with comparative ease on the smaller tires, it is very difficult to remove or apply large clincher tires. In the form shown at A the clincher rim is made in two parts, one of the sections being easily removable when the locking ring is taken out of the groove in which it fits. When the movable section of the rim is taken off the outer casing may be easily removed, as it can be slipped off the fixed portion of the rim just as a belt can be removed from a pulley.

The Dunlop or straight side type of outer casing is depicted at B and C, these also being fitted to quick-detachable rims. In the Dunlop casing retention is by a series of steel wires at the base of the tire which have a certain amount of holding power, which is further augmented by the air pressure inside of the tube. It is claimed for this construction that it is more easily removed than the clincher tire when applied to a one-piece rim, though on the quick-detachable type shown in illustration one form is as easily removed as the other. The rim shown at A and B is the same member, and it will take either clincher or Dunlop type casing. When used for the latter a rubber filler ring is provided to fill the channel of the fixed portion of the rim, while the flat side of the removable portion is brought in contact with the casing walls instead of the channel or hooked side. The form shown at C is made exclusively for use with Dunlop type casings, and cannot be utilized for clincher tires.

At D the Fisk bolted-on casing is shown, but this form is now practically obsolete and will be noticed on only very old model cars. This differs from the other forms in that the clinchers are designed in such a manner that they practically form a foot or base, and when closed together will keep the inner tube away from the rim, which is

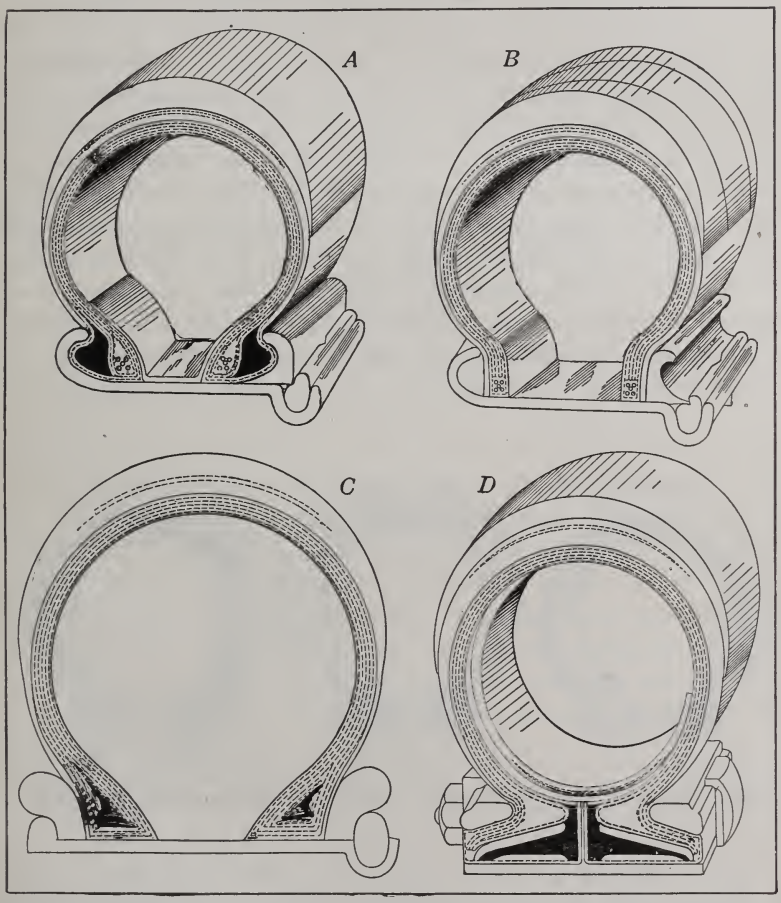


Fig. 633.—Forms of Quick Detachable Rims which Permit Easy Removal of Deflated Pneumatic Tires.

not done with the other forms of rims. The rim proper consists of a flat band of steel attached to the wheel felloe. Two locking rings are provided, one at either side of the tire, and these are held into proper relation and clamped tightly against the base member of the shoe by means of bolts which pass through the enlarged beads of the casing. This form of attachment is very secure and the tire is held to the rim

by mechanical means as well as air pressure. In other forms of tires in which air pressure alone is depended upon to keep the beads in contact with the rim it is possible for tires to be thrown off the wheels if they become deflated, though with the mechanically fastened form, as shown at D, the tire will be held in place, even when partially deflated, much more securely than in the other forms.

The construction of inner tubes is practically the same in all standard makes of tires, and these are usually interchangeable. The outer casings differ in some respects, these being merely a matter of detail involving the number of plies of fabric, the thickness of the padding, the arrangement of breaker strips, and the character of the tread. All the tires shown at Fig. 633 have the plain round tread, which is the most satisfactory for all-around use. The smooth tread, however, has the disadvantage in that it is liable to slip on muddy roads, and for this reason a number of tread forms have been designed to secure greater adhesion to the road or to reduce wear. A round-tread tire will wear off until the breaker strips are exposed, and the tire should be retreaded as soon as this condition is apparent.

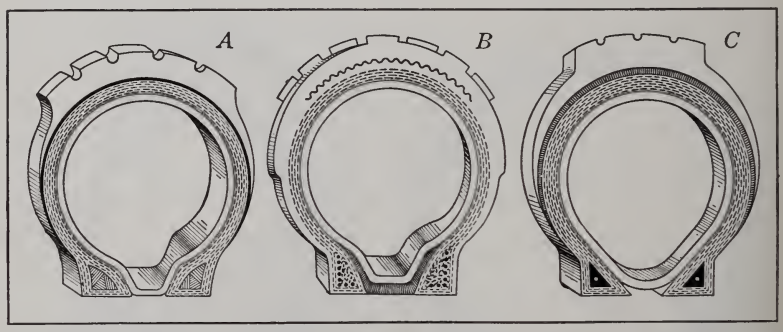


Fig. 634.—Showing Various Raised Treads Used on Pneumatic Tire Casings.

The casings shown at Fig. 634 are a few of the forms which have been designed to secure greater wear of the tread. In that shown at A the tread is raised at five portions and is very thick. In that shown at B the tread is provided with a large number of small rubber studs or projections which are depended on to prevent side slip more than providing any great amount of added wear to the tread. The form shown at C is known as a raised-tread type, and in this the round tread is reënforced with a flat band running around the outer periphery, this providing a greater thickness of tread than will be possible with the round-tread construction.

The leading forms of treads designed to secure greater traction than that obtained from the plain-tread forms are shown at Fig. 635. In the Morgan & Wright, shown at A, a large number of knobs are molded integral with the tread to prevent skidding. The Empire casing shown at B has a number of disks composed of strips of fabric rolled up and set edgewise in the tread to promote adhesion. In the Swinhart, which is depicted at C, strips of rubber are molded with the tread to form a species of basket weave. This prevents skidding, because the spaces between the strips will fill with mud or dirt and will not slip over the road surface as readily as a smooth tread. The casing shown at D is provided with a number of rings molded with the tread to form little cups which grip the road by the suction effect of the air compressed between the tire and the road surface in the depressions. The Ajax nonskid tread depicted at E is composed of diamond-shaped rubber pieces molded integral with the tread when the tire is cured. A very ingenious method of roughening the surface of the tread to promote traction is that used on the Firestone casings. In this the words "Firestone" and "Non-Skid" are molded in bold lettering alternately and at an angle all around the shoe.

The Midgeley tread is depicted at G. This construction has a series of coil springs molded around the outer periphery of the casing. The Diamond casing outlined at H utilizes the Bailey rubber-stud tread, one of the first antiskidding treads to be devised. In the Michelin casing illustrated at I, a leather band provided with steel studs, which are riveted through it and the casing, is depended on to prevent skidding, to secure improved traction, and to make the casing practically puncture proof from ordinary road obstacles. The Republic Staggard tread tire is shown at J. The principle of providing a large number of projections which is used in the forms depicted at A, D, H, I, is followed on this casing as well, but these knobs are of such size the liability of rapid wear, which is present when rubber buttons of comparatively small size are used, is reduced and the life and antiskidding properties of the tread are augmented proportionately.

While the nonskidding forms of tires have peculiar advantages which adapt them for use on soft and slippery roads, they are more expensive than the round-tread casings, and are really not needed a large part of the time. The labor of changing from the antiskid type of tread to smooth casings would be considerable, and it would not be practical to make the changes as often as conditions imposed by our variable climate would make necessary. For this reason a num-

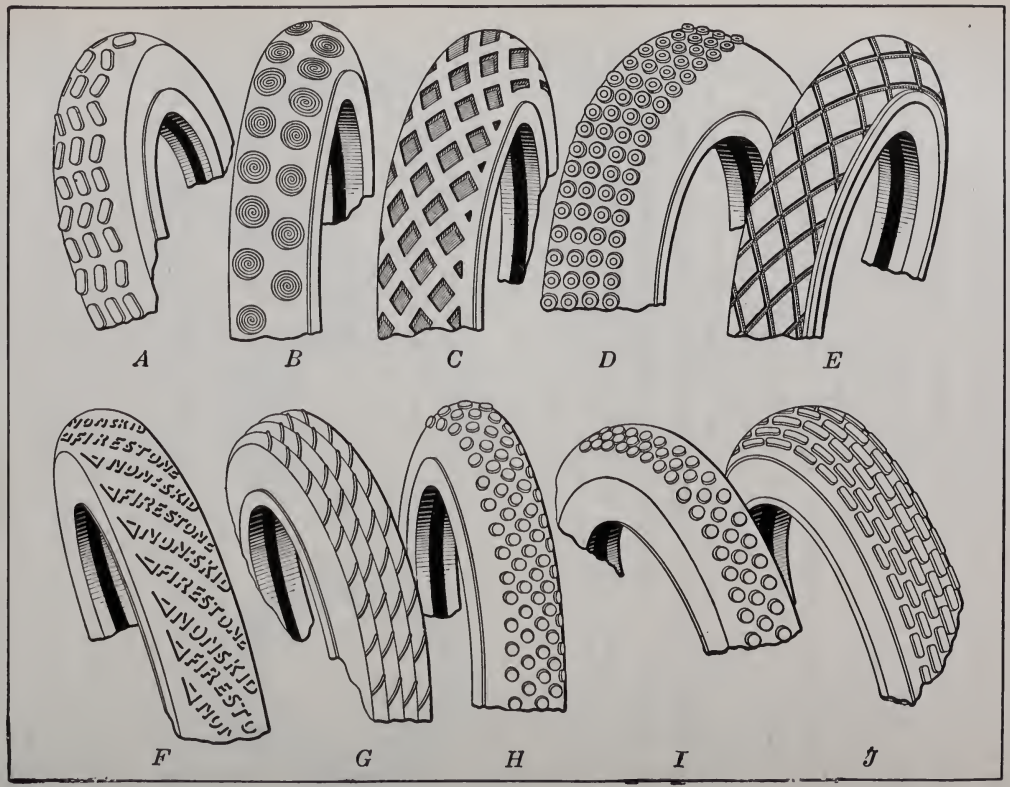


Fig. 636.—How Outer Casing Treads May Be Formed to Secure Greater Traction Effort Than Obtains from Smooth Treads and Thus Prevents Side Slipping.

ber of auxiliary treads and nonskid devices have been placed on the market, the idea being to use these in conjunction with the plain-tread tires when necessary. These auxiliaries may be divided into two classes. First, those designed merely to promote better tractive effort and eliminate skidding, and, secondly, those which have been designed to act as a protector for the casing of rubber which they encircle.

Tire Protectors.—A number of these auxiliaries are shown at Fig. 636. That at A is a leather tread provided with steel studs on the tread surface, made in such a form that it is put around the tire when the casing is deflated and held firmly in place by blowing up the tire again. This may be classed with the tire protectors, as it is believed the heavy chrome-leather band has much more resistance to nails or other objects which might puncture the rubber tube, than the plain round-tread tire would have. At B and C devices which belong to the first class are depicted. These consist of cross chains attached to suitable side members which encircle the wheels. The object of the chains on the tire tread is to eliminate loss-power effort by providing a better grip between the wheels and road surface, and not to act as a protector for the outer casing except in a somewhat limited way. In the form shown at B the cross chains are attached in such a manner that they lie in the same plane as do the rungs of a ladder. At C the chain members are of zigzag form. The protectors shown at D, E, and F are very similar in principle to that outlined at A, except that the method of securing them to the wheel varies to a slight extent. That at D is a form designed to encircle the casing and can be held in place by the air pressure inside of the tire. At E the protector is fastened to the wheel by a series of strap members which clinch under a side-retaining ring member. At F the edges of the protector are provided with hooks which grip the flanges of the clincher tire and thus hold the protector very firmly in place when the tire is properly inflated and the casing distended.

The disadvantage of tire protectors is that they decrease the resiliency of the tire, because leather is not as flexible as rubber, especially after it has become hard by exposure to water. The use of these protectors undoubtedly conserves the tire casing from puncture, but considerable heat is generated between the tire and the protector, and this may be sufficiently high to weaken the rubber casing. Most motorists favor the use of the quick-detachable chains to prevent skidding, because these may be easily removed when they are not needed. There is some labor involved in removing and replacing the leather protectors, and these are not usually used with

new casings on account of the decrease of tire resiliency. They are often applied to weak casings or shoes which have been worn to the fabric, and when used in this manner they are very useful in securing greater service from the weak tires, which would have to be discarded if some form of protecting tread was not used.

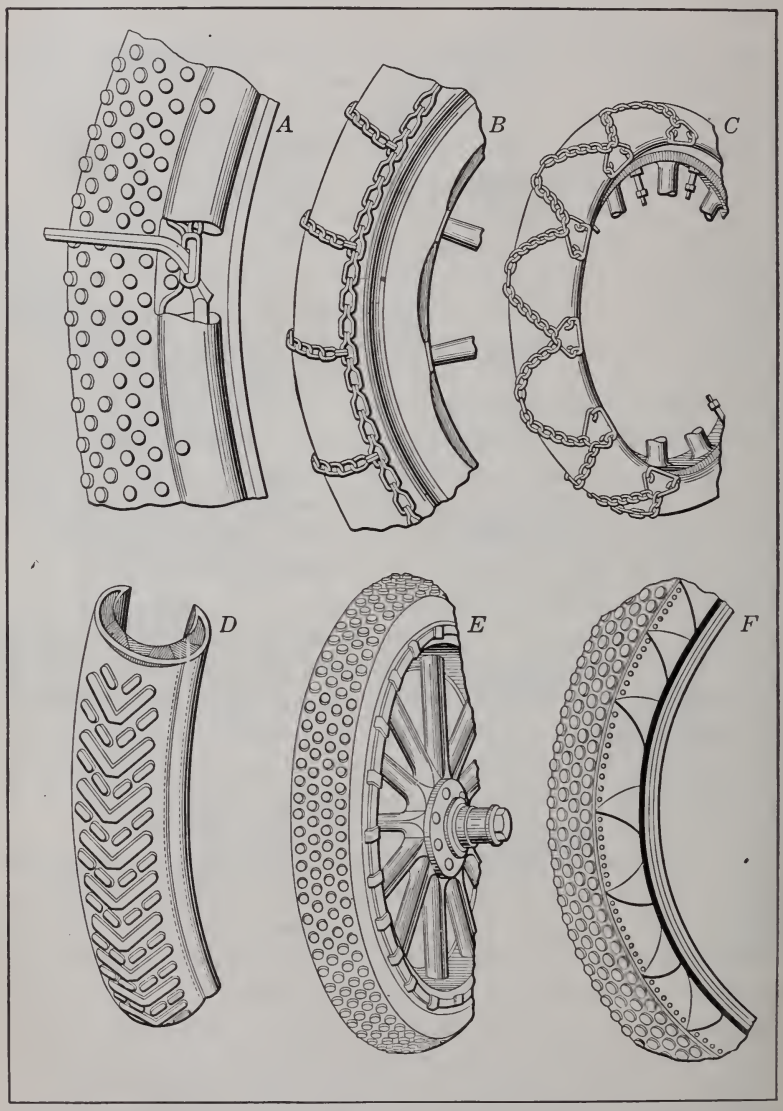


Fig. 636.—Supplementary Treads and Anti-Skidding Attachments Designed to Use in Connection with Smooth-Tread Casing.

The views at Fig. 637 show the ease with which Weed chain grips can be attached to the wheel. In the view shown at A the chain has been applied to the tire and the vehicle has been pushed forward just enough to ride over the loose ends of the chain, which are on the ground. At B the car has been pushed forward sufficiently so the loose ends of the chain are clear of the wheel, and the process of hooking up by means of little snap hooks is easily performed, as outlined at C. Chains are also used on motor truck wheels and a simple and easily attached form is shown at Fig. 638. This device provides increased traction by means of three double cross-chains locked to each of the rear wheels. Each cross-chain is double, hence smaller than the equivalent single chain and said to reduce vibration.

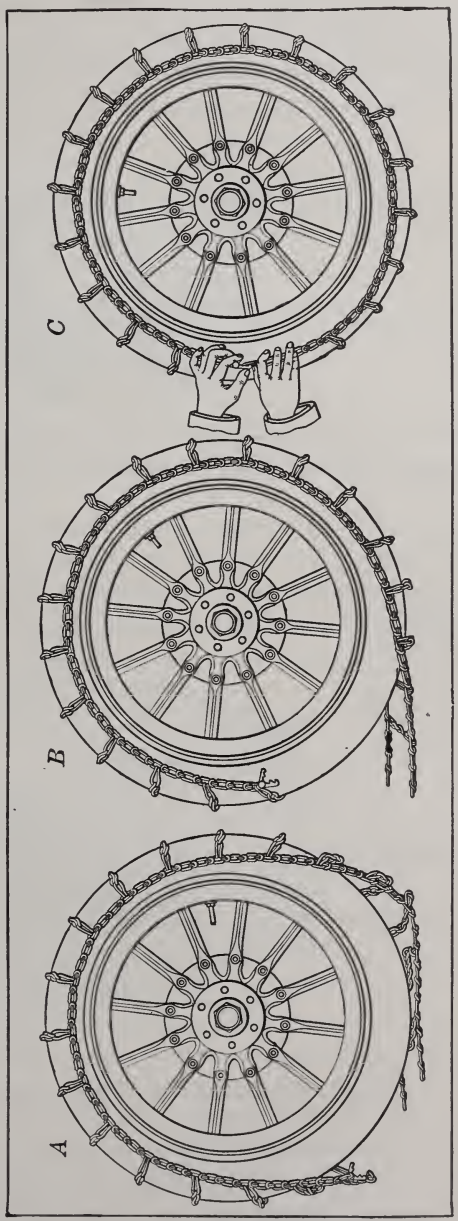


Fig. 637.—Methods of Applying Weed Tire Chains to Wheel Without Jacking Up the Car.

Demountable Rim Forms.—The advantages of the quick-detachable rim over the ordinary clincher pattern have been previously considered. It will be seen that it is possible to remove a tire with less difficulty than is present when the clincher rims are used. While a defective tire may be removed and replaced with a new one very easily,

it is necessary to inflate the new tire with air by means of a hand or power pump or with carbonic-acid gas carried under pressure in a portable gas tank. In order to reduce the time occupied in changing tires, which is needed to adjust the shoe properly and blow up the inner tube, a number of demountable rims have been devised.

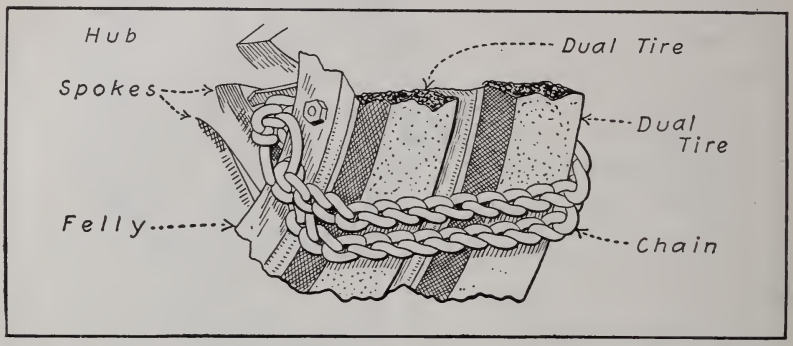


Fig. 638.—Non-Skid Chains Intended for Use with Dual-tired Truck Wheel.

The wheel felloe carries a metal rim, and to this is attached a second member on which the tire is mounted. The tire-carrying rim may be securely attached to the wheel by means of suitable and quickly operated clamping bolts or rims.

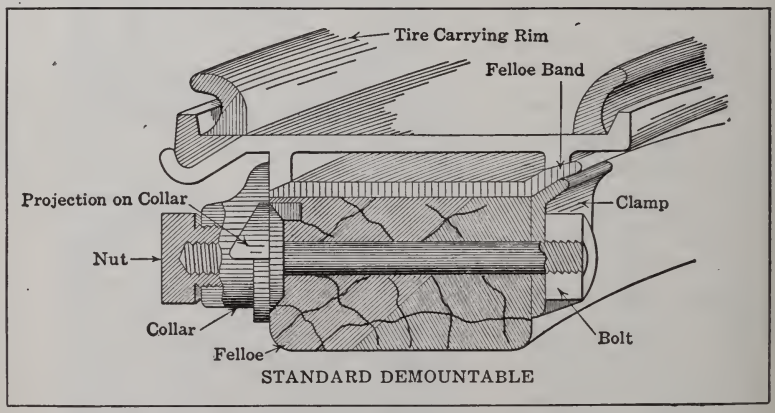


Fig. 639.—Quick Detachable Rim of the Demountable Form.

When demountable rims are fitted instead of carrying the usual spare outer casing, fully inflated tires are carried on rims similar to the demountable portions, and when the tire is punctured the damaged one and its rim are removed as a unit and a new, fully inflated member replaced. When it is necessary to remove the shoe, as in

the ordinary single-rim construction, the operation of replacing a tire will take from ten to fifteen minutes under favorable conditions, but with quick-demountable rims the operation of changing a tire will take only two or three minutes. Demountable rims are more expensive than the simpler forms, but the convenience and elimination of time-consuming delay, as well as the saving in labor, more than compensates for the increased cost of equipment.

Numerous forms of demountable rims have been devised, but few have survived the test of time and have received general application. At Fig. 639 a combination of quick-detachable and demountable rims is shown. With this construction the advantages of both types are obtained without disadvantages of any moment, excepting those of cost of equipment. The quick-detachable type of rim makes it possible to change the tires very easily, should this be necessary, and makes for more easy removal for repairing when the damaged tires are restored to their efficient condition. In this form the tire-carrying rim is held on the felloe band by a clamping collar mounted on the stud and forced in place by a nut on the outer end of the stud. The construction is so clearly shown that its advantages will be readily understood.

The clincher type of rim has been used on many cars because it has been a standard fitting for a number of years, but at the present time it is seldom used in connection with large tires, which are difficult to remove from the wheels unless used in combination with a demountable rim. A number of standard demountable rims which have received general application are shown at Fig. 640. That at A holds the clincher rim which carries the tire in place by a series of clamps and wedges which are forced against the tire-carrying rim by pressure of nuts carried at the end of bolts passing through the wheel felloe and having peculiarly shaped heads, which prevent the tire-carrying rim from moving over the inner edge of the wheel. A number of these bolts are provided, the spacing varying with the weight of car and size of tire. On light cars one bolt to every two spokes is considered ample, while on heavier vehicles a bolt may be used between every two spokes, which would mean that there would be as many clamping bolts used as there were spokes in the wheel.

The form outlined at B is similar in construction to that outlined at A, except that the felloe band is a substantial member which does not need to be reënforced to hold the tire-carrying clincher rim firmly in place when the clamps are screwed home by the nuts. The Fisk demountable rim, used in connection with the Fisk bolted-on type of detachable tire, as shown at Fig. 633, D, is outlined in section

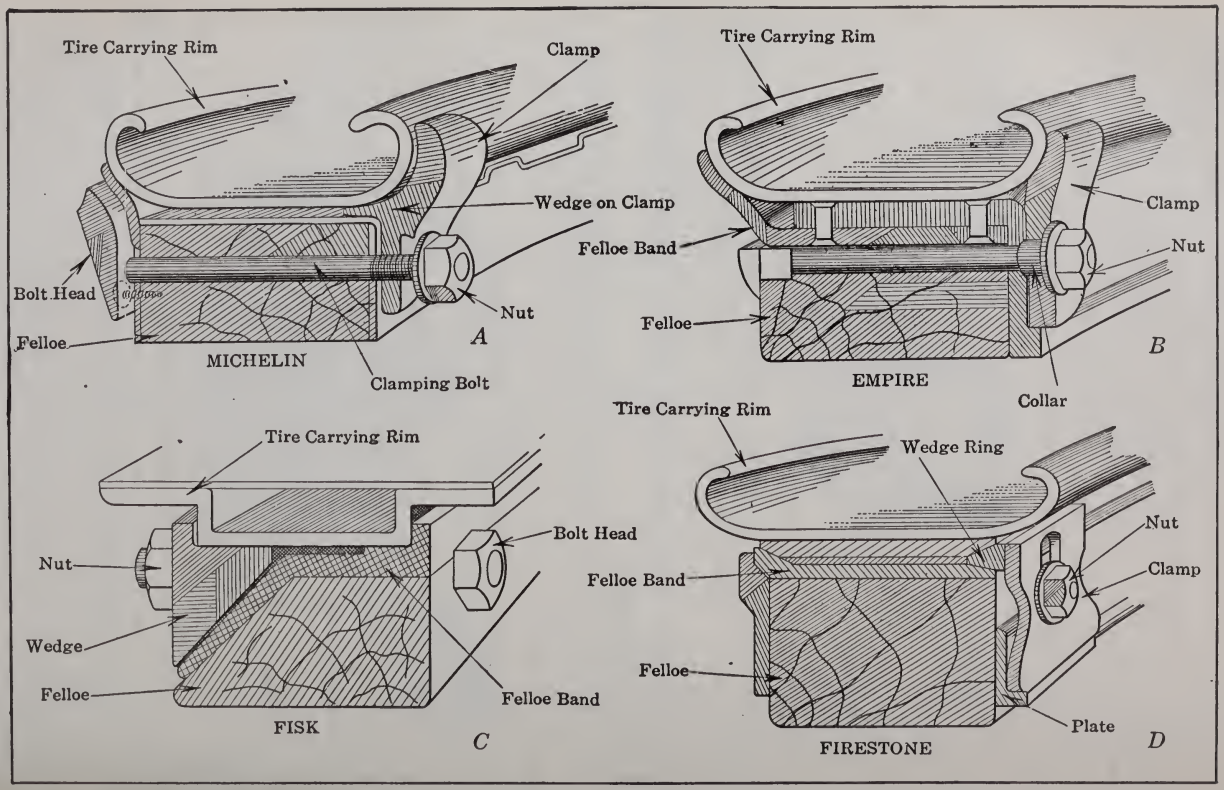


Fig. 640.—Examples of Demountable Rims that Have Been Devised for Using Conventional Types of Casing.

at Fig. 640, C. In this a portion of the felloe is chamfered off and the felloe band is made to fit. The tire-carrying rim is locked in place by a wedge member that slides on the angular side of the felloe band when pressure is brought to bear upon its face by the nuts carried at the end of the bolts passing through the felloe and felloe band. As the wedge rides up on the incline it locks the tire-carrying rim firmly in place and prevents either lateral or circumferential displacement.

In the construction depicted at D a tire-carrying rim of the clincher type is used, and this in turn is attached to a ring member which has chamfered corners. The felloe band has two inclines, one designed to rest against one side of the chamfered ring, while the other acts as a seat for the wedge-shape locking ring, which is forced in place under the tire-carrying rim by means of clamps and nuts. In order to make for quick removal, a wrench of the socket type is usually attached to a bit brace, such as used by carpenters, for loosening and tightening and clamping nuts. With some forms of demountable rim it is necessary to remove the nut entirely in order to slip the clamp off the bolt. In others the nuts are merely loosened and the clamps either swung or dropped out of the way of the tire-carrying rim, which is easily slid off the felloe band. Other forms of demountable rims have been devised in which the tire-carrying member is held in place by some form of expanding band which is made to increase its diameter by means of wedges or cam action, but these are not so generally used as the types described.

Features of Cushion Tires.—Some classes of vehicles that are not designed to run at high rates of speed, and which are not intended to carry heavy loads, are fitted with cushion tires. While these do not have the resiliency of the pneumatic form, they have much greater flexibility than solid-rubber tires. For this reason they are sometimes used on the electrically propelled light delivery or pleasure vehicles and sometimes on the light-weight commercial cars of the gasoline type. Some of the popular forms of cushion tires are shown at Fig. 641. At A the tire tread, which is of the dual form, is molded in such a manner that a series of shallow grooves are formed around the tire. These incline from the outside toward the center and are depended on to give improved traction as well as to make the tire more resilient. The base of the tire is pierced with a large number of holes which extend clear through from side to side, so the outer tread or load-carrying portion is supported on a series of rubber bridges which are adapted to bend and provide a certain degree of flexibility.

The cushion tire shown at B is similar in form to the conventional clincher casing, and is designed to be used on clincher rims of the pattern commonly supplied with pneumatic tires. The flexible feature of this tire is obtained by using a number of rubber load-supporting partitions to join the walls of the tire, and at the same time they are separated from each other by an air space of sufficient size so the tire will distort more easily than the conventional solid-rubber pattern. The cushion tire shown at C depends upon the form of tread to provide resiliency, and it would not be as flexible as either of the two forms previously considered.

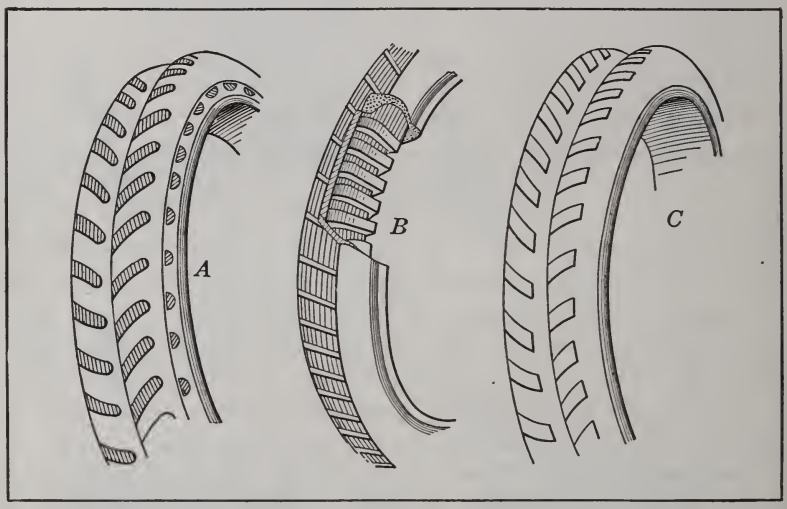


Fig. 641.—Cushion Tires which Provide More Resiliency than Solid Rubber Tires But which are Not Equal to the Air-filled Forms.

One objection to either solid or cushion tires is that a deep cut or stone bruise will seriously weaken the entire structure, whereas only a limited portion is really unfit for use. Then again, sometimes, when brakes are locked too suddenly, a portion of the tire may be worn more than the other parts, but the entire efficiency of the tire will be affected and the strength will depend upon that of the weakest portion. The sectional cushion tire which is depicted at Fig. 642, A, has been evolved to make possible the replacement of one or more injured portions without disturbing the other members. The tire is composed of a series of hollow rubber segments, as shown, which are held securely in place by means of a dovetail structure which extends from the face of one segment to engage with a corresponding

member on one of the faces of the neighboring segment. These are securely fastened to the wooden felloe of the wheel and into the steel rim by means of bolts and washers. A certain amount of air is retained in the spherical chambers of the rubber segment by the sealing effect of a special washer, and this provides an air cushion which makes for easier riding than would be possible with a solid tire. In event of damage to one segment it may be removed without difficulty and a new one substituted.

A combination cushion tire composed of a heavy solid-rubber tread and an inner tube inflated with air to form a cushion is shown

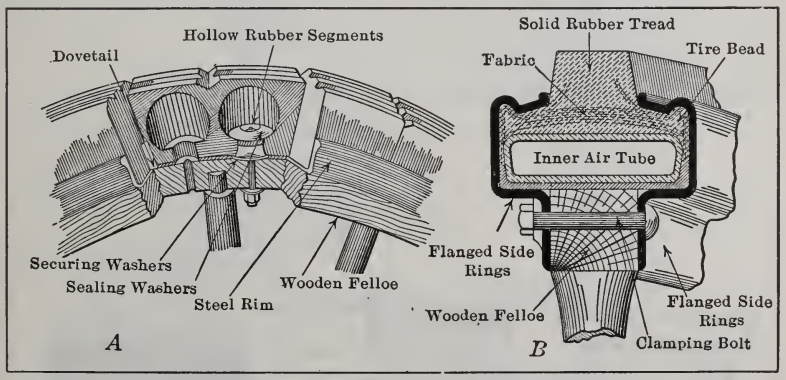


Fig. 642.—Novel Forms of Cushion Tires. A—Cairns Detachable Segment Construction. B—Combination Form Comprising Heavy Tread and Inflatable Inner Tube.

at Fig. 642, B. It is claimed for this construction that the resiliency is not greatly diminished and that the tire is absolutely puncture proof. The tire consists of two main parts, the solid-rubber outer tread being of rubber composition and mounted on a base of fabric and rubber, and the air tube, which is inflated and which provides the resilient effect. Both members are firmly clamped between circumferential steel flange side rings. The inner tube rests upon an ordinary steel rim or bonding member attached to the felloe, which is made wider than the usual construction and of channel form. The steel flanges are extended beyond the rim and are turned over at their outer edge in such a way that they form grooves to hold the beads of the tire, and continue to the base of rubber tread, where they end in a bead and leave sufficient space between them for the solid tread to work up and down. One of the flanges is permanently fastened to the felloe, while the other is removable by unscrewing the clamping nuts.

It is claimed that as the flanges enclose the air tube as well as the weaker portions of the outer member which are subjected to the air pressure, a very strong construction is obtained. The solid-rubber tread is the only portion that comes in contact with the road, and provision is made to prevent the air tubes being chafed by the sides of the steel rim or by the edges of the outer member. When the solid tread encounters an obstacle in the road it is pressed inward against the air tube in the same manner as the conventional form of outer shoe is, and more resiliency is obtained than with the rigid solid form. The inner tube is well protected from puncture, and it is also claimed that blow-outs are almost impossible, because to reach the inner tube it would be necessary to pierce either the heavy solid tread or one of the steel side flanges.

Forms of Solid-Rubber Tires.—On heavy commercial vehicles it is not practical to use pneumatic tires because these would have to be

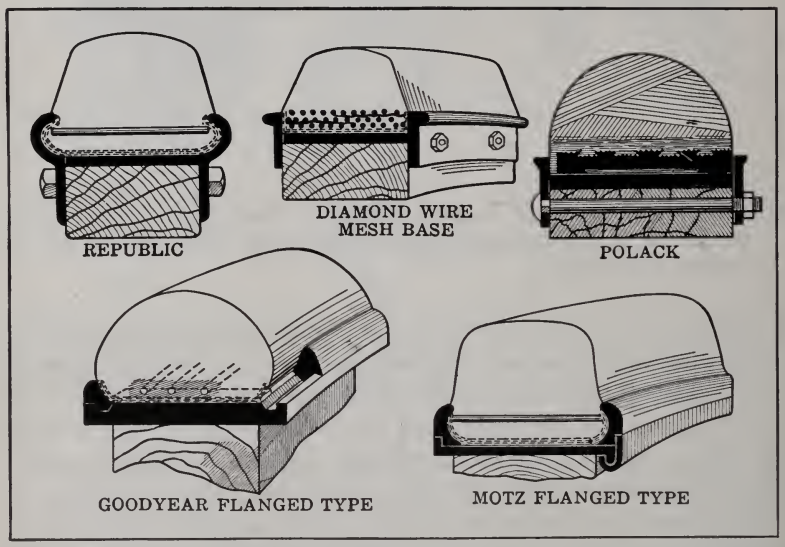


Fig. 643.—Outlining Construction and Methods of Fastening Solid Rubber Tires to Wheels.

of very large size to carry the loads imposed by the usual heavy truck chassis and loaded body. As the speeds of these vehicles are not very high, solid-rubber tires may be employed to advantage. These are molded from special rubber compositions in one continuous ring, and they are usually provided with some form of metal reënforcement at

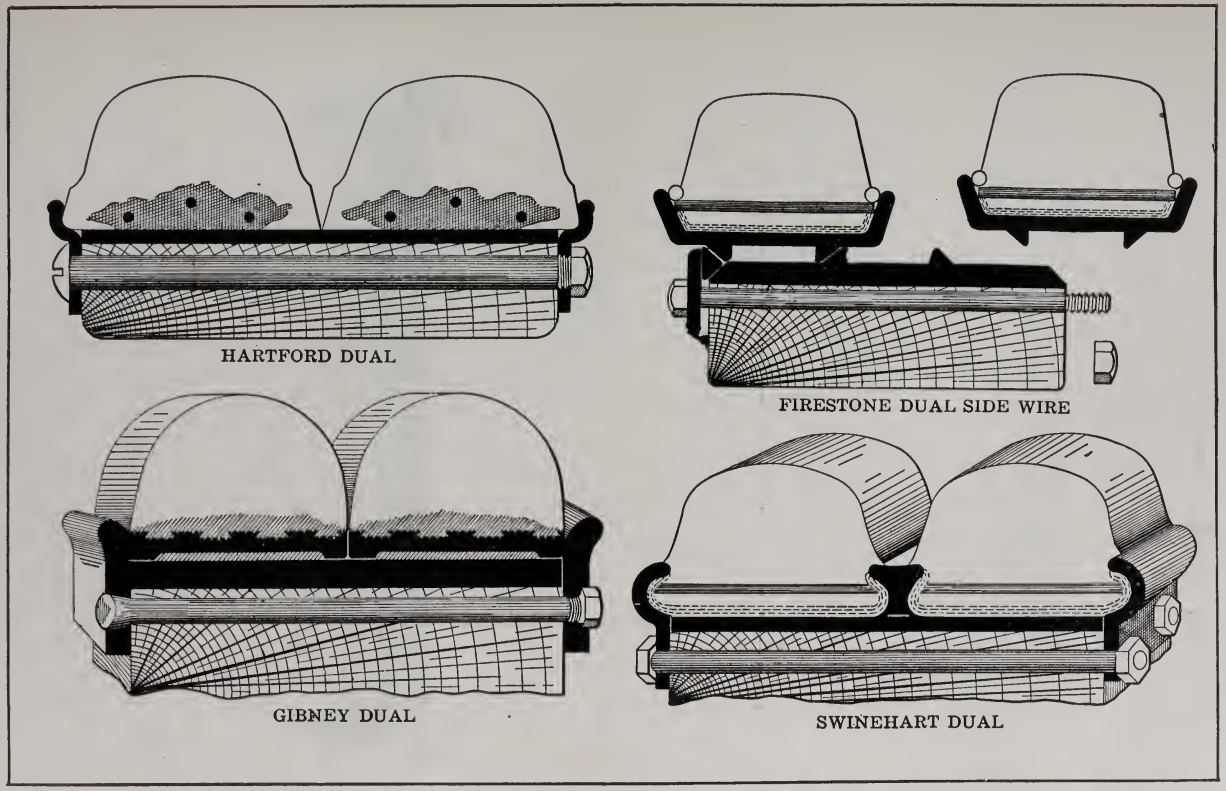


Fig. 644.—Twin Type Solid Tires for Heavy Motor Trucks and Methods of Holding Members in Place on Wheels.

the bottom which insures that they will clamp tightly against the rim or the felloe band. Various forms of quick-detachable rims have been evolved to hold these members in place, and the metal reënforcements at the bottom vary from simple transverse wires to continuous bands of steel molded integral at the base of the rubber rings.

A number of solid tires and methods of attachment are clearly shown at Fig. 643. Single tires of this form are used on the front wheels of practically all trucks, though the rear members are generally supplied with dual tires, which have greater carrying capacity and which also lessen the dangers of side slip on wet pavements. When twin tires are used it is desirable that they be installed in such a way that they can be readily removed from the wheel for replacement in event of wear, and it is also thought necessary to provide means of attachment of such nature that they can be removed independently, if desired. Various dual tire forms and the method of holding them in place are shown at Fig. 644. The construction outlined at Fig. 645 shows the application of wedges to lock the solid-rubber tires firmly to the wheel.

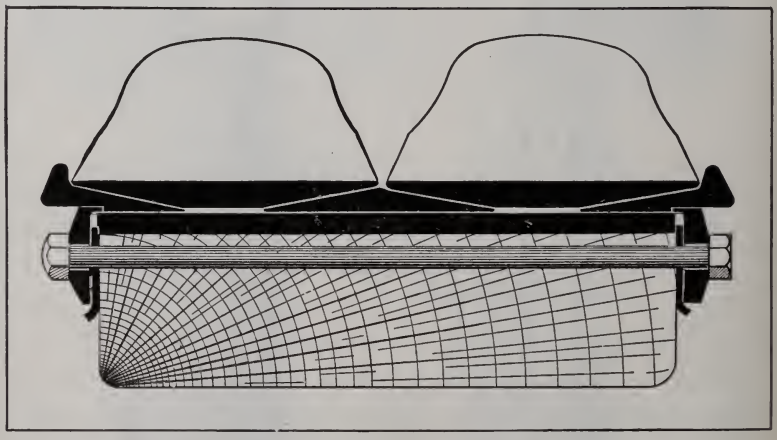


Fig. 645.—Hartford Detachable Twin Solid Tire Construction.

When solid-rubber tires were first applied to trucks they were of such form that special machinery was needed to install them, and the work could only be done at depots where this form of machinery formed part of the equipment. When accident to the tire or natural wear made it necessary to replace the worn member with a new one

the wheel had to be removed from the truck and sent to the tire company's station to be fitted up with tires. This meant a loss of time of some magnitude, which has been entirely overcome by the new demountable construction. Spare tires may be carried in stock and may be used to replace the damaged members without the use of special applying machinery in most instances and without necessitating the removal of the wheel.

Tools and Supplies for Pneumatic Tire Restoration.—It has been previously stated that one of the chief disadvantages of pneumatic tires has been their liability of failure by puncturing the outer casing and penetrating the inner tube and thus providing a means for escape of the compressed air in the inner tube. The life of a pneumatic tire is decidedly uncertain and will depend on many factors outside of those of purely natural wear. . There have been cases where outer casings have given satisfactory service for seven or eight thousand miles, but these instances have been the exception rather than the rule. It is the opinion of most motorists who have had practical experience that if an ordinary set of shoes will give a service averaging two thousand miles that they are equal to the demands made upon them and that they are satisfactory. It may be stated that tires will last longer on light cars than heavy ones and the service obtained from tires fitted to vehicles driven at low and moderate speeds will be much greater than that obtained from tires fitted to high-speed vehicles. There is also a personal element which must be taken into consideration, and that is the way that the car is driven and the care taken of the shoes and inner tubes.

It is necessary, therefore, in all cars using pneumatic tires to carry a certain amount of equipment for handling and repairing these on the road. A typical outfit is shown at Fig. 646, this consisting of a spare outer casing, two extra inner tubes for replacement purposes, a blow-out sleeve, a number of patches, and an acid-cure vulcanizing outfit or small flame for applying them. Tire irons must be provided to remove the casing from the rim; the jack is used to raise the wheel of the vehicle on which the defective tire is installed from the ground and make it possible to remove the tire completely from the wheel. The air pump is needed to inflate the repaired tube or the new member inserted to take its place. The talcum powder is sprinkled between the casing and the tube to prevent chafing or heating, while the spare valves and valve tool will be found useful in event of damage to that important component of the inner tube. As it is desirable to inflate the tires to a certain definite pressure, a small gauge which will show the amount of compression in the tire is useful.

The outfit shown may be supplemented by other forms of vulcanizing sets and by special tire irons to make for easier removal of the outer casing. Tire irons vary in design, and most makers of tires provide levers for manipulating the casings, which differ to some

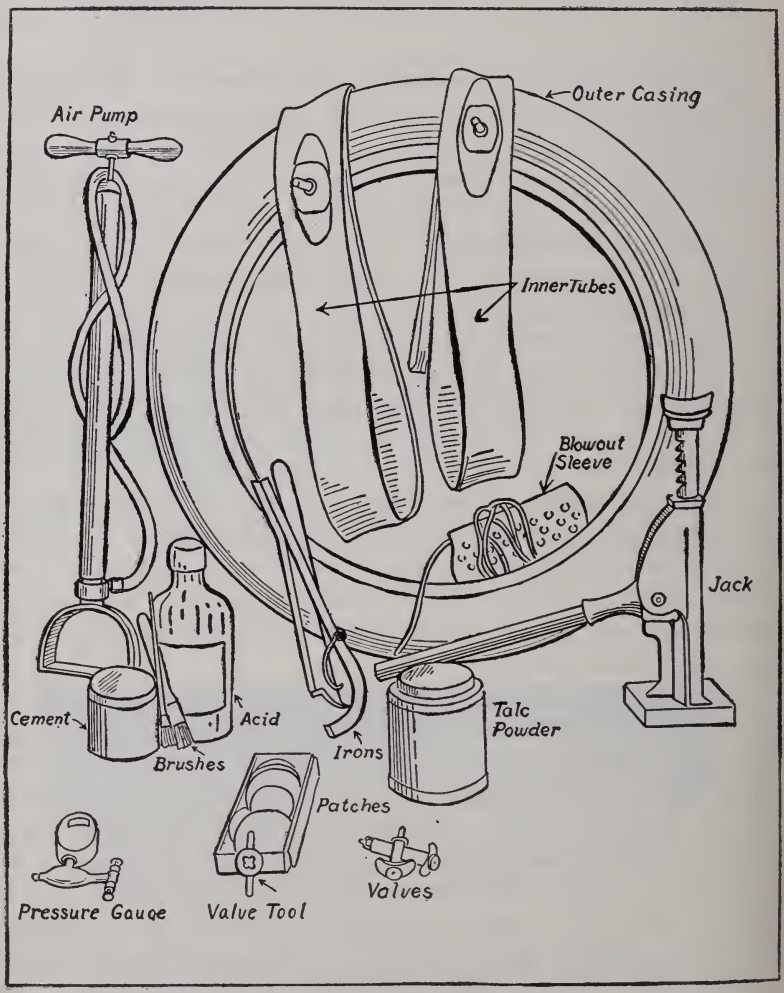


Fig. 646.—Spare Parts and Necessary Repair Equipment for Automobiles Using Pneumatic Tires.

extent. A set of tire irons such as would be needed with a clincher-tire equipment could be selected from the forms shown at Fig. 647. That shown at A is utilized to loosen the clincher bead from under

the rim should it become rusted in place. After the shoe has been loosened from the rim flange one of the levers of the form shown at B, C, or D would be inserted under the bead in order to lift it over the rim. Two or more of these levers are provided, and the length and form will vary with the preference of the motorist. It will be remembered that the longer levers are more easily operated than the short ones, and that the length of the lever provided will depend entirely upon the size of the tire to be removed. Demountable and quick detachable rims are so widely used at the present time that only the simplest forms of irons will be needed.

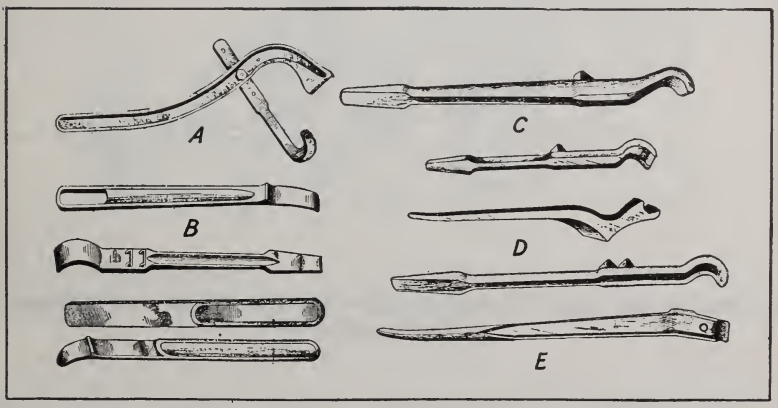


Fig. 647.—Forms of Tire Irons Used in Removing and Repairing Clincher Type Casings.

Motorists, as a rule, should carry the releasing lever shown at A, two of the short members depicted at B, and one longer lever, such as the upper one of group C, or the forms D or E. The latter is a combination form which may be used as a jack handle as well as a tire iron, and when it is supplied it is not necessary to carry a jack handle in the equipment. The flattened ends are generally employed for prying the bead from the clincher rim, and when this has been done and sufficient space exists between the bead and the rim to insert the curved end of the larger levers, considerable leverage is obtained and the bead may be lifted over the clincher rim without undue exertion. The object of rounding the corners, and of making the working portions as broad as possible, is to reduce the liability of pinching the inner tube, which would be present if the irons had sharp edges.

The tire-repair material is sometimes carried in a special case, as shown at Fig. 648, this consisting of all parts necessary to make

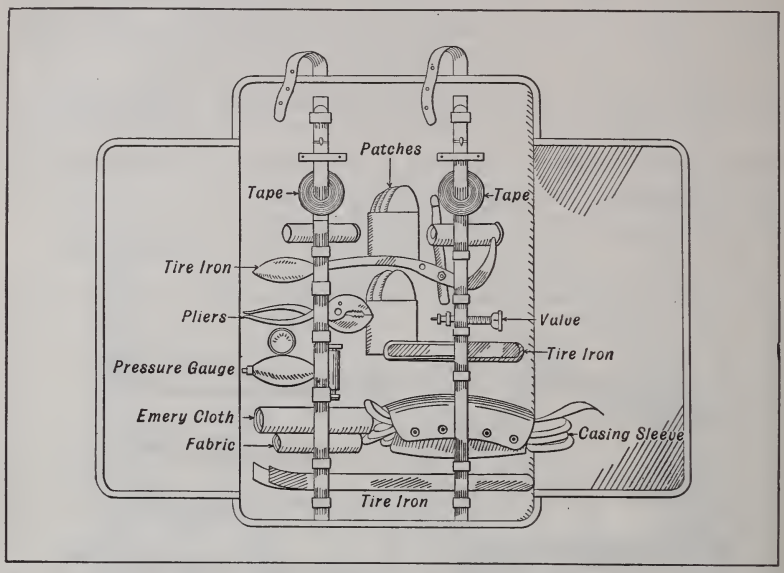


Fig. 648.—Small Repair Kit, Containing Tools and Supplies for Emergency Tire Repairs.

temporary repairs to be considered in proper sequence. This outfit is sometimes supplemented by the special tools shown at Fig. 649.

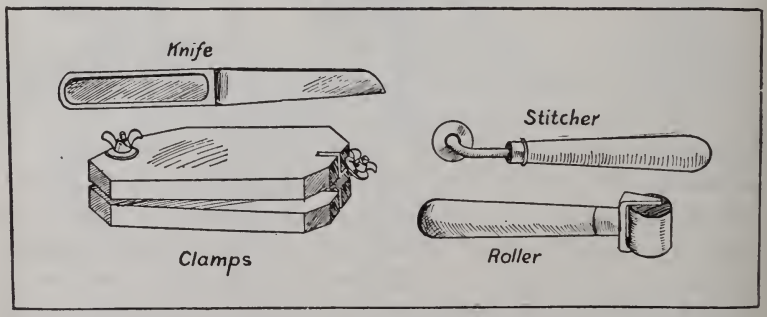


Fig. 649.—Tools Found Useful When Patching or Repairing Inner Tube.

The knife is used to cut the rubber, trim patches, etc. The stitcher and roller are useful in rolling the patch after it has been cemented to the tire to insure adhesion of the patch with the tube, while the wooden clamps are useful in binding the patch firmly against the

damaged portion of the tube while the cement is drying. Some motorists carry small vulcanizers in order to effect more permanent repairs than would be possible with the simple patching processes, in which the adhesive powers of cement are utilized. A

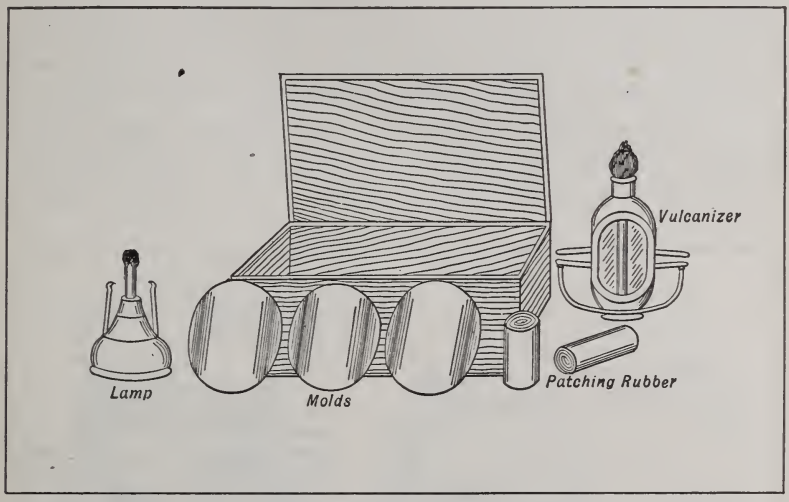


Fig. 650.—Portable Vulcanizer Outfit for Filling Cuts in Outer Casings or Patching Inner Tubes.

simple steam vulcanizer and molds for use in connection with it are shown at Fig. 650, and an acid-cure vulcanizing set which does not make use of any form of heating apparatus is shown at Fig. 651.

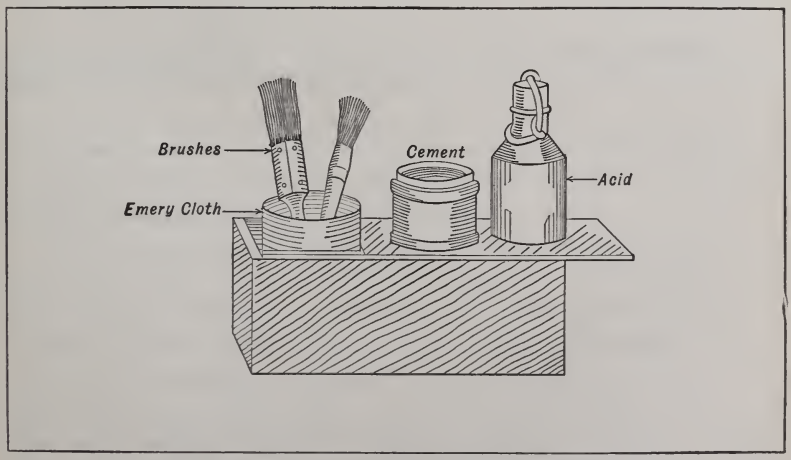


Fig. 651.—Acid-Cure Vulcanizing Outfit.

The acid-cure outfits are now seldom used on account of the simple flame and solid fuel vulcanizers now available. A simple vulcanizer is shown at Fig. 652. It consists of a pair of arms terminating in a stationary disk and a swiveled disk with a cupped upper surface; the cupped piece is on the upper arm and the two disks are pressed together with the tube to be repaired between them by means of a thumb-nut. The heating medium is a disk of prepared fuel which is placed in the cup of the upper disk and ignited with a match. It burns, or rather glows, without flame and produces exactly the heat required. Patches are applied without cement. The process is to clean the tube, apply the patch, clamp it in the vulcanizer, light the

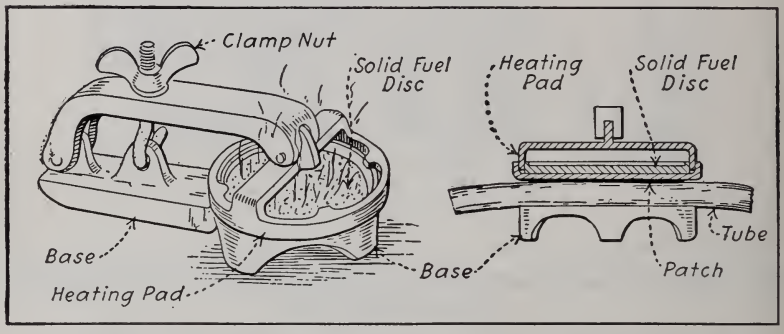


Fig. 652.—Simple Flame-heated Vulcanizer, Using Solid Fuel Disks.

disk and let it stand for eight minutes after lighting. A patch so vulcanized cannot be removed without tearing up the tube. Fuel disks and patches are supplied with the vulcanizer.

Tire-Manipulation Hints.—In removing or replacing outer casings considerable care must be exercised not to injure the shoe or pinch the inner tube. The first step is to jack up the wheel from which the defective tire is to be removed, this relieving the wheel of the car weight. The valve inside is then unscrewed in order to allow any air that may remain in the tube to escape, and then the lock nuts on the valve stem are removed so that these members may be lifted to release the clincher beads from the rim channels. If the tire is stiff or has not been removed for some time, a special iron, such as depicted at Fig. 653, is utilized in the manner shown, and the beads are pushed clear of the clincher rim. When the casing has been loosened on one side, a flat tool, such as shown at Fig. 647, B, is inserted under the loose bead to act as a pry or lever to work the edge of the casing gradually over the rim.

Very long levers are necessary to handle heavy, stiff clincher tires, and new casings are particularly hard to remove. The shorter irons may be employed on the smaller casings and on shoes which have been used for some time and which are more pliable than the new ones. Two of the levers are generally used together, one being kept under the loosened edge of the bead, while the other is used to force the bead over the edge of the rim. When the outside edge of the bead has been forced over the rim at all points the inner tube is lifted from the rim and is pulled out of the shoe. The start at removing is made at the point diametrically opposite the valve stem. When this portion has been pulled clear of the rim and out of the casing it is

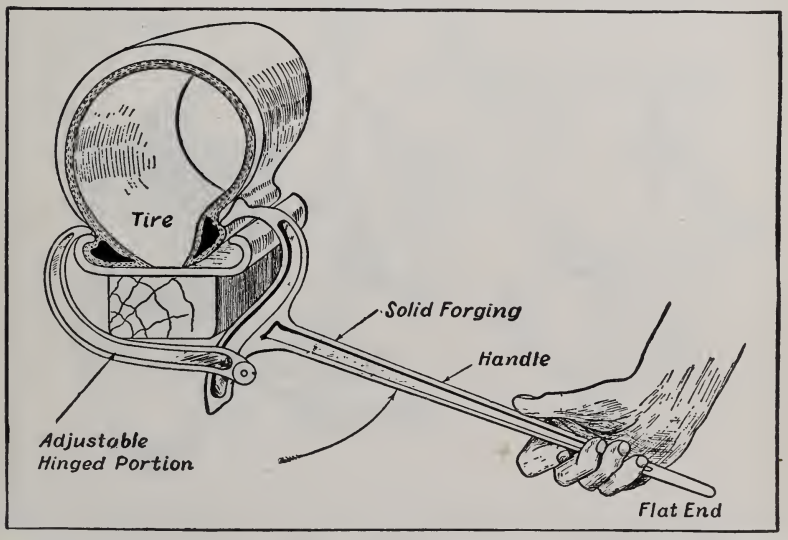


Fig. 653.—Special Appliance for Loosening Clincher Shoes from Rim of Wheel.

not difficult to pull the rest of the tube out and finally lift the valve stem out of the hole through which it passes in the wheel felloe, and take the inner tube entirely off the wheel.

If the casing demands attention, or if a new case is to be used, the inside bead is worked over the channel of the clincher rim in just the same manner as was done with the outside bead, and after a start has been made and a portion of the inside bead forced over the rim there will be no difficulty in slipping the entire shoe from the wheel. Applying a tire is just the reverse to removing one. The first operation is to place the inner bead of the tire in position in the center of the rim by forcing it over the outside flange. This is

done gradually, and in order to force the remaining portion of the shoe it may be necessary to use long levers when the greater part of the casing has been applied. The next step is to work the shoe gradually toward the inner channel of the rim, then to insert the security bolts in the holes made to receive them.

The inner tube is replaced after it has been partially inflated by putting the valve stem in first and then inserting the rest of the tube, being careful not to pinch it under the heads of the lugs or security bolts. After the inner tube has been put in place the outer bead of the tire is worked over the edge of the rim, the portion adjacent to the valve stem being inserted first. When working the

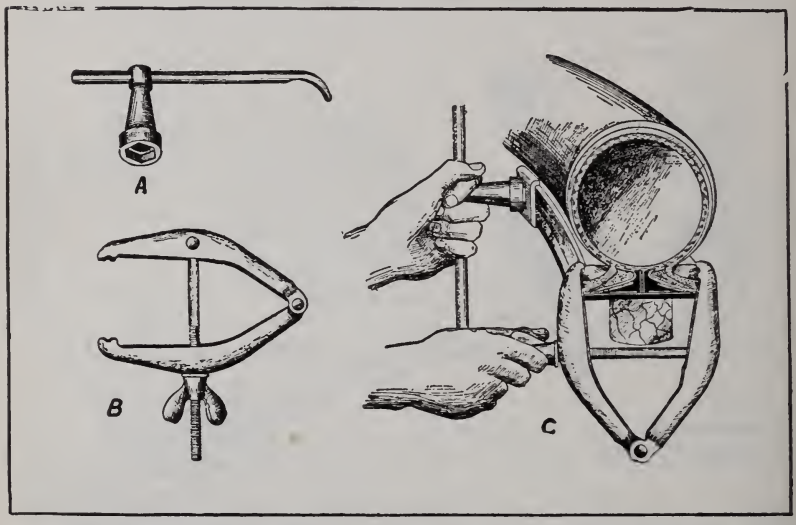


Fig. 654.—Tools for Removing Early Type Fisk " Bolted On " Casing and Method of Using Them.

remainder of the bead over the rim channel much care must be exercised to insure that the inner tube will not be pinched by the sharp edges of the tire levers. The object of partially inflating the inner tube is to distend it so there are no loose or flabby portions that are liable to catch under the tire bead when this is being forced in place over the wheel rim.

The mechanically fastened tires are much easier to remove than clincher shoes, because after the retaining rims are taken off the wheels the outer casings can usually be pulled right off the flat rim. The tools and the manner of using them employed in taking

off Fisk bolted-on tires are shown at Fig. 654. The clamp is employed when replacing the shoe and it serves to hold the retaining ring and the bottom of the shoe closed in such a way that the nuts on the through bolts may be easily tightened up by using a socket wrench depicted at A. This wrench has a T handle with a hook end, and this hook is sometimes of value in prying off a retaining ring that has become rusted in place. The method of handling these tools and this type of tire is so clearly shown that further description seems unnecessary.

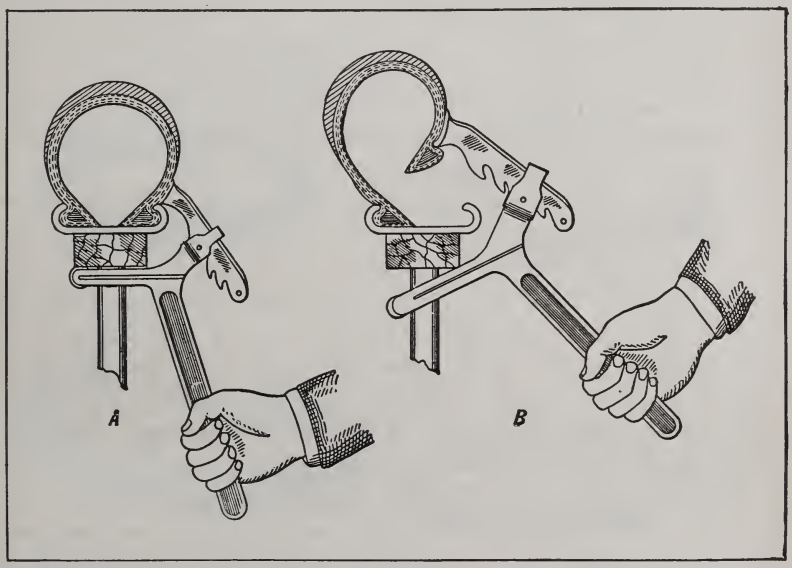


Fig. 655.—Adjustable Fixture for Loosening Casings that Have Stuck to the Rim.

Tire-removing tools are made in many forms, and more have been devised for use with clincher type of casings than the other forms because the beads on these casings sometimes become so firmly imbedded in the rim channels that it is extremely difficult to remove them, especially if the shoe has been on the rim for some time. Another form of removing tool possessing a certain amount of adjustability which makes it adaptable for use in connection with varying sizes of clincher casings, and the method of use, is shown at Fig. 655. In this form the main or handle portion has a piece extending from it that carries a rubber roll designed to pull against the spoke. The part that bears against the shoe is a separate piece, provided with a number of hooks to make it possible to alter its position as desired. For use with a small tube the uppermost notch is used, and as the

shoes become larger the notched piece is pulled farther up in the slot in which it slides on the head of the Y-shaped handle. Tools of this nature are extremely useful and should form part of the equipment of every motorist who uses clincher tires.

How to Remove Demountable Rim.—Before jacking up the car loosen all the bolts except the two nearest the valve stem (one on either side) until the wedges swing out of the way. Screw up the bolts in this position enough to hold the wedges from swinging back. Loosening the bolts before jacking up the wheel simply causes the weight of the car to hold the wheel steady while you are working on it. Then put the jack under the axle. Insert the point of screwdriver between the rim and felloe band opposite the valve stem, and force the end held in the hand toward the hub of the wheel. This will pry the rim off the wheel at this point, and by revolving the wheel until the valve stem is up, the rim can be easily slipped off.

To Replace Rim.—To put the extra tire and rim in place, insert valve stem and again revolve until the valve stem and the two stationary wedges are nearest the ground. Now remove the jack and throw the weight of the car on the rim at this point. Back out all the bolts which were loosened far enough to allow the wedges to be turned back into place. Then tighten the bolts until the little studs on the inside edge of the rim rest on top of the felloe band. If they do not slide on easily, insert the tool and pry the studs onto the band.

To Remove Tire from Rim.—To take the rim out of the tire, lay the rim and tire flat so that the end of the cut farthest from the valve stem is up. Remove the anchor plate, then, beginning at the short end of the rim which does not have the valve stem, insert the end of tool under the head of the tire.

Force down the end of the tire tool held in the hand. This pulls the end of the rim out of the tire. It will be noted that, in this operation, the two short sides of the rim are brought together, thus reducing the circumference of the rim. Repeat the operation as often as necessary, inserting the tool about six inches further around each time.

Now turn the rim and tire entirely over as shown in Fig. 656, A, and force the tire tool between both beads of the tire and the rim. This entirely frees one end of the rim.

As in Fig. 656, B, take the free end of the rim in the hands, and, holding the tire with the foot, pull the rim entirely out of the tire.

To Replace Tire on Rim.—To replace the tire on the rim, first insert the new tube slightly inflated, and note that it lays smooth and even all around. Lay the rim flat on the floor with the tire on the rim as in Fig. 656, C. Raise the end of the rim that has been

drilled for the valve stem and after the valve stem has been inserted, put both beads of the tire entirely into the end of the rim that has been raised up for a distance of about six inches. Be sure that the other end of the rim is still under both beads of the tire. Being sure that the beads of the tire are properly started and that the tube is not being pinched, follow all the way round, putting both beads entirely on the rim as you go. Do not permit the other end of the rim to slip into the tire until the very last. Having fitted the tire properly to the

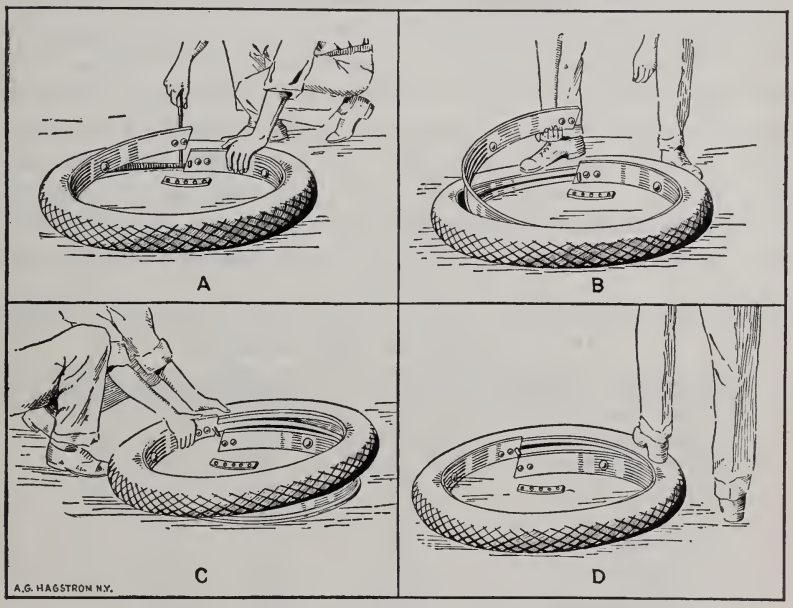


Fig. 656.—How to Remove Demountable Split Rim from Tire.

rim put the anchor plate in position and screw down the valve stem nut when the tire is ready to be inflated. Before putting the rim into the tire rub a paste made of powdered graphite and water on the beads of the tire. This prevents them sticking to the rim.

Rules for Tire Selection and Inflation.—The tires used on motor cars are generally selected by considering the amount of load sustained by the wheels of the cars, but considerable difference of opinion seems to obtain regarding the way the weights should be estimated. Tire manufacturers believe that the entire weight of the vehicle with all possible equipment and passengers must be considered, but there have been cases where a car has been supplied with tires that were inadequate because only the weight of the car was considered in making the selection and the added load of passengers

and equipment was disregarded. It is believed desirable to provide rear tires that will be twenty-five per cent larger than those needed merely to support the weight of the rear end of the vehicle, because in the majority of cases these members are called upon to sustain stresses incidental to traction as well as the strains produced by the vehicle weight.

It is customary to use one size tire on the four wheels, the thought being that the shoes from the front wheels, which are not subjected to the severe service that those on the rear are called upon to endure, can be placed on the rear wheels when those casings become weakened by use, and their place taken by the weakened rear shoe, which may have sufficient capacity to do the work expected of front-wheel tires. The following table gives the proportion between vehicle weights and tire sizes that are commonly accepted by tire manufacturers. These figures are based on the maximum permissible weight of a car without passengers, but as they do not consider the factor of possibilities of overload, and if a motorist is having tire

PROPORTIONS BETWEEN AXLE LOADS AND TIRE SIZES ADOPTED BY AMERICAN TIRE MAKERS

2½-inch tires, all diameters	225	pounds	per wheel
3 inch tires, all diameters	350	"	" "
3½ x 28-inch tires	400	"	" "
3½ x 30-inch tires	450	"	" "
3½ x 32-inch tires	555	"	" "
3½ x 34-inch tires	600	"	" "
3½ x 36-inch tires	600	"	" "
4 x 30-inch tires	550	"	" "
4 x 32-inch tires	650	"	" "
4 x 34-inch tires	700	"	" "
4 x 36-inch tires	750	"	" "
4½ x 32-inch tires	700	"	" "
4½ x 34-inch tires	800	"	" "
4½ x 36-inch tires	900	"	" "

For weights in excess of 1,000 pounds per wheel, 5-inch tires and over are recommended. Weights given apply to car without passengers.

troubles, it would be well to provide tires that are oversize and of more than sufficient capacity. Such members are not only more enduring than shoes which are barely up to the requirements, but they are not liable to blow out or deteriorate as fast as overloaded tires.

Next to the selection of proper size tires the important consideration is that these be kept properly inflated. If a tire is not properly filled with air it will flatten out, and the tendency will be to separate the layers of fabric and rubber of which the shoe is com-

posed, because of the alteration of the almost round or tubular section that the tire is supposed to be when in use. If a tire is properly inflated the walls will be braced from inside by the pressure of the compressed air in the inner tube, and the flattening effect will have no perceptible effect in producing disintegration of the fabric and rubber plies of the casing. The figures given in tables which follow are those recommended by leading tire manufacturers as being most suitable for the various sizes of tires listed.

These usually take into account the increase in temperature and resulting pressure of the air created by the friction between the tires and the roads caused by prolonged running. A French authority has made a series of tests to determine what the increase of pressure would be on tires from three to four and a half inches in diameter under usual touring-car service conditions. These results are presented in tabular form and should prove very interesting. The increase with larger tires is greater in proportion because the walls of the casings are heavier and stiffer and greater internal strains are produced in the fabric by the distortion of the shoe at the points of bending.

AIR PRESSURES FOR INFLATING PNEUMATIC TIRES RECOMMENDED BY LEADING MAKERS

Diameter of Tire, Inches	Maximum Weight on Wheel, lbs.	Air Pressure in Tire, lbs. per Square Inch
2½	225	50
3	350	60
3½	600	70
4	750	80
4½	1,000	90
5	1,000	90

INCREASE IN AIR PRESSURES CAUSED BY DRIVING

Initial Pressure in Tire, Cold	Working Pressure in Tire, Warm	Increase Resulting from Work
Lbs. per Sq. In.	*Lbs. per Sq. In.*	*Lbs. per Sq. In.*
71.116	88.183	17.067
85.339	105.750	20.411
99.562	123.546	23.984
113.785	141.920	28.135
128.008	158.588	30.580
142.232	176.368	34.136

The conventional method of inflating tires by using a foot pump does not always insure that the tire will receive adequate inflation,

and when a pump is employed it is imperative that some form of gauge be provided that will register the amount of pressure inside of the tire in order that it will reach the figure recommended by the tire makers. Different methods of tire inflation have been devised which eliminate the necessity of using manually operated pumps. Obviously a simple expedient would be to provide a small power-driven pump that could be actuated by any convenient mechanical connection with the engine. Another method is to use an air bottle, which is a steel container in which air is stored under great pressure. The air is compressed to such a point that a tank less than two feet long and six inches in diameter will furnish sufficient air to inflate seven or eight tires of average size, or twelve to fourteen small ones. The tanks may be exchanged at small expense when exhausted for new containers holding a fresh supply of air. In some tanks gases of various kinds under high pressure are used and the motorist may obtain these on the same basis as air bottles are supplied.

All devices of this character are fitted with gauges to indicate the amount of pressure in the tire, and to prevent overinflation. If a tire is not properly inflated the shoe will be liable to various kinds of road damage and will be easily punctured, while if the pressure is too high the shoe is liable to "blow-out" at any weak point in the structure. A tire-pressure gauge is a very necessary article of equipment in any car and its proper use when blowing up tires will insure the best possible results if the schedule recommended by the tire manufacturers is adhered to.

Tire Repair and Maintenance.—The common causes of tire failure that the motorist is apt to encounter are shown at Fig. 657. The most common is natural wear of the tread portion of the tire. The rubber compound in contact with the road surface wears away in time, and the fabric layers which constitute the breaker strips are exposed. The shoe is weakened and any sharp object in the road is apt to penetrate the weakened case and puncture the inner tube. If a number of the layers of fabric comprising the body of the shoe are cut this constitutes a weak place in the casing and a blow-out will result because the few layers of fabric remaining do not have sufficient strength to resist the air pressure.

A stone bruise is caused by the removal of a portion of the rubber tread by a sharp stone, piece of glass, etc., and is much more serious than a puncture because it removes some of the tire, whereas in ordinary cases of puncture a sharp object merely penetrates the casing. A sand blister is produced by sand or grit from the road working

into a space in the tire between the tread and the fabric body through some neglected incision or bruise. The side of the tread is often chafed by running the tires against curb stones or by driving in car

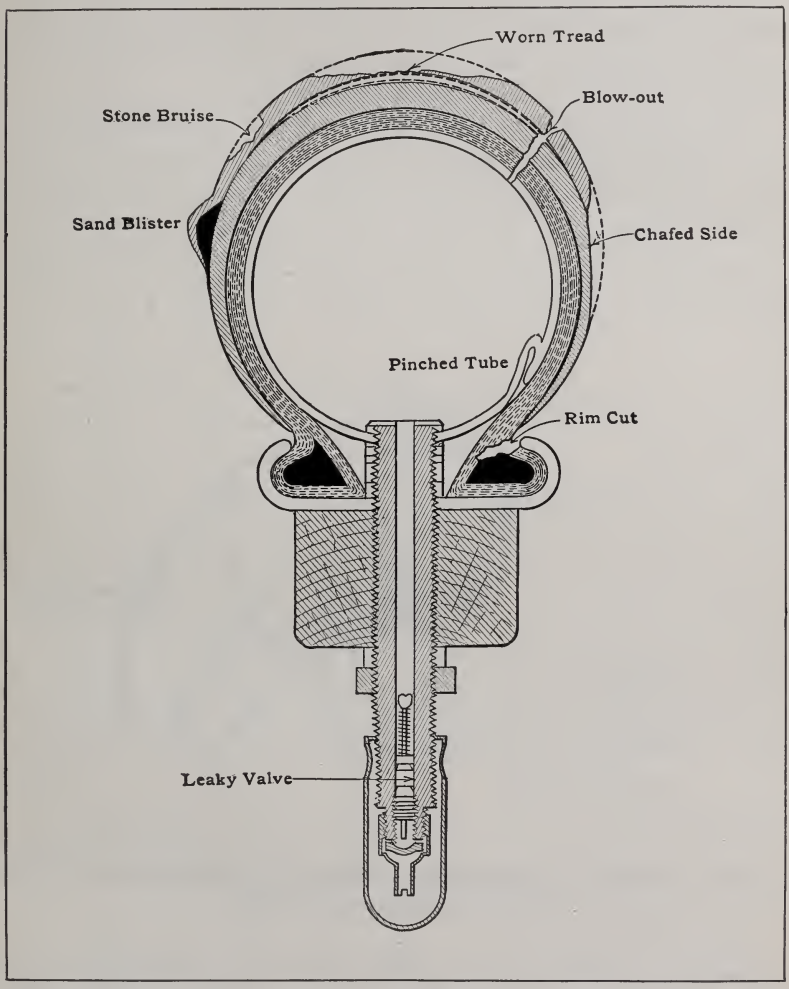


Fig. 657.—Sectional View of Pneumatic Tire, Showing Some Conditions which Cause Failure of Casing or Inner Tube and Sometimes Both.

tracks. Rim cutting is generally caused by insufficient inflation which permits the rim to cut into the tire and thus tends to sever the bead from the side of the shoe.

The chief inner tube trouble is penetration of the wall by some sharp object, or the folding over of part of the tube walls when the

tire was applied. The parts of the check valve sometimes give trouble and the valve leaks. In cases of valve trouble it is usually cheaper to replace the valve inside than it is to attempt to fix it. Some of the causes of valve leakage are hardening of the rubber washer, bent stem, which prevents the valve from seating properly or a particle of dust or other foreign matter which would act to keep the valve from closing the air passage positively.

The most serious condition that a motorist will meet with is a "blow-out" and usually only temporary repairs can be made on the road. The common methods of restoring a defective outer casing are depicted at Fig. 658. In this an inner sleeve, which is composed of

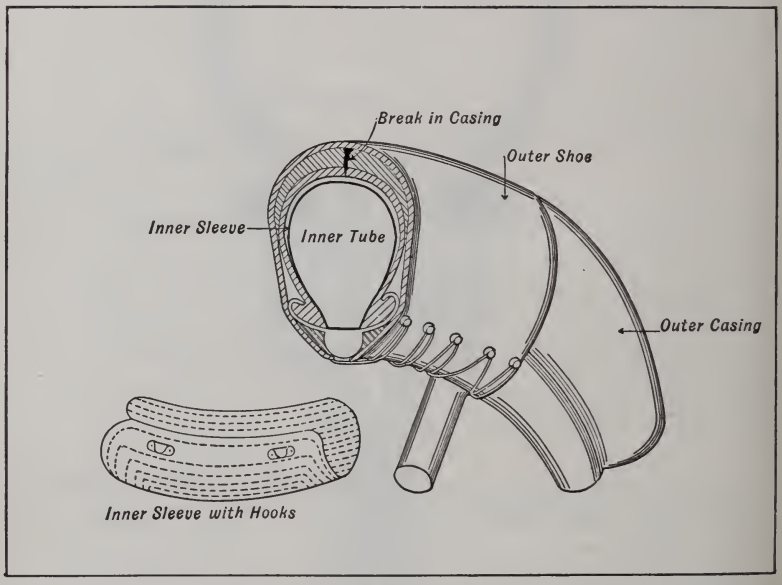


Fig. 658.—Temporary Casing Repairs Possible when Small Blow-out or Large Puncture Occurs on the Road.

a number of plies of fabric, is placed between the inner tube and the broken portion of the outer casing to prevent pinching of the inner tube by the jagged edges of the cut, and to strengthen the casing from the outside an outer shoe or gaiter made of leather is laced around the shoe. The object of using both inside and outside reënforcing members in combination is to not only strengthen the weak outer casing but by providing an outer shoe dirt is kept from working into the tire.

Punctured inner tubes may be temporarily repaired by using

a cemented surface patch. The first step necessary is to clean the surface of the tube very thoroughly with gasoline and then to rough up the surface of both patch and portion of the tube surrounding the holes with a wire scratch brush or with sandpaper. After the surfaces are properly cleaned and roughened the patch and the tube are coated with suitable patching cement which is allowed to become thoroughly dry before the second coat is applied. The second coat is allowed to become "tacky," which expresses a condition where the cement is almost dry and yet still possesses a certain degree of adhesiveness. The patch is applied to the cemented portion of the tube and the whole is clamped firmly together to secure positive adhesion while the cementing medium is drying. Patches should always be of sufficient size to cover the damaged portion and at the same time have about three quarters of an inch or more of the patch at all sides of the orifice.

Very satisfactory repairs to both inner tubes and outer casings of a permanent nature can be made by using small portable vulcanizers which may be heated by either electricity or vapor. When these are used a special vulcanizing cement is necessary and uncured rubber stock must be used for patching or filling openings caused by punctures or blow-outs. The patch of raw material is applied to the cemented surface of the tube or casing and the vulcanizer heated to the proper temperature. The heat of the vulcanizer causes the rubber of the patch to unite perfectly with the old material and forms an intimate bond. The view of the inner tube at Fig. 660, B, shows various-sized holes and sizes of patches to use in making repairs. It also shows defects that cannot be patched but which must be vulcanized.

In vulcanizing the most important precaution is to maintain a proper temperature. Too great a degree of heat will burn the rubber, while a proper cure cannot be effected if the temperature is too low. The temperatures recommended for vulcanizing vary from 250 to 375 degrees F. The lower degree of heat is used in working material that has been previously cured, while the higher temperature is recommended for new rubber. A number of small portable vulcanizers and their method of use is shown at Fig. 659. In the view at A the vulcanizer is heated by electric current and is provided with two faces, one flat, designed for use against inner tubes, and the other curved to conform to the curvature of outer casings. In the view A the vulcanizer is shown with the flat face in use, while at B it is shown clamped to an outer casing with the curved face in contact with the tread. The heat is obtained by passing a current of elec-

tricity through suitable resistance coils imbedded in the body of the device.

Where electric current is not available various forms of flame-heated vulcanizers may be used. In that form depicted at C the

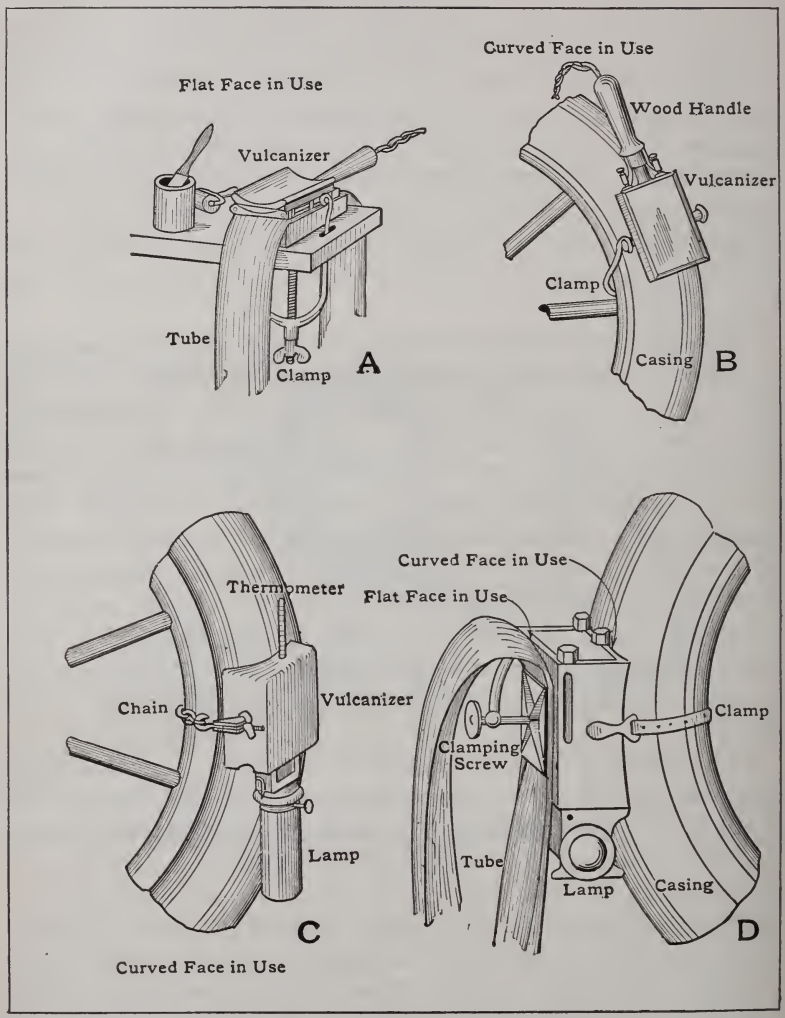


Fig. 659.—Methods of Using Small Electric or Vapor Vulcanizers on Tube and Casing Work, a Very Convenient Method of Effecting Permanent Repairs.

vulcanizer body is filled with water, which is converted into steam by the heat of a flame furnished by the alcohol lamp that forms part of the device. This form of vulcanizer is provided with a flat face

as well as a curved one and can be used for either inner tube or outer casing restoration. A combination vulcanizer which is composed of a large hollow cast-iron body filled with water and heated with a spirit lamp is depicted at D. In this the curved face and the flat face may be used simultaneously and an inner tube patched at the same time that the outer casing is being treated. As very complete instructions are furnished with these small vulcanizers, any motorist may become familiar with their use without much difficulty. A simple and cheap flame vulcanizer of late design is shown at Fig. 660, A. The

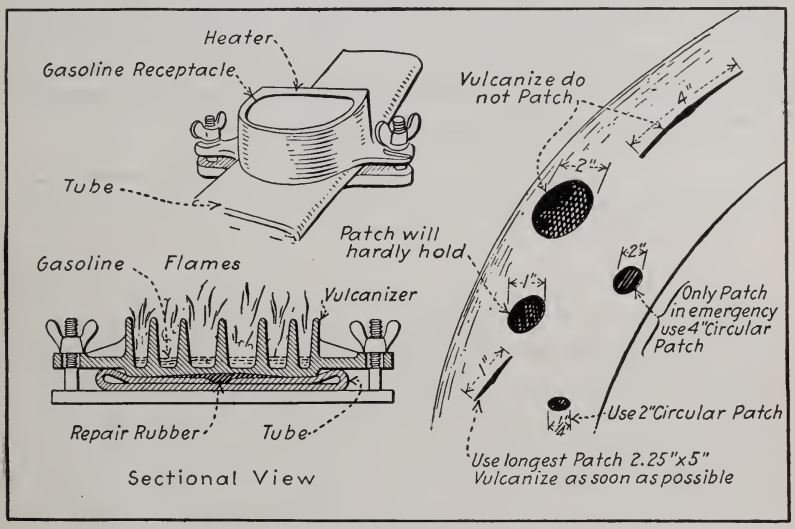


Fig. 660.—Simple Flame-heated Vulcanizer for Tube Repairs Burns Liquid Gasoline, as Shown in Sectional View. B—Sizes of Punctures and Patch Sizes to Be Used in Sealing Them.

heating portion consists of a simple casting having a number of projecting fingers which are heated by the flame of burning gasoline. A definite amount of fuel is poured into the heater and ignited and after this has burnt itself out enough heat will have been imparted to the casting to produce satisfactory vulcanization of the repair material placed in the defective portion of the inner tube. These small vulcanizers are intended primarily for the use of the motorist in making minor repairs and are not practical tools for the tire repair shop, though they may be used to advantage in small garages where no attempt is made to carry on tire repair work on a large scale.

The rules to secure satisfactory operation from pneumatic tires may be easily summed up. In the first place it is imperative that

the tires be inflated to the pressures recommended by the manufacturers and that they be selected with a certain margin of safety over the actual requirements. The tires should be kept clean and free from oil or grease because the oleaginous substances used for lubrication very quickly attack rubber compounds and cause crumbling and rapid deterioration. Oil or grease should be wiped off as soon as noticed and the tire cleaned by the application of gasoline. Any small cuts or openings in the tire that may permit water to enter or sand to work between the fabric and the tread will cause trouble in time. One should be careful in driving not to apply the brakes too suddenly because this will lock the wheels and wear the tire very quickly. Care should be taken not to drive in car tracks, and when highways do not have the proper surface they should be negotiated very carefully to avoid cutting the casings.

CHAPTER XIII

AUTOMOBILE STARTING AND LIGHTING SYSTEMS

Self-Starters for Gasoline Engines—Types of Starters—Features of Ignition Starters—Compressed-Air Starting Systems—Electric Starting Systems—One Unit Systems—Two Unit Systems—Function of Generator—Types of Generators—Storage Batteries—Automatic Controls—Circuit Breaker—Governors—Ampere Meter—Auto-Lite Starting System—Delco Starting System—Typical Starting Motors—Automatic Pinion Shift—Overrunning Clutches—Electric Lighting Systems—Bulbs and Lamp Forms—Combination Lamps—Novelties in Electric Lamps—Kemco Fan Generator—Care of the Storage Battery—Battery Charging Methods—Inspection and Care of Generator and Starting Motor—Lamp Troubles and Their Causes.

Self-Starters for Gasoline Engines.—One of the disadvantages of the gasoline engine which has been often advanced by those favoring steam or electric power is that it is difficult to start it in some cases, and various means were devised to overcome the objection advanced. The early gas engines fitted with poorly designed carburetors and inadequate ignition systems were often difficult to set in motion, but as the gasoline engine was improved and the multiple-cylinder form gained in favor, those used during the past few years have been exceptionally easy to start by some form of starting handle or crank, and often a quarter turn of that member is sufficient to set the engine in motion if it was in proper adjustment and the various auxiliary groups were functioning properly. At the present time the improvements made in the gasoline automobile have been more in the nature of detailed refinement and those engaged in producing motor cars have studied more carefully the various points which make automobiles more convenient and more easily operated. The requirements of the present day cannot be met solely by easy cranking because this feature is common to all automobiles, from the smallest runabout to the heaviest touring car or truck.

The present demand is for engines that are equipped with some form of mechanism which will make them self-starting, that is, so that they may be set in motion by merely pressing a button or pushing a valve from the seat and not by the usual form of hand crank

at the front of the car. The starting handle has always been a danger point and many broken arms and fractured wrists have resulted from a premature explosion of gas in the cylinders which forced the starting handle backward and against the arm or hand of the person starting the engine. Motor-car control has been simplified to a point where many women are running cars, but the average motor requires the expenditure of more strength than that possessed by the average woman or young person to start it. When a separate starting device is fitted the motor may be started as easily by a person lacking in strength as by one who can "spin" the engine around at will.

Self-starters operate on two principles. First, that in which the crank shaft is rotated by some form of external mechanism which causes the pistons to draw in a charge of gas in the usual manner and which is merely a mechanical substitute for hand cranking. Second, those systems in which a charge of gas is supplied the cylinders and ignited independently of crank-shaft rotation. Mechanical starters include all devices which rotate the shaft to produce the cycle of operations necessary to secure the power impulse in the cylinders, and motion may be imparted to the crank shaft in two ways: by the use of independent mechanism, or by making a motor of the engine itself.

The independent motor devices may be spring, air, or electrically operated mechanisms. Spring motors have not attained the popularity that air or electric motors have because they weigh considerable and occupy more space than would be needed by the other types. Their capacity is limited because the energy is supplied by a spring or springs which become unwound and which cannot supply any energy when they are uncoiled. Spring motors are usually geared to the crank shaft and thrown out of gear by automatic means after the engine is started when the springs have been wound to the proper degree of tension.

Features of Ignition Starters.—It is not an uncommon thing to start a four- or six-cylinder motor by merely turning on a switch because a certain amount of unexploded gas may remain in one of the cylinders and this may be compressed to a point where it will explode as soon as an electric spark takes place in the cylinder to fire the gas. It is natural, then, that the first starting systems proposed should incorporate some means of furnishing a charge of gas to the engine and then exploding it. The gas supplied may be either carbureted gasoline or acetylene and the conditions which exist are similar to those present when the engine is started on the spark.

A simple form of gas-starting systems is outlined at Fig. 661. Special check valves are inserted in each cylinder head of the four-

cylinder motor and are supplied with gas through a special form of hand-operated rotary distributor valve carried on the dash. The gas is supplied from an acetylene tank and one or two turns of the distributor handle serves to supply gas to the cylinder, the piston of which is at the upper center and in the proper position to receive the impact of the exploded gas. Turning on the switch, provided that the car is a form using battery ignition as an auxiliary or regular system, will suffice to produce a spark in the cylinder to which the gas has been introduced and will start the motor.

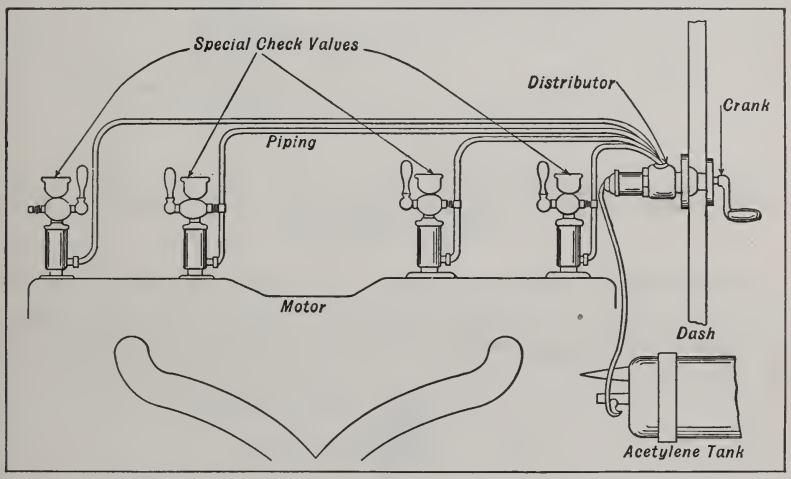


Fig. 661.—Simple Ignition Starting System Using Acetylene Gas and Hand Operated Distribution Valve on Dash.

Gasoline is sometimes used as a starting medium and when this is employed some form of pump is used to force an explosive vapor into the cylinder. An upward movement of the pump handle draws in a certain amount of gasoline from the tank and air through some form of special inlet check, and when the pump handle is depressed the gasoline mixture is pumped into the proper cylinder through a pipe which is attached to some form of distributor or selector valve to direct the gas stream to the proper explosion chamber. A system which depends upon supplying gas is shown at Fig. 662. In this the hand pump is placed in front of the operator's seat in such a position that the handle may be conveniently reached by the driver or passenger. A couple of strokes of the pump suffices to supply enough explosive mixture to start the engine when the ignition circuit is completed. The gasoline-starting system is not as popular as

that using acetylene gas because the latter gas will explode easier and the operator does not need to exercise the degree of judgment that is needed when supplying a gasoline vapor.

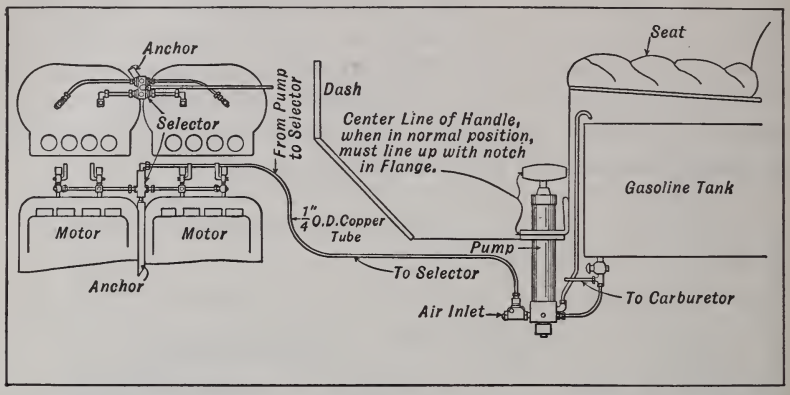


Fig. 662.—Ignition Starting System in which a Hand-operated Pump Forces Mixture to Cylinders.

Compressed-Air Starting Systems.—Two forms of air-starting systems were tried out and later abandoned in favor of electrical means; one in which the crank shaft is turned by means of an air motor, the

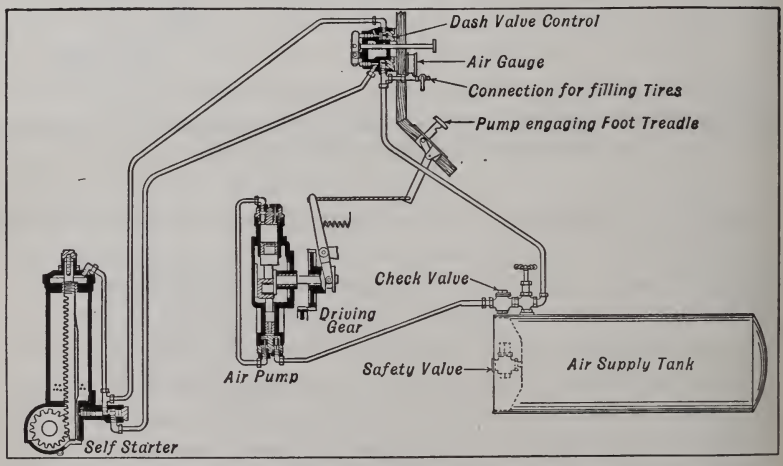


Fig. 663.—Never-Miss Starting System, with Special Air Motor for Mechanical Cranking.

other class where compressed air was admitted to the cylinders proper and the motor turned over because of the air pressure acting on the pistons. A system known as the "Never-Miss" is shown at Fig. 663

In this a small double-cylinder air pump is driven from the engine by means of suitable gearing and supplies air to a substantial container located at some convenient point on the chassis. The air is piped from the container to a dash-control valve and from this member to a peculiar form of air motor mounted near the crank shaft. The air motor consists of a piston to which a rack is fastened which engages a gear mounted on the crank shaft provided with some form of ratchet clutch to permit it to revolve only in one direction, and then only when the gear is turning faster than the engine crank shaft.

The method of operation is extremely simple, the dash-control valve admitting air from the supply tank to the top of the pump cylinder. When in the position shown in cut the air pressure will force the piston and rack down and set the engine in motion. The valve is a special form and the piping is arranged in such a manner that a current of air may be sent against the bottom of the piston when it has reached the end of its stroke to return it to the top of the pump cylinder. When the piston reaches the bottom of its stroke, the air is automatically discharged through a series of exhaust openings in the cylinder wall.

An air gauge is placed on the dash so that the pressure of air in the supply tank may be ascertained at a glance. If the pressure is lower than it should be a foot treadle is depressed and the air pump put into action by meshing the driven gear on the pump crank shaft with the driving member that supplies power from the engine. When the air pressure is sufficiently high the treadle is released and the pump ceases to supply air. A safety valve is installed on the tank to relieve any excess pressure which might accumulate if the pump is kept in action longer than needed.

Another form of air-starting system in which air is supplied directly to the cylinders of the motor through a special distributor arrangement is shown at Fig. 664. The small air pump is driven by gear connection from the engine in the usual manner, and supplies air to a pressure tank. The distributor is driven in much the same manner and at the same speed as an ignition distributor used on a magneto, and the arrangement of piping is such that the air is supplied to the cylinders in the regular firing order. When the foot valve is depressed air is admitted to the cylinders and the engine is kept in motion by air pressure until it has inspired a charge of gas which becomes ignited and starts the motor on its cycle of operation.

The starter used on the early Chalmers car and fitted to the car as an integral part of the power plant is shown at Fig. 665. In this a check valve in the head of Number 1 cylinder stores air under

pressure in a tank carried in the body of the car. A dash valve releases air from the tank when it is desired to start the motor and this is carried to a distributor operating upon the same principles as the usual form of ignition commutator. The compressed air is sent to the cylinders which are ready for firing and in this way the motor is operated and the crank shaft turned by the air pressure until sufficient gas has been drawn in from the carburetor by the downwardly moving piston to make ignition effective. One of the disadvantages of the air-starting system shown at Figs. 664 and 665 is that these are

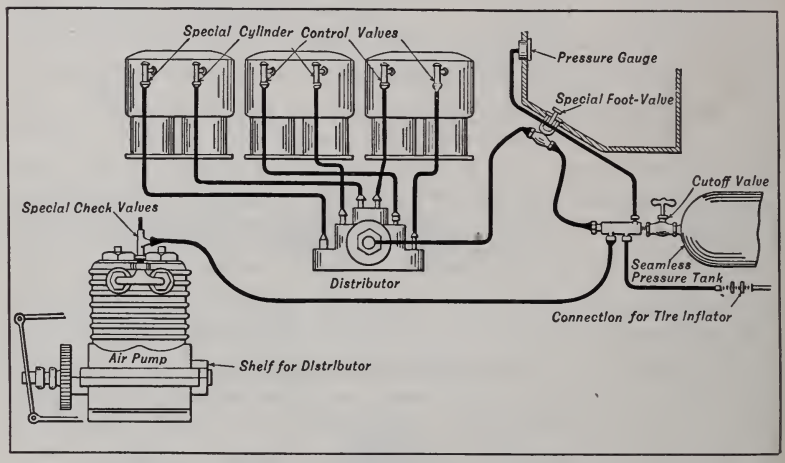


Fig. 664.—Janney-Steinmetz Compressed-Air Starting System.

not effective if the motor should stop on dead center, i. e., when the piston in the working cylinder is exactly at the top of its stroke. This condition is one that seldom obtains in a gasoline engine because the natural tendency is for the pistons to balance themselves in such a way that they are nearer the middle of their stroke than the dead center position. Should a motor stop on dead center it may be easily turned over a small amount by the hand crank and then the self-starting device immediately becomes operative. One of the advantages of these systems is that they furnish air for tire inflation as well as for motor-starting purposes. When used on a six-cylinder engine the objection advanced that the motor is liable to stop on dead center is not to be considered as with a four-cylinder motor.

Summing up the advantages of these various self-starters, it would seem that in some cases moderately satisfactory results could be obtained from the forms in which acetylene gas is introduced to the cylinders and then ignited by turning on the switch. These ignition

starters have a disadvantage, however, that they cannot be used where ignition is by magneto without battery auxiliaries. Starters which rotate the crank shaft have the advantage that they can start a motor even if it is equipped with a magneto because they will turn an engine over faster than is possible by hand power, and the result is that a spark of adequate strength will be generated to ignite the gas even if batteries and coil are not provided.

The disadvantage of air-starting systems where the air is admitted to the cylinders is that the air chills the cylinders and makes starting somewhat difficult in cold weather or when conditions are such that the gasoline mixture is not properly proportioned. If considered from the point of view of results obtained, it would seem that the electric starter with its capacity for a large number of motor starts per charge of batteries would be the most suitable form.

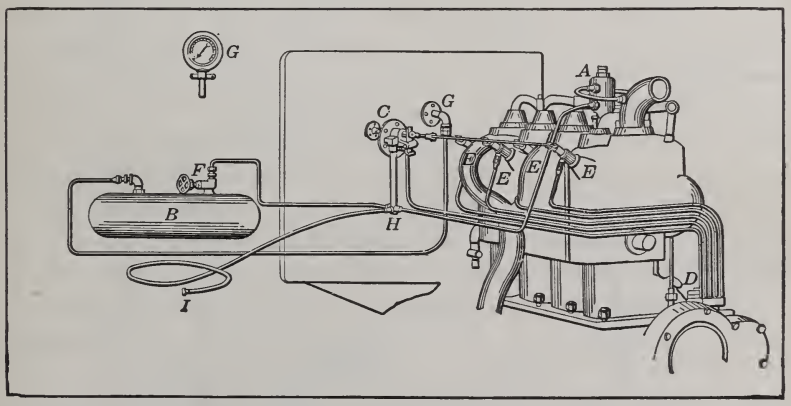


Fig. 665.—Parts of Gas Starting Group Supplied on Early Chalmers Cars. A—Pressure Supply Valve. B—Compressed Gas Tank. C—Dash Starting Button. D—Mechanical Distributor. E—Cylinder Check Valve. F—Gas Shut-off. E—Pressure Gauge on Dash. H and I—Air Connection for Tire Inflation.

Electric Starting Systems.—Starters utilizing electric motors to turn over the engine are now considered the ideal starting device. The capacity is very high, as the motor may draw current from a storage battery and keep the engine turning over for half an hour on a charge. The objection formerly advanced against their use that it requires considerable complicated and costly apparatus which is difficult to understand and which requires the services of an expert electrician to repair should it get out of order is no longer true, because the development has greatly simplified the units and the various systems are now

well understood by all. Electric starting and lighting systems have been made in many forms; though the basic principles of operation are practically the same in all systems, they can be grouped in several main classifications. It will not be possible to describe all in a general treatise of this nature, but if the features of the leading systems are outlined it will not be difficult for the motorist or repairman to become familiar with the principles of other systems which may be different only in points of minor detail. Not only do the individual systems vary in detail, but the components of the same system are often of different construction when used on cars of different makes. The standard equipment must include three main component parts; namely, the generator, which is driven by the engine and which produces electric current to keep the storage battery charged, and the starting motor, which is in mechanical connection with the engine and in electrical connection with the storage battery when it is desired to turn the engine over for starting. If the motor and generator are combined in one instrument, the starting system is known as a "one-unit" type. If the motor is one appliance and the generator another, the system is said to be a "two-unit" type. Each of these has advantages, and both forms have demonstrated that they are thoroughly practical. In addition to the three main items enumerated, various accessories, such as switches, ammeters, connectors, wiring, protective circuit breakers, automatic current regulators, etc., are necessary for the convenient distribution and control of the electric current.

The arrangement of the parts of a typical "one-unit" system in which the motor generator is used only for starting and lighting is shown at Fig. 666. This shows the location of the various parts in their relation to the other components of the motor car power plant. The motor generator is usually mounted at the side of the engine and is driven by the drive shaft when used as a generator and serves to drive the engine through a gear on the fly wheel when it is used as a motor. The ignition current is supplied from an entirely independent source not shown—a high tension magneto. The starting switch and that controlling the lighting system are nearly always placed on the dash, while the storage battery is carried under the floor of the tonneau in a pleasure car or on the running board of the heavier vehicles. It will be observed that the armature carries two commutators, one of which is used when the armature is driven by the engine and when the device serves as a current generator, the other being employed when the operating conditions are reversed and the electrical machine is driven as a motor to turn over the engine crank shaft. When the device is driven as a generator the small sliding pinion on the short

end of the shaft is out of engagement with the spur gear cut on the fly-wheel exterior. When it is desired to start the engine, the spur gear

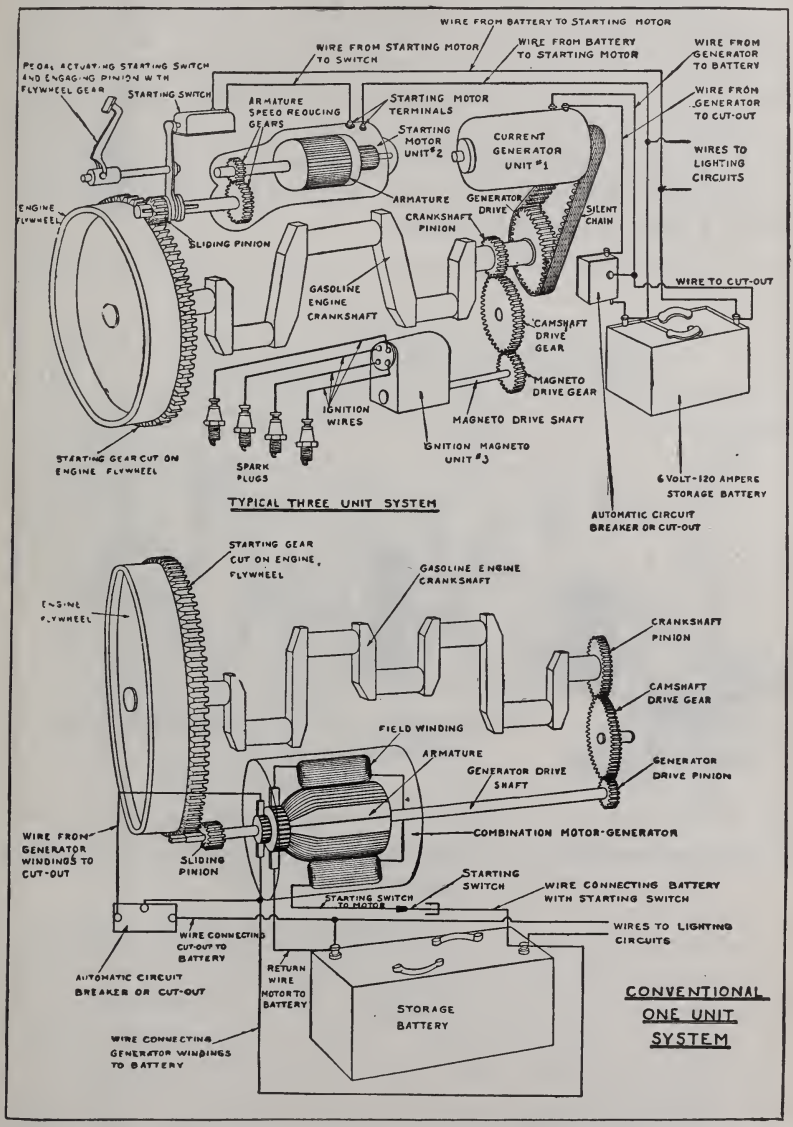


Fig. 666.—Diagrams Showing Relation of Parts of Typical Electric Starting Systems. That at the Top is a Three-Unit, while the One Shown Below is a One-Unit Form.

is meshed with the member cut on the fly wheel and the current from the storage battery is directed to the windings of the electric machine,

which becomes a motor and which turns over the engine crank shaft. When the device is working as a generator the current developed goes to the storage battery and from that member to the various current-consuming units. Sometimes the motor and generator are combined in one casting and the system so provided is erroneously called a "one-unit" system. In reality such a system is a "two-unit" system because the electrical machines are uni-functional, instead of performing a dual function, as does the combined motor generator at the bottom of the illustration, Fig. 666. The wiring is shown in simplified form and should be easily followed by anyone.

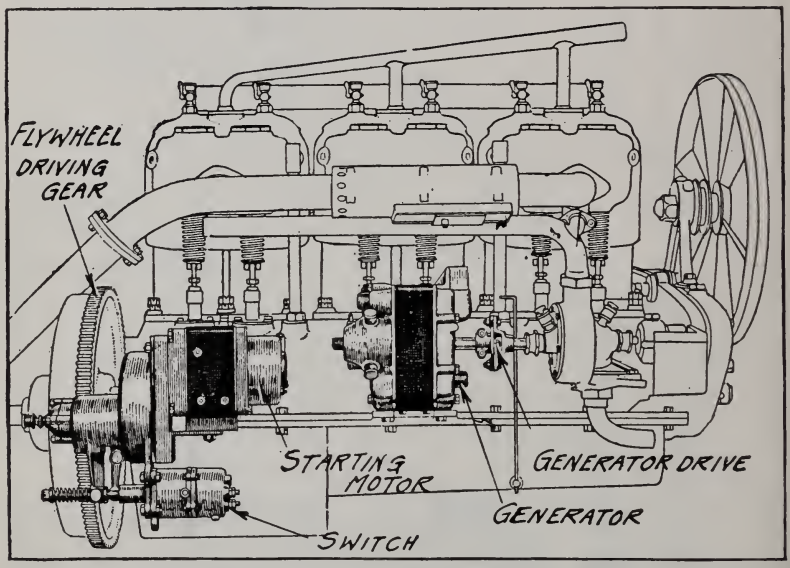


Fig. 667.—Depicting Method of Installing Starting Motor and Current Generator on Locomobile Six-Cylinder Engine.

The parts of a two-unit motor starting and lighting system are shown at top of Fig. 666. This system is sometimes called a "three-unit" system on account of having a source of independent current supply for ignition purposes. As will be observed, the generator is driven from the motor crank shaft by silent chain connection, one of the terminals passing through the cut-out device and to the storage battery, the other terminal running directly to the storage battery terminal having a short by-pass or shunt wire attached to the cut-out. All the time that the engine is running the generator is delivering electricity to the storage battery. It will be observed that the storage battery is also coupled to the lighting circuit which is shown at the

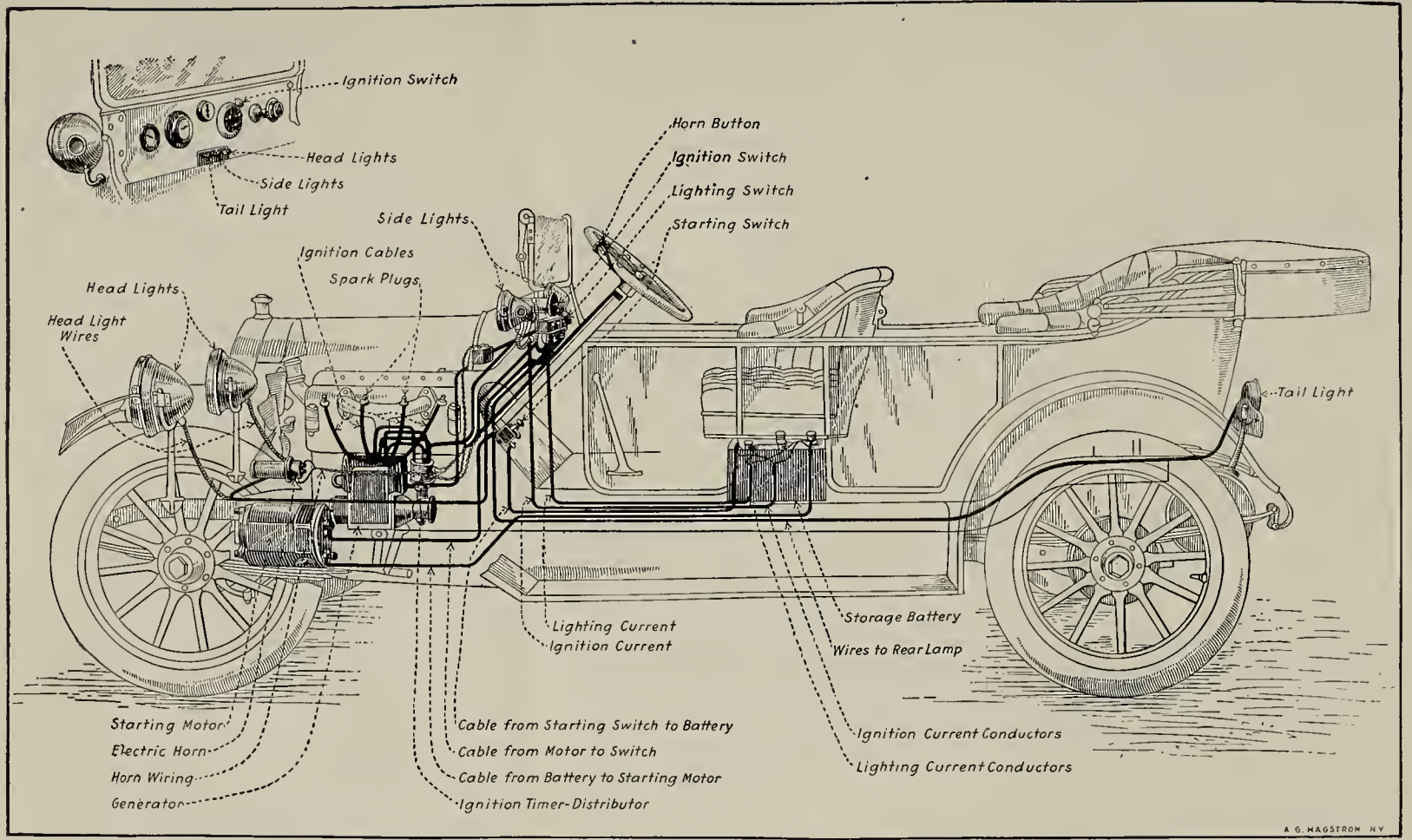


Fig. 668—Phantom View of a Typical Light Touring Car, Showing Location of Lighting, Starting and Ignition Apparatus, also All Connecting Wires and Control Switches.

right of the illustration and to the electric starting motor as indicated. One of the storage battery terminals is joined directly to the switch terminal by a suitable conductor, the other goes to one of the terminals on the starting motor, while the remaining terminal of the starting motor goes to the switch. In this system, when the small sliding pinion is meshed with the fly-wheel gear the switch is thrown on simultaneously and the current that flows from the storage battery through the windings of the starting motor rotates the engine crank shaft by means of a reduction gear shown. As soon as the engine starts the foot is released and a spring pulls the switch out of contact and also disengages the sliding pinion from the fly-wheel gear. The actual appearance of a gasoline engine fitted with a starting motor and generator is shown at Fig. 667. It will be observed that the starting motor is mounted at the back end of the crank case in such a position that the sliding pinion may be brought into engagement with the fly-wheel gear. The conventional interlock between the starting switch and the pinion shifting means is clearly shown. The relation of the various units comprising a typical two-unit starting, lighting and ignition system is shown at Fig. 668. As all parts are clearly designated, the wiring from one portion of the system to the other can be readily traced.

Electrical starting systems may be operated on either six, twelve or twenty-four volt current, the former being generally favored because the six volt lamps use heavier filaments than those of high voltage and are not likely to break due to vibration. It is also easier to install a six volt battery as this is the standard voltage that has been used for many years for ignition and electric lighting purposes before the starting motors were applied. In referring to a system as a "one-unit" system of lighting, starting and ignition one means that all of these functions are incorporated in one device, as in the Delco system shown at Fig. 672. If one unit is used for generating the lighting and starting current and also is reversible to act as a motor, but a separate ignition means is provided, such as a high tension magneto, the system is called a "two-unit" system. The same designation applies to a system when the current generating and ignition functions are performed by one appliance and where a separate starting motor is used. The three-unit system is that in which a magneto is employed for ignition, a generator for supplying the lighting and starting current and a motor for turning over the engine crank shaft. Before describing typical individual systems, it will be well to review briefly the various components common to all systems.

The generator, as will be apparent from its name, is utilized for producing current. This is usually a miniature dynamo patterned

largely after those that have received wide application for generating current for electric lighting of our homes and factories. The generators of the different systems vary in construction, some having a permanent magnetic field, while others have an excited field. In the former case permanent horseshoe magnets are used as in a magneto. In the other construction the field magnets as well as the armature are wound with coils of wire. In all cases the dynamo or generator should be mechanically driven from the engine crank shaft either by means of a direct drive, by silent chain or through the medium of the timing or magneto operating gears. The method of driving the generator used with the Marmon engine from the timing gears is shown at Fig. 671. All the current produced by the generator and not utilized by the various current-consuming units, such as the lamps, ignition system, electric horn, etc., is accumulated or stored in the storage battery and kept in reserve for starting or lighting when the engine is not running or for lighting and ignition when the car is being run at such low speed that the generator is not supplying current.

Storage batteries used in starting systems must be of special design and large capacity in order to stand the high discharge and to perform efficiently under the severe vibration and operating conditions incidental to automobile service. The storage battery may be installed on the running board of the automobile, under the body, or under the rear seat, the location depending upon the design of the car and the degree of accessibility desired. The best practice is to set the storage battery in a substantial carrying case held by rigid braces attached to the frame side and cross members. The battery may be set under the tonneau floor boards, a door in these giving ready access to the battery. The starting motor, which takes the place of the common hand crank, is operated by current from the storage battery, and the high speed armature rotation is reduced to the proper cranking speed by suitable reduction gears. The construction of the starting motor is practically the same as that of the dynamo and it operates on the same principles, except that one instrument is a reversal of the other.

In order to secure automatic operation of a lighting and starting system several mechanical and electrical controls are needed, these including the circuit breaker, the governor, which may be either mechanical or electrical, and the operating switches. The circuit breaker or automatic cut-out is a device to retain current in the storage battery under such conditions that the battery current is stronger than that delivered from the generator. If no circuit breaker was provided, the storage battery could discharge back through the generator winding. The circuit breaker is usually operated by an electro-magnet and

may be located either on the generator itself or any other convenient place on the car, though in most cases the circuit breakers are usually mounted on the back of the dash-board. This device is absolutely automatic in action and requires but little attention.

The governors are intended to prevent excessive output of current from the generator when the engine runs at extremely high speed. Two types are used, one mechanical, operated by centrifugal force, and the other, electrical. The former is usually a friction drive mechanism mounted on the generator shaft which automatically limits the speed of the dynamo armature to a definite predetermined number of revolutions per minute. The maximum current output is thus held to the required amount independently of the speed at which the car is being driven. The use of this device minimizes the possibility of overheating the generator or overcharging the battery at high engine speeds. The electrical system of governing does not affect the speed of the armature, but controls the output of the generator by means of armature reaction, a buckling coil or a reversed series field winding. The governors usually permit a maximum generator output of from ten to twelve amperes, though the normal charging current is less than this figure.

In practically all systems an ampere meter is mounted on the dash so it can be readily inspected by the driver, this indicating at all times the amount of current being produced by the dynamo or drawn from the battery. If the indicating needle of the ampere meter points to the left of the zero point on the scale it means that the battery is furnishing current to the lights or other current-consuming units or discharging. When the needle points to the other side of the scale it means that the generator is delivering current to the battery which is charging it; the amount of charge or discharge at any time can be read from the scale on the face of the ampere meter. Some of these instruments have the words "charge" and "discharge" under the scale in order to enable the operator to read the instrument correctly. Another important element is the lighting switch which is usually mounted at some point within convenient reach of the car driver. This is usually placed on an instrument board on the back of the cowl in connection with the other registering instruments. As ordinarily constructed, the switches are made up of a number of units as the wiring is such that the head, side and tail lamps may be controlled independently of each other. For simplicity and convenience of installation the switch is usually arranged so that all circuits are wired to parallel connecting members or "busbars" placed on the back of the switch. As but little current passes through the lighting switch the contacts are not as heavy in construction as are those of the starting switch.

Auto-Lite Starting System.—The arrangement of parts of a three-unit starting, lighting and ignition system of Auto-Lite manufacture is shown at Fig. 669, while the various important parts comprising the

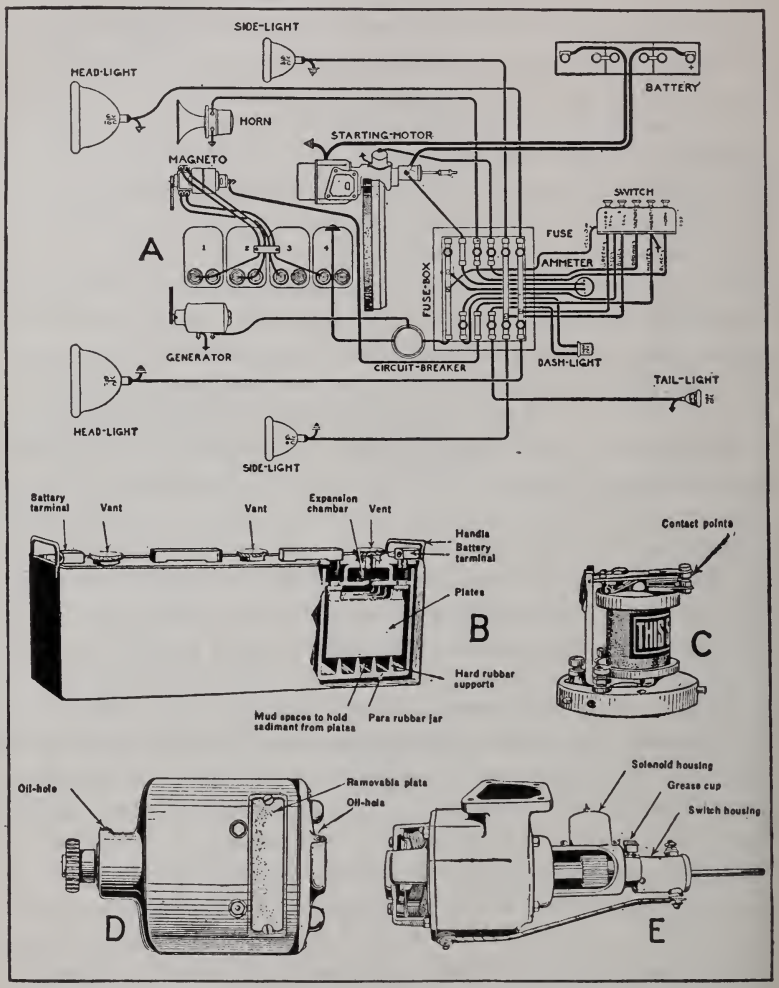


Fig. 669.—Diagram at A Shows Arrangement of Parts of Auto-Lite System and How They are Wired Together. B—Part Sectional View of Storage Battery. C—Automatic Circuit Breaker. D—Current Generator. E—Starting Motor.

system are shown in the lower portion of the illustration. As will be apparent the ignition is from an entirely different source, an independent high tension magneto being provided for this purpose. The gen-

erator is placed at the side of the engine and is driven by a silent chain connection from the motor crank shaft. The starting motor is attached to the rear of the engine on the magneto side and is used to turn the engine crank shaft by engaging directly with a gear cut on the outside of the fly-wheel. The system operates on the one wire method. An automatic circuit breaker is provided to which the generator is connected. This is interposed between the generator and storage battery and when the engine speed becomes so low that the generator output is less than the discharge of the battery the circuit breaker interrupts the connection and prevents the battery from discharging through the dynamo. The various circuits are clearly outlined in the diagram and no difficulty should be experienced in tracing the wiring to the various units. The lighting system is very complete, consisting of two

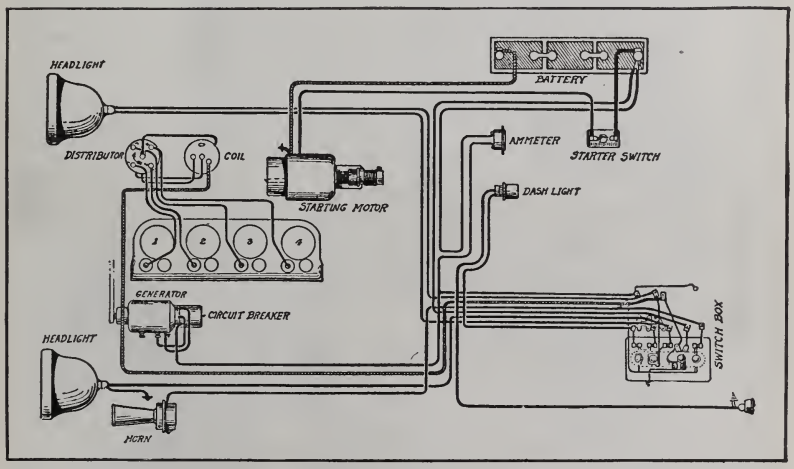


Fig. 670.—Wiring Diagram, Showing Auto-Lite Starting, Lighting and Ignition System.

head lights, two side lights, a dash light and rear signal. The wires leading to the various units and to the switch are of different colors, so that no trouble will result when tracing the various circuits. In order to prevent damage through short circuiting of a wire, a fuse box is provided, small fuses being interposed in all lamp circuits. When it is desired to start the motor, a switch on the master switch box is operated and a foot pedal depressed. This automatically engages the sliding pinion carried on the motor armature and also closes the starting switch contacts. An Auto-Lite system in which the battery current is employed for ignition is shown at Fig. 670. The system for lighting is also simpler, because the side lights are eliminated.

The storage battery used with this system is shown at Fig. 669, B. It differs from conventional construction as the three cells are placed end to end instead of side by side, making a long, narrow battery box instead of the type generally used, which is approximately square. The automatic circuit breaker is shown at C. The only parts needing inspection are the contact points. The generator, which is connected with the crank shaft and driven by a silent chain, is shown at D. This has an electric governing system, so that its current output is less at high speeds than it is at normal speeds. The starting motor is shown at E,

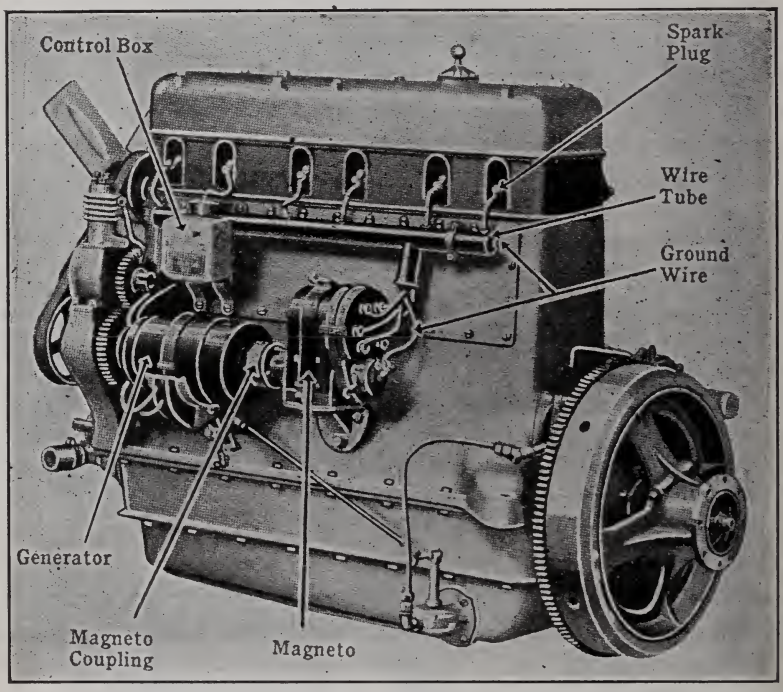


Fig. 671.—View of Marmon Motor, Showing Application of Current Generator for Starting and Lighting and Magneto for Ignition Purposes.

the sliding pinion which engages with the fly-wheel gear being clearly visible through the cutaway portion of the gear enclosing case. The starting switch is mounted on the end of the motor and is worked by the same rod that slides the pinion.

Delco Starting System.—One of the most popular systems is that shown at Fig. 672, which is a complete starting, lighting and ignition system using a single unit to perform the three functions. This is the Delco system and was the first really practical self-starting assembly

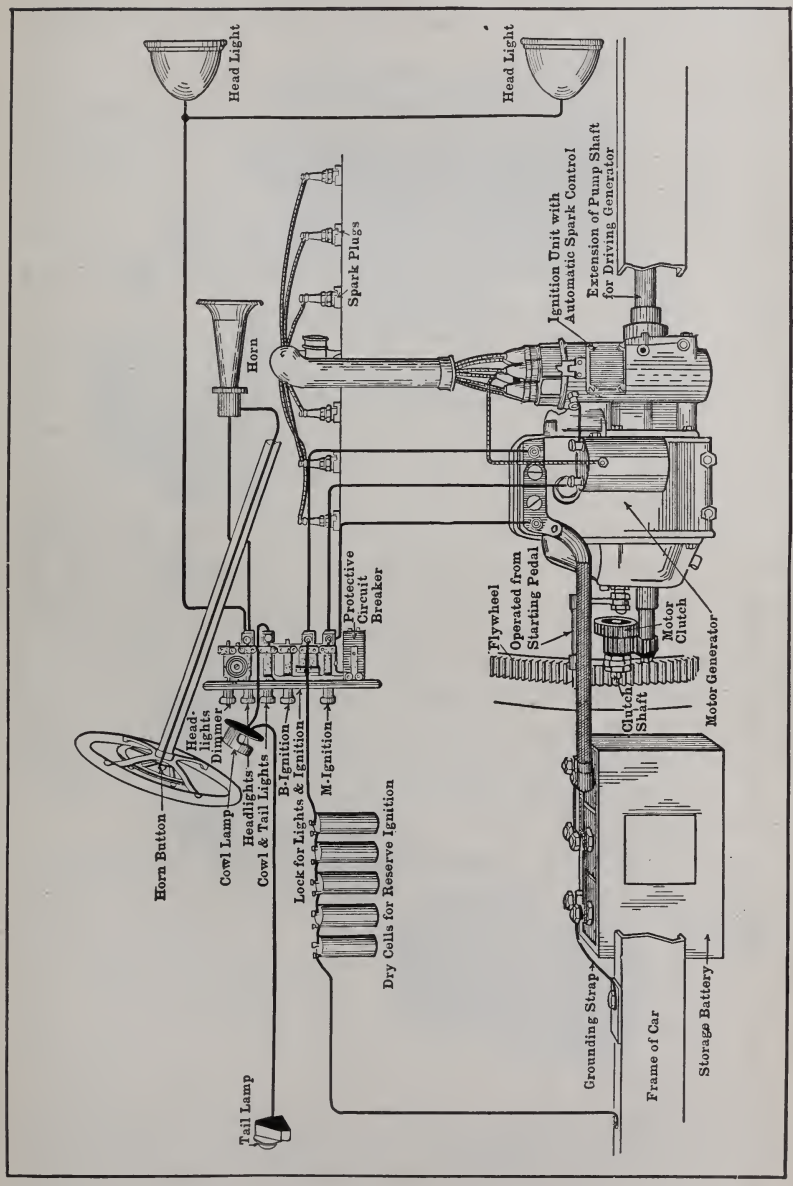


Fig. 672.—The Delco One-Unit Starting, Lighting and Ignition System.

to receive general application. It is of a single wire or ground type which means that one side of the storage battery is directly connected to the frame of the car, only one wire being carried to the various lamps and other current-consuming units. The motor generator is a single unit type and includes the ignition distributor and timer, which is built in the front end of the housing. The operation of the motor generator will be more clearly understood if one views it first, merely as an electric motor, suitably connected with the engine to turn the crank shaft and then by an ingenious shifting of the internal mechanism as a generator for charging the storage battery and to furnish current for the lights and ignition, at this time being so arranged that the generator is turned by the engine.

When used as a motor, it operates on the series wound principle and has a spur gear pinion upon the end of the armature shaft nearest the fly-wheel. Interposed between this pinion and the gear teeth cut in the face of the fly-wheel is a pair of gears adapted to slide along and revolve upon an intermediate shaft. This sliding action results in the larger of the gears engaging with the motor pinion, while the smaller one meshes with the gear teeth on the fly-wheel. A one-way starting clutch is incorporated inside of this set of gears and is for the purpose of permitting the engine to run ahead of the motor during the short time that the gears are meshed after the engine fires and is running under its own power. The total gear ratio between the armature shaft and the engine shaft is approximately 20 to 1. This means that the armature makes twenty revolutions to turn the engine over once, and assuming a motor speed of 2,000 R. P. M., the engine will be cranked over 100 R. P. M., or considerably faster than is possible by hand.

When the unit is generating current for charging the battery it is a simple shunt wound generator. In this case it is driven from the engine by an extension of the pump shaft. The generator is driven at crank shaft speed and in order to compensate for the higher ratios when the unit is in starting relation to the engine a second one-way driving clutch is provided adjacent to the forward housing. This permits the armature to run ahead of the driving shaft during the cranking operation. When a starting pedal is pushed forward it shifts the brushes from the generator commutator and engages the brushes of the motor commutator, there being two commutators on the armature. Whenever the starting pedal is released the motor brushes are lifted from their commutator and generator brushes are dropped on their commutator.

A cut-out relay is located in the rear end housing of the motor

generator, this instrument performing a double function. During the initial starting operation it is closed mechanically to complete

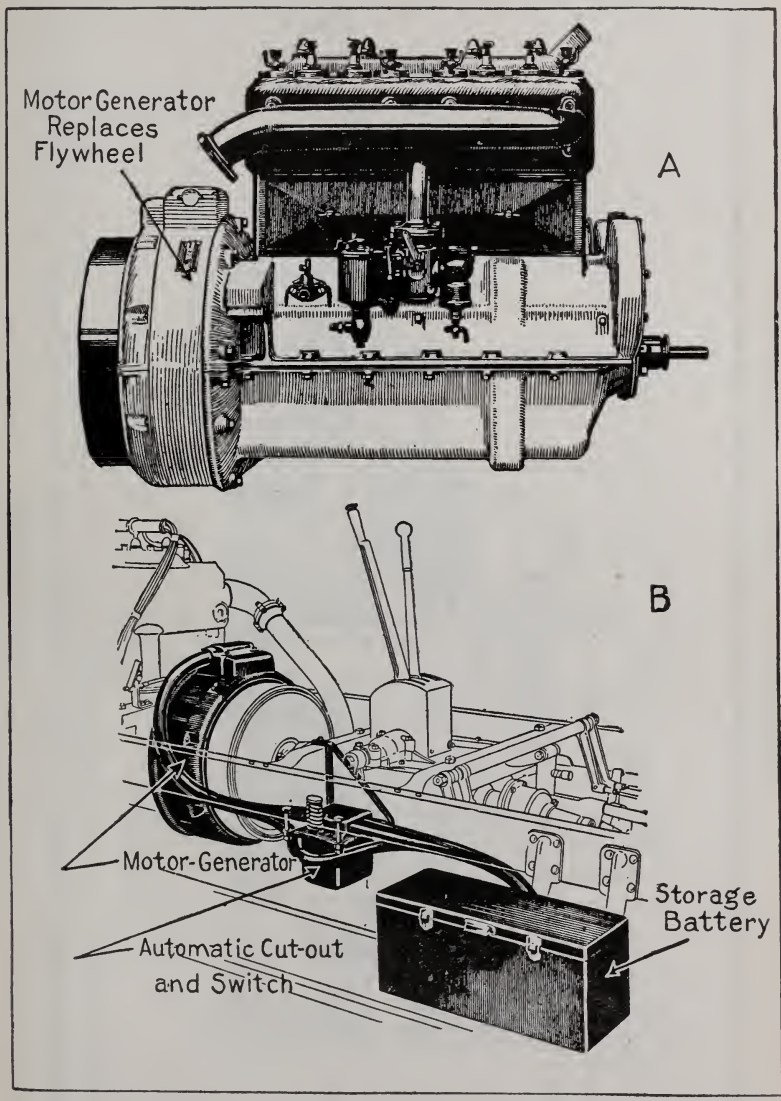


Fig. 673.—One-Unit Starting System, Where Combination Motor and Generator Replaces Engine Flywheel.

the circuit between the storage battery and the armature, and it also automatically closes the circuit between the generator and storage battery when the generator voltage is high enough to charge the

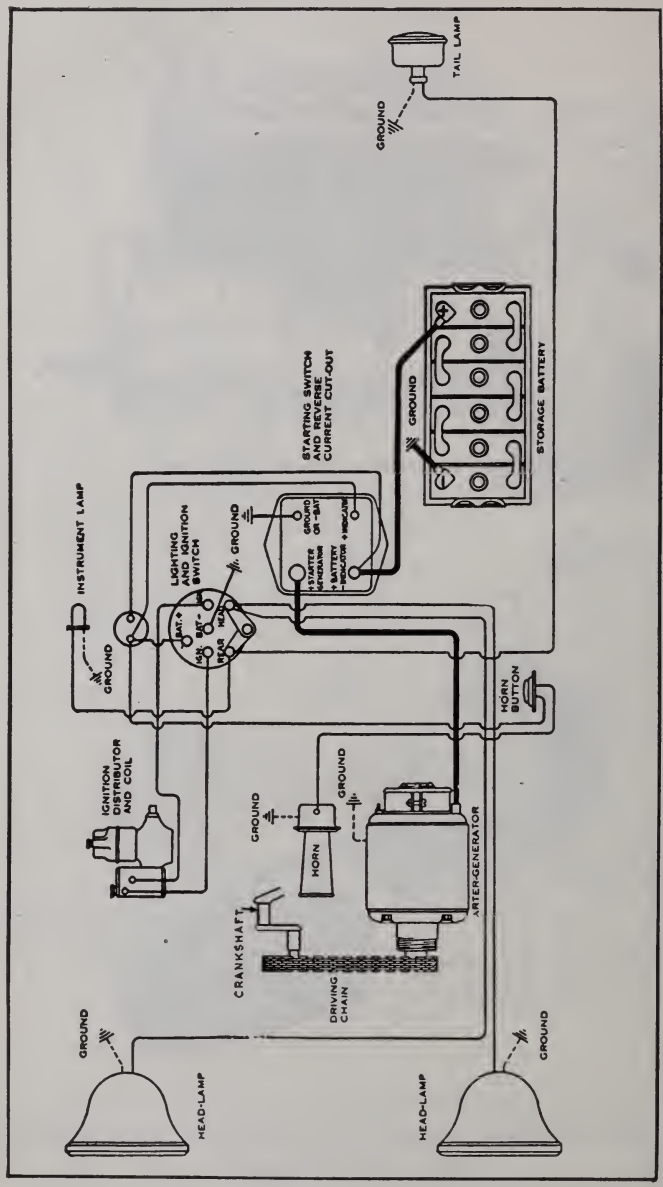


Fig. 674.—Wiring Diagram, Showing Location of Principal Parts of the Dodge-Northeast Starting, Lighting and Ignition System.

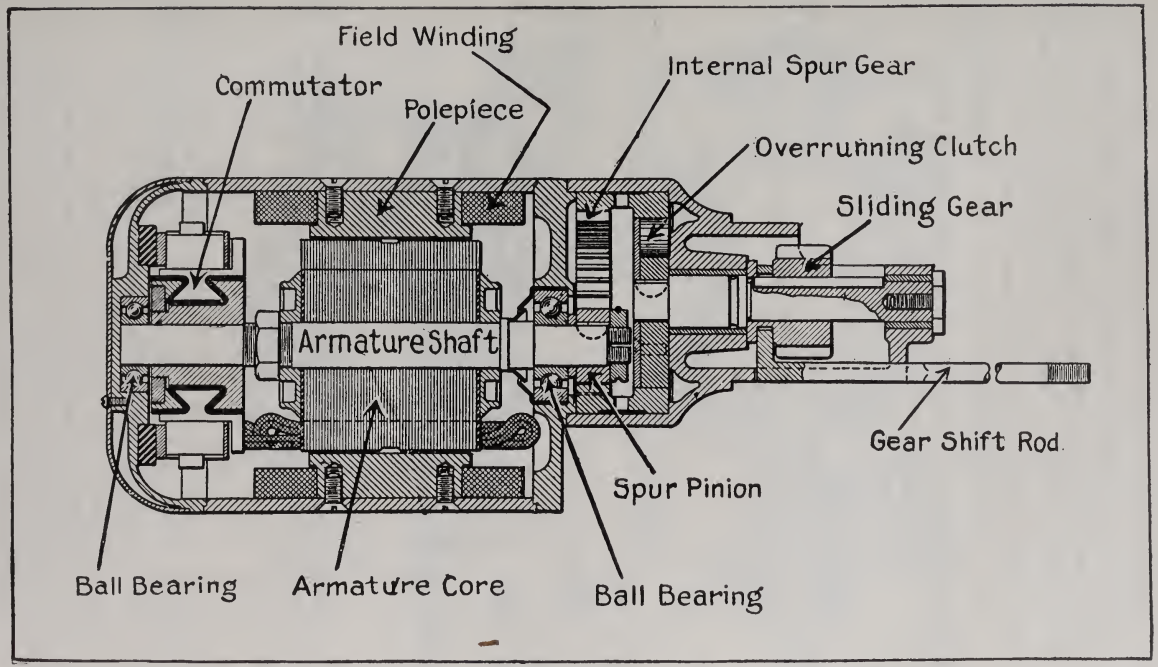


Fig. 675.—Sectional View of Early Starting Motor Design, Showing Reduction Gearing, Overrunning Clutch, and Sliding Gear to Engage the Flywheel.

battery. It opens the circuit when the generator slows down and the voltage becomes less than that of the battery, this preventing the latter from discharging back through the generator winding.

An example of a one-unit system in which the motor generator is attached to and forms part of the gasoline engine fly-wheel is shown at Fig. 673. When running as a dynamo, which occurs as soon as the engine starts, the current is delivered to the storage battery. If the gasoline engine is stopped and the starting button is depressed, the current from the storage battery is passed through the windings of the electrical device, transforming this into a motor and producing sufficient power to crank the engine. In order to obtain the proper degree of starting torque a twenty-four volt storage battery is used instead of the six volt battery needed with the Delco or Auto-Lite systems. An automatic regulator is provided,

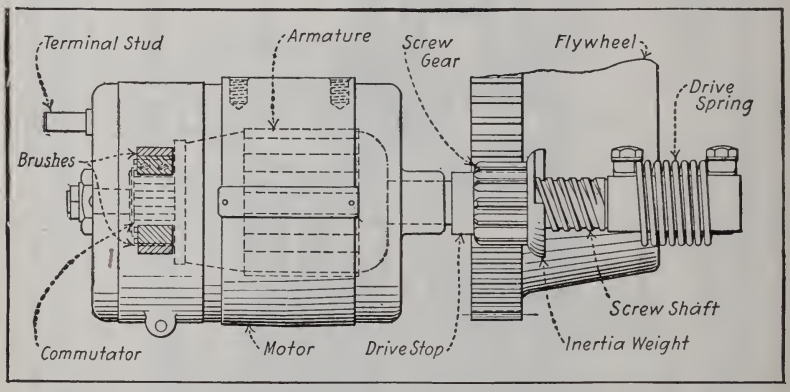


Fig. 676.—Starting Motor, Showing the Application of the Automatic Pinion Shift, by which Flywheel Driving Pinion is Engaged by Motor Armature Shaft Rotation.

which makes for a uniform rate of battery charging for any engine speeds. Another automatic switch, which is worked in connection with the starting button, automatically changes the electric motor into an electric generator and vice versa. Another method of using a single electric machine as a starting motor and current generator is shown at Fig. 674. In this, the motor-dynamo is driven directly from the motor crank shaft by a silent chain. The six-cell storage battery delivers 12 volts. This is a one-wire system and the chassis frame serve as a ground return for the battery current.

A typical small motor employed for starting gasoline engines is shown in section at Fig. 675, and is an excellent example of the

construction generally followed in apparatus of this type. The armature shaft, which carries a laminated armature core, revolves on single row annular ball-bearings which provide practical immunity from bearing troubles. A spur pinion is keyed to the driving end of the armature shaft and meshes with an internal spur gear that drives the housing of an overrunning clutch that is formed integrally with it. A reduction of speed is obtained at this point and the rotative speed

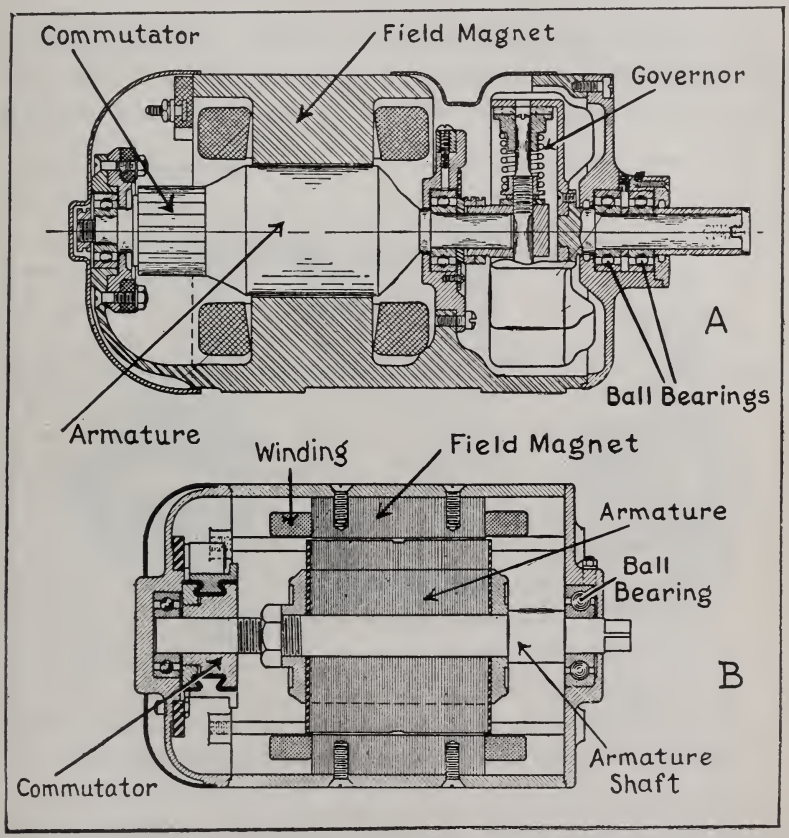


Fig. 677.—Sectional View of Typical Generators Used in Connection with Electric Starting and Lighting Systems.

is still further reduced by the difference in size between the sliding gear, carried by the driven shaft, and the gear formed on the flywheel rim. The small sliding gear is adapted to be moved on its driving shaft so it can engage a large diameter member formed on the flywheel. The pinion is shifted by a yoke and gear-shift rod that may be actuated by a suitable foot or hand lever. In the motor design

shown at Fig. 676, which is the starting motor utilized with the Delco two-unit system, the small pinion on the armature shaft is shifted automatically. There is a spiral thread cut into the pinion and as soon as the armature starts turning it screws the pinion into engagement with the flywheel gear. As soon as the engine starts, the pinion is shifted out of mesh automatically. This is a very popular form of drive and is found on a large number of 1917 automobile starting motors.

Two types of generators that are commonly used in connection with two-unit lighting systems are shown in section at Fig. 677. That at A is a Gray & Davis dynamo, which is so constructed that

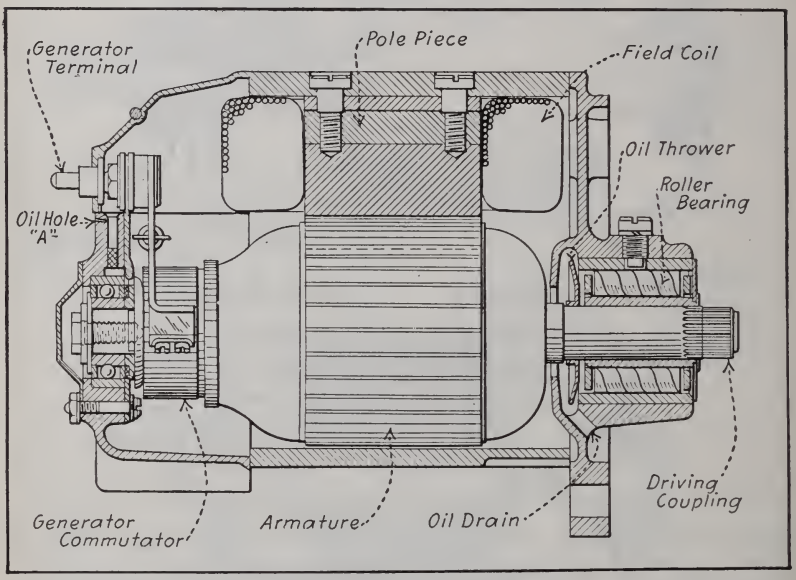


Fig. 678.—Current Generator of the Delco Two-Unit System.

the armature will be driven at a constant speed, regardless of the variation in rotative speed of the power plant. The armature is mounted on ball bearings, but is driven through the medium of a friction governor which is interposed between the armature shaft and the main drive shaft. The driving pulley or gear is attached to the shaft extending from one end of the generator casing, which is attached to the friction governor driving drum which is mounted on two annular ball bearings. The action of the friction-clutch governor is extremely simple. When the gasoline engine exceeds a certain predetermined speed the armature shaft-drive clutch shoes will

be pulled out of contact with the driving drum and will be held out of driving engagement with the gasoline motor until such time as the speed reduces sufficiently to permit the clutch shoes to expand again and take up the drive. The dynamo shown at B is a considerably simpler form, as it is wound so that no governor is necessary and the windings are so proportioned that it may be driven at high speed without danger and yet deliver a current of electricity at comparatively low motor speed. The side sectional view at Fig. 678 is the Delco generator, used in connection with the latest two-unit system. The illustration at Fig. 679 shows the arrangement of the brushes, particularly the third brush for regulating the current output. This differs from an ordinary shunt wound generator in that the shunt field current instead of being taken from the regular brushes of the generator is taken from an auxiliary or regulating brush which bears on the commutator between the regular brushes. With this method of regulation a strong shunt field is secured at the low speeds which causes the generator to commence charging at low speeds. As the speed increases the amount of voltage that is applied to the shunt field is decreased, although the total voltage between the main brushes may be increased. This prevents the output of the generator from increasing with the increased speed, and at the higher speeds it causes the output of the generator to be decreased.

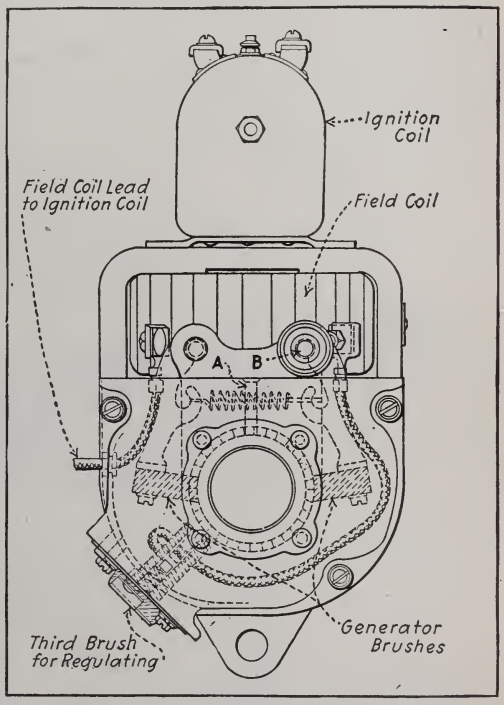


Fig. 679.—View of Commutator End of Delco Generator, Showing Position of Third Brush for Current Regulating Purposes.

By this manner of regulation it is possible to obtain the highest charging rate between speeds of 15 to 25 miles per hour. Experience has taught that it is with the type of a driver whose average speed is

between these limits that the highest charging rate is required. The driver whose average speed is above these limits uses less current in proportion to the amount of driving than does the slower driver. The output of these generators may vary a few amperes, as the output is affected to a certain extent by the condition of the battery and by the temperature.

An important component of some electric starting systems is an overrunning clutch, which permits the gasoline engine to rotate independently of the starting motor when it picks up its cycle of opera-

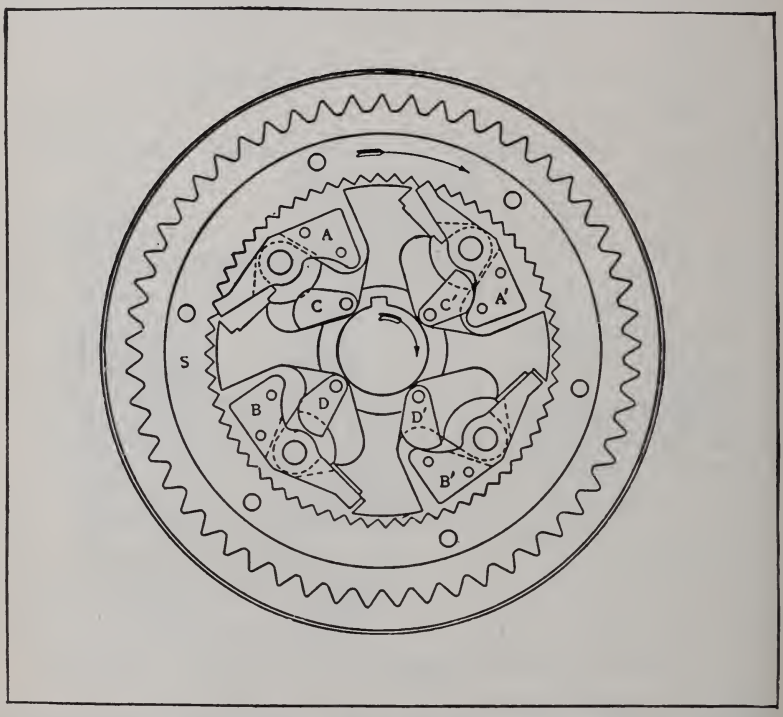


Fig. 680.—Defining Construction of an Early Overrunning Clutch Design of the Pawl and Ratchet Type with Automatic Throwout.

tion. The average four-cylinder engine will start at forty to fifty revolutions per minute. As the speed of the average small electric motor used for starting purposes is about 1,400 revolutions per minute, it will be apparent that the starting motor armature must turn thirty-five times as fast as the motor crank shaft. If there was no overrunning clutch provided to automatically release the starting motor, the gasoline engine might pick up its cycle of operations and

immediately speed up to 500 or 600 revolutions per minute if the throttle is open to any extent. With a gear ratio of 35 to 1 the starting motor armature would be forced to turn at 21,000 revolutions per minute, which speed or rotation would not only seriously strain the starting motor, but would prevent the operator from unmeshing the gearing interposed between the starting motor and the engine crank shaft. The overrunning clutch, therefore, is an automatic device that should permit the electric motor to drive the gasoline engine, but break the driving connection as soon as the gasoline engine tries to drive the starting motor. A ratchet type driving clutch is shown at Fig. 680. The toothed driving member S is attached to the internal gear which is rotated by a small spur pinion. The ratchet pawl members A and A′ are attached to the shaft connected with the gasoline engine flywheel. As long as the member S does the driving, the ratchet pawls will remain in contact with the teeth. A reversal of motion or an increase in the starting-shaft speed will release the drive automatically.

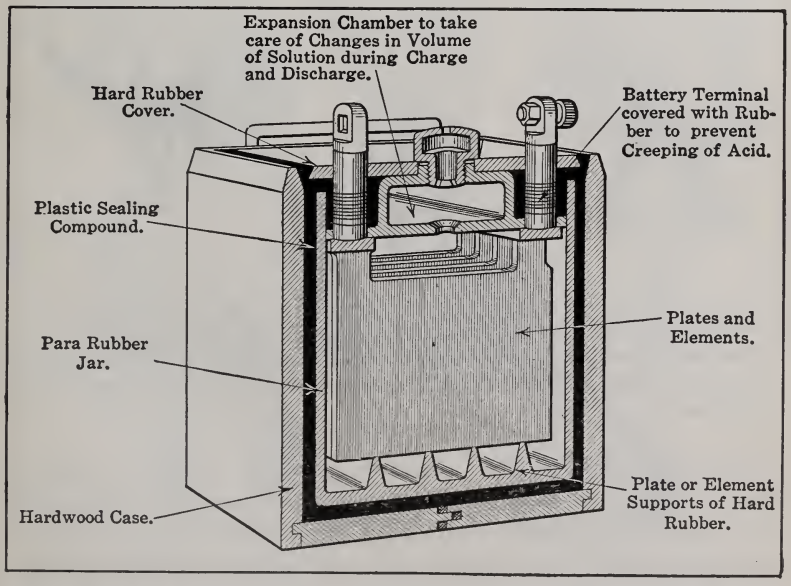

Expansion Chamber to take care of Changes in Volume of Solution during Charge and Discharge.
Hard Rubber Cover.
Battery Terminal covered with Rubber to prevent Creeping of Acid.
Plastic Sealing Compound.
Plates and Elements.
Para Rubber Jar.
Plate or Element Supports of Hard Rubber.
Hardwood Case.

Fig. 681.—Special Storage Battery Employed to Furnish Starting and Lighting Current.

Electric Lighting Systems.—During the past five years all manufacturers have employed electric lamps to advantage on automobiles, and while these were formerly fitted only to the high-grade cars the development made in providing suitable current producers and lamps

having strong filaments has made possible the application of electric lighting to all classes of cars, especially since the electrical system of starting automobile engines is now used universally. The usual method of current supply is by storage battery, somewhat similar in principle to those used for supplying ignition current but which are more substantially constructed and have plates of greater capacity than those usually provided in ignition cells. The construction of a typical lighting and starting battery is shown at Fig. 681, this form having been designed especially for this class of work.

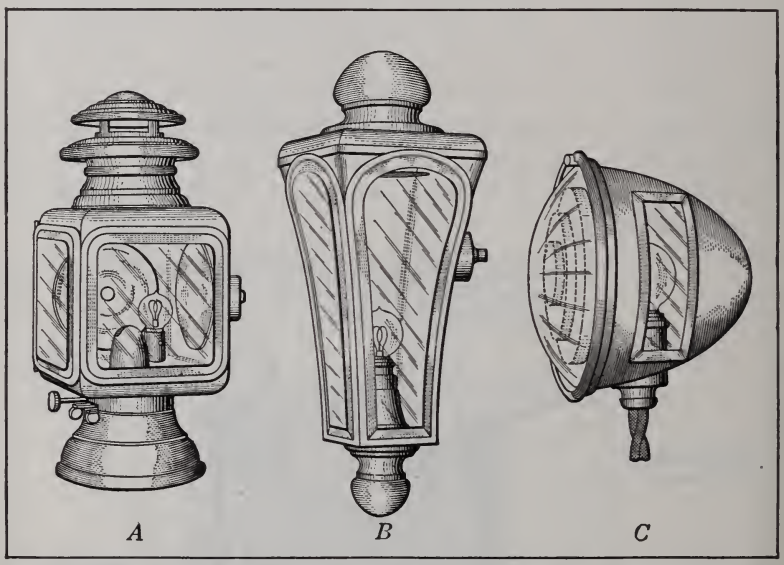


Fig. 682.—Side and Tail Lamps Using Electric Bulbs for Illumination. A—Kerosene Side Lamp with Tungsten Bulb in Corner. B—Pillar Lamp for Limousine Bodies Using Electric Lamps Exclusively. C—Small Electric Tail Lamp.

Mechanical generators of electricity are now used in all lighting systems, and a number of small dynamos have been used successfully in this connection. A dynamo always supplies its current directly to a storage battery, and the electricity for lighting is taken from the storage battery rather than the dynamo. The reason for this is that any fluctuation of engine speed makes the current production vary in value. If the engine was running slow and the lamps were attached directly to the generator there would not be sufficient illumination. At the other hand, if motor speeds were high and the generator was driven faster, enough current might be produced to burn out the lamps. When the current from the dynamo is directed to a storage battery

that member serves as an equalizer and will maintain a constant discharge to the circuit in which the lamps are wired. It will absorb excess electricity generated at high-motor speeds and will supply

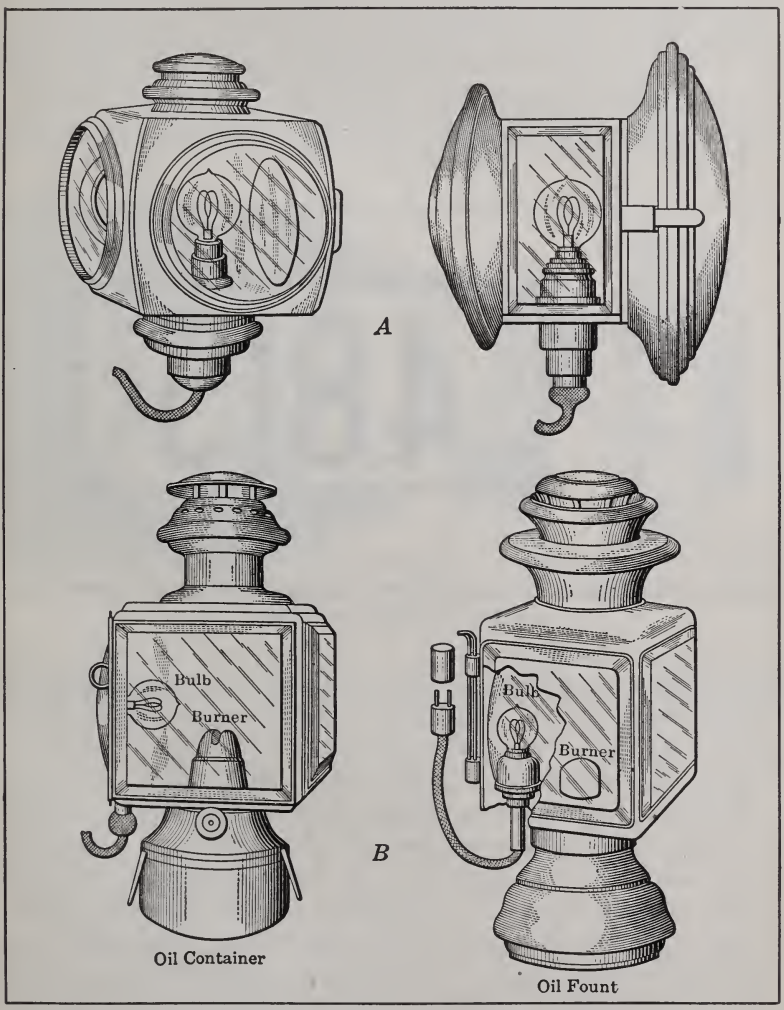


Fig. 683.—A—Side Lamps Designed to Use Only Electric Bulbs. B—Methods of Combining Kerosene Burner and Tungsten Bulb in Side Lamps.

that energy to the lamps at such time that the generator would be inadequate to supply the proper amount of current.

Various forms of lamps utilizing electric bulbs are shown. That at A, Fig. 683, is a side lamp that has been designed especially for use

with electric current, while that depicted at B is a combination form in which the electric light bulb has been inserted in an oil lamp of conventional pattern in such a way that it will not interfere with the normal operation of the kerosene burner should it be desired to use the kerosene flame. This feature is one that provides an important advantage in that a failure of the electric lamps or source of current would not seriously inconvenience the motorist, as he could use the kerosene burner and secure adequate illumination to enable him to operate the car without danger. The combination shown at Fig. 684 shows the

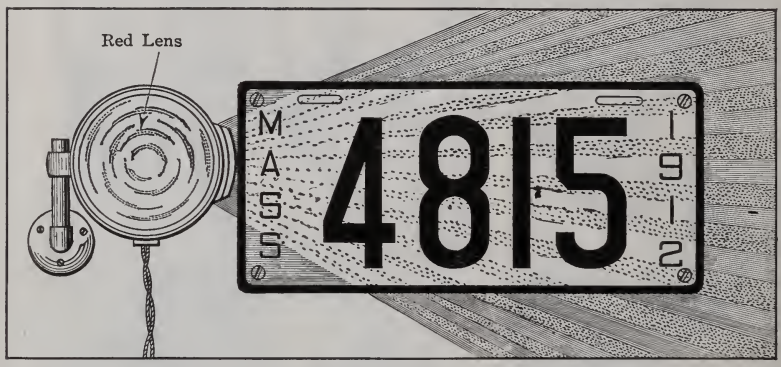


Fig. 684.—Gray & Davis Combined Electric Tail Lamp and License Plate Holder, a Device of Marked Utility.

adaptability and simplicity of the electric light to good advantage. In this the electric lamp is mounted in connection with a license number in such a way that a stream of white light is thrown on the number to illuminate it, whereas a red lens shows a danger signal to the rear.

The most important component of the modern electric lighting system, and one that has made electric lighting practical, is the incandescent lamp. This produces light because a filament of conducting material becomes heated by the passage of electric current and gives off rays when it is in an incandescent condition. The electric bulbs used in automobile lighting systems have tungsten filaments instead of the carbon members formerly widely employed in lamps used for house lighting. The tungsten filament gives a more intense and concentrated light than the other forms, and its current consumption is much lower. The filament is stronger and more enduring as it is not liable to be broken by vibration incidental to motor car use. An ordinary carbon filament consumes about 3.5 watts per candle power, while the tungsten loop uses but 1.25 watts to provide the same degree of illumination. The economy of the tungsten filament

is of special importance if the current used for lighting is derived from a chemical source, and even if a mechanical generator is used this can be made lighter and more compact and require less power to drive it than if ordinary carbon filament lamps of equivalent candle power were used. New type bulbs filled with nitrogen gas give still greater illuminating value than the vacuum form employing either carbon or tungsten filaments.

The types of lamps and bases used are shown at Fig. 685. The bulb shown at A has a cluster-loop filament and an Edison screw

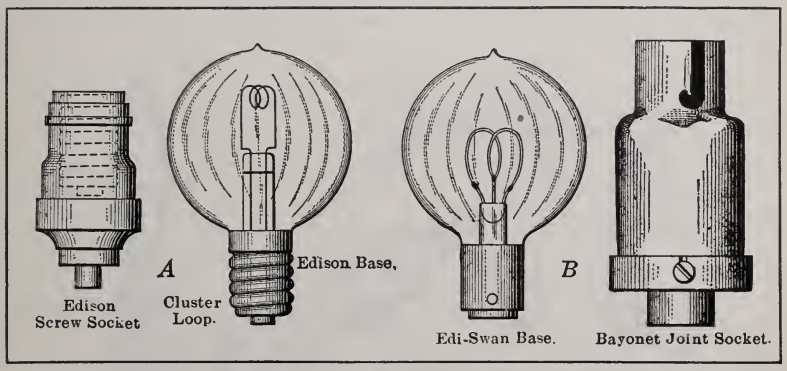


Fig. 685.—Incandescent Bulbs and Sockets Used in Motor Car Lamps.

base. The lamp is screwed into a suitable threaded socket and the circuit is completed when the stud on the lamp bottom makes contact with a suitable contact spring in the socket. The objection advanced against the Edison screw base is that this may be loosened by vibration, and as soon as the lamp becomes loose and the button at the bottom leaves a contact spring the circuit will be interrupted and the light go out. The continued vibration may cause the lamp to work out of the socket and become broken.

Many motorists favor the Edi-Swan method of bulb retention. In this the lamp base is plain and is provided with a couple of small locking pins. A special slotted socket is used and when the lamp is put in place it depresses a strong spring that makes contact and which also locks the lamp firmly in place when it is given a quarter turn, so the pins fit into small depressions at the side of the main slot. This form of lamp cannot jar loose and it is easily inserted or removed from its socket. The object of using a short and thick filament of the cluster-loop type is to provide for secure anchorage of the leading in wires, and at the same time to provide a more intense

and concentrated light, which is better adapted for use with the forms of reflectors where the lamp must be at the correct focal point to secure proper projection of the beam of light.

When an electric lighting system is provided the current can be adapted to other uses besides merely providing illumination of the roadway. Small fixtures used for illuminating the speedometer, oil gauge or clock may be easily brought into use by merely pressing a push button located at some convenient point. The interior of limousine bodies may be brightly illuminated, and other conveniences in the form of trouble lamps and cigar lighters may be used to ad-

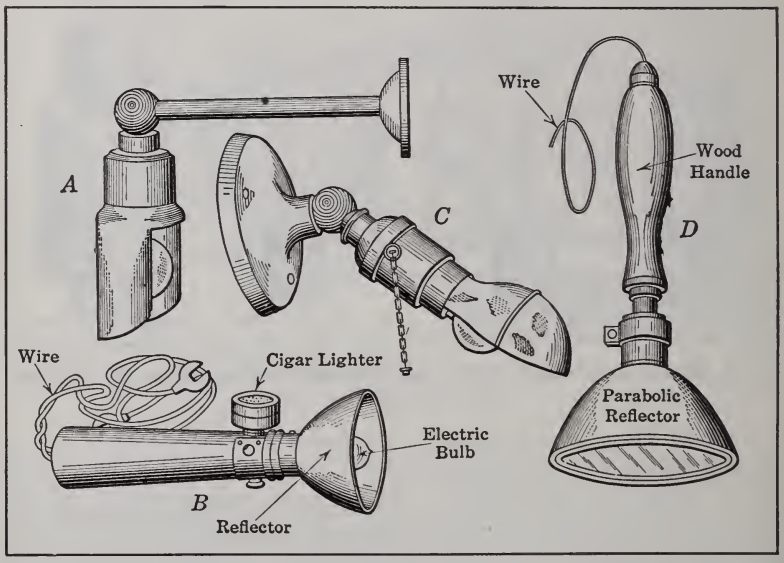


Fig. 686.—Convenient Electric Fixtures that May Be Included in the Equipment in Modern Cars Using Electric Lighting Systems.

vantage. Some of the special forms of lamps are shown at Fig. 686. That at A is a small dash fitting designed to throw the light from the lamp directly against the face of a clock or speedometer. A useful "trouble lamp" which combines a cigar lighter as well is shown at B. The bulb is mounted in a special reflector attached to a suitable handle which is connected to the source of current by a long, flexible wire cable which permits the lamp to be used at all points of the car. The form shown at C is a modification of the dash type depicted at A and is used as a side bracket for interior illumination of closed bodies. The search light illustrated at D is a modified form of that shown at B and does not combine a cigar lighter.

An electric headlight of very good design is shown at Fig. 687. The lamp is mounted in a movable base that may be adjusted so the bulb will always be in the proper relation to the parabolic reflector to throw an intense beam of light. As will be evident the construction of such a lamp is simple and makes possible smooth forms, which are much neater appearing than gas lamps if only the electric filament is used for illumination.

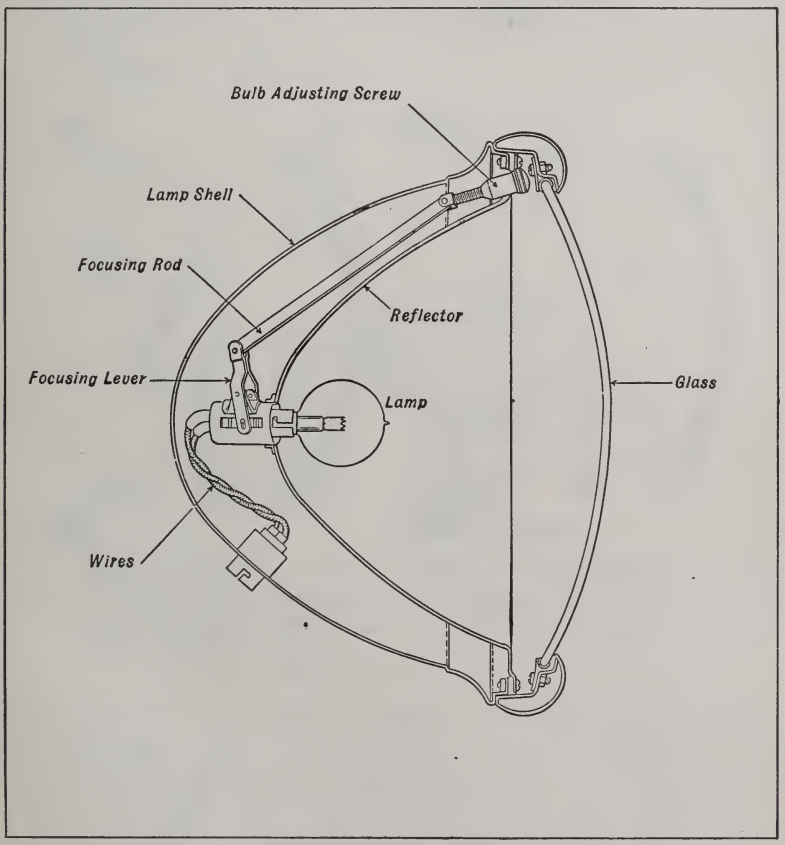


Fig. 687.—Sectional View of Gray & Davis Electric Headlight, Showing Method of Focusing Bulb by Accessible Adjusting Screw.

Many automobilists, especially in Europe, are inclined to be suspicious of innovations, and because of their familiarity with kerosene oil and gas lamps they desire to retain these and use the electric bulb as well. This is easily done in the case of side lights by putting in a bulb at some point where it will not interfere with the regular

burner. Gas-burning headlights may be converted to use electric current when desired by simple adapters as depicted at Fig. 688. These are clamp members attached to the burners. A lamp socket is mounted in such a manner that it may be swung out of the way as shown at A, when it is desired to use the gas flame or moved back so that it occupies about the same position relative to the lens mirror as does the gas flame when electric light is desired. The position of the bulb at times it is desired to use electricity instead of gas is shown at Fig. 688, B.

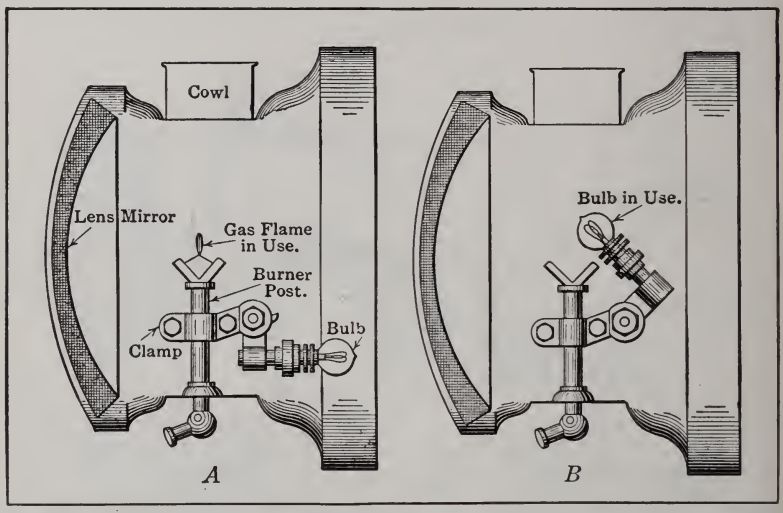


Fig. 688.—Combination Headlight Fitted with Both Gas Burner and Electric Bulb. A—Position of Bulb with Gas Flame in Use. B—Electric Bulb Furnishing Light.

New Things in Electrical Lamps.—Designers of automobiles have not been slow in adapting the lamps used in their electric lighting systems to secure various advantages in mounting or by combining several lamps to simplify installation. At Fig. 689, A, the secure method of attaching the headlights on the Pierce-Arrow automobile by having the lamp case securely attached to the mud guard is shown. The combination of small and high candle-power bulbs in one lamp used on the Packard cars is shown at B. This is made necessary because in some communities the law is very stringent against glare from headlights. When used in a city the small lamps, which are of low candle-power, may be used, while the headlights can be turned on when in the country. The combination of the two lamps used on Locomobile is shown at Fig. 689, D. In this the low candle-power bulb is placed

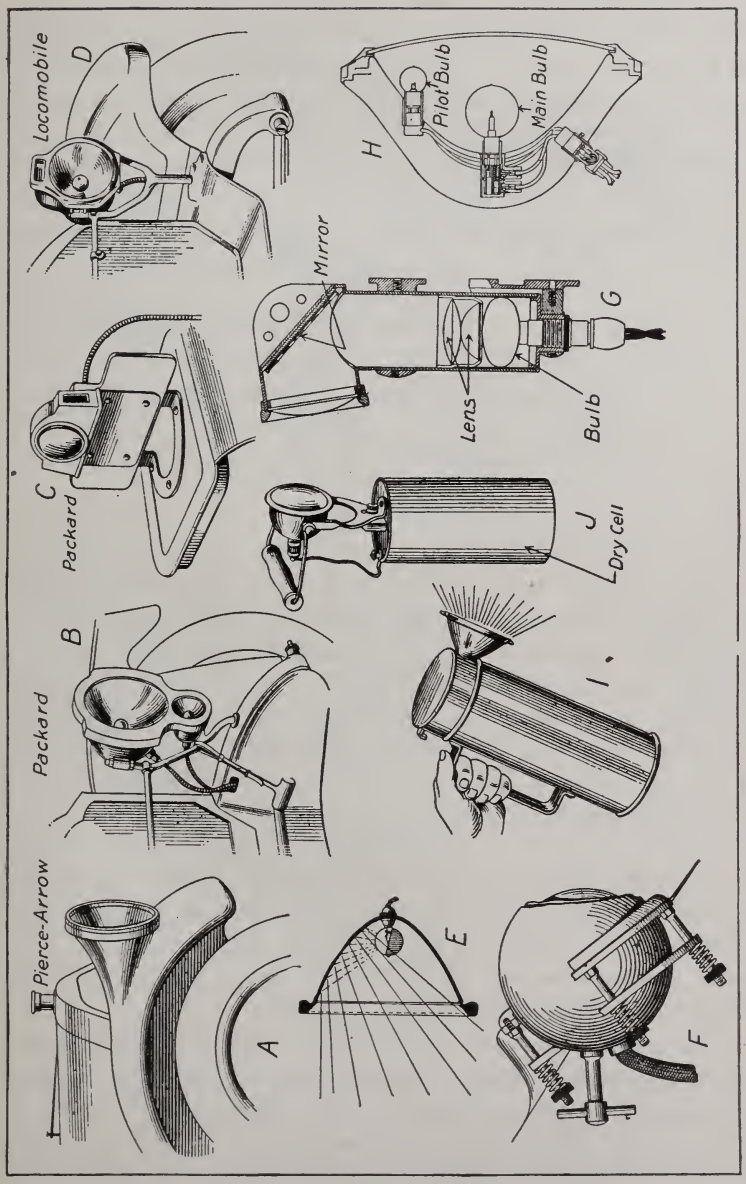


Fig. 689.—Improvements in Electric Lamps for Motor Car Use.

in the upper part of the lamp. The secure method of fastening the tail light and license plate carrier on the rear of a Packard mud guard is shown at C.

The internal construction of a double bulb lamp is shown at H. In this the small bulb for city work, which is termed the pilot bulb, is carried in a socket at the top of the reflector in such a way that its rays are reflected to the ground instead of producing a glare, as the main bulb does, because it is at the proper focal point of the parabolic reflector. The pilot bulb is intended for city driving, or when the car is standing idle at night. A number of devices have been introduced to reduce glare, these consisting of special reflectors, or special lens glasses for the front of the lamp. A simple device, which is shown at Fig. 689, E, consists of a metal shield, which fits close to the lower half of the headlight bulb, throwing all of the light rays against the upper half of the reflector. It is said that this makes the light upon the roadway more intense than when the deflector is not used, but prevents any rays from rising more than four feet from the ground.

A peculiar form of glareless headlight, which is known as the Roffy, has been recently introduced, this being of the unconventional form shown at Fig. 689, G. The amount of light available depends upon the candle-power of the bulb used. The bulb is carried at the lower portion of a vertical tube very little over two inches in diameter. The lamp is a special mushroom shape, and immediately above it is a plano-convex condensing lens that collects the light. Immediately above this is another lens of double convex form which converges the light and throws it against the inclined mirror at the top, which in turn throws it through a projection lens, which forms the front glass. This compensates for the color distortion introduced by the condensing lens. The reason why the lamps are glareless is that they throw a very sharply defined cone of light, whose rays are so inclined, due to the angles of the mirror, that the upper beam is parallel to the ground. As the light never rises above its source, which is lower than the height of a man's eyes, there is no glare.

An unconventional form of searchlight for use in the cowl dash is shown at Fig. 689, F. This is known as the "eye-ball" type, owing to the fact that the body of the lamp is spherically formed, which permits of the projected beam being turned at will through an angle of about eighty degrees in both horizontal and vertical planes. The body of the lamp is held between two rings secured to the pressed steel cowl. The lamp can be used as a dirigible searchlight for reading signposts, etc., while, if an extension cord is provided, the lamp shell can

be taken directly out of its socket and used to investigate trouble at any point on the car. This is a French invention.

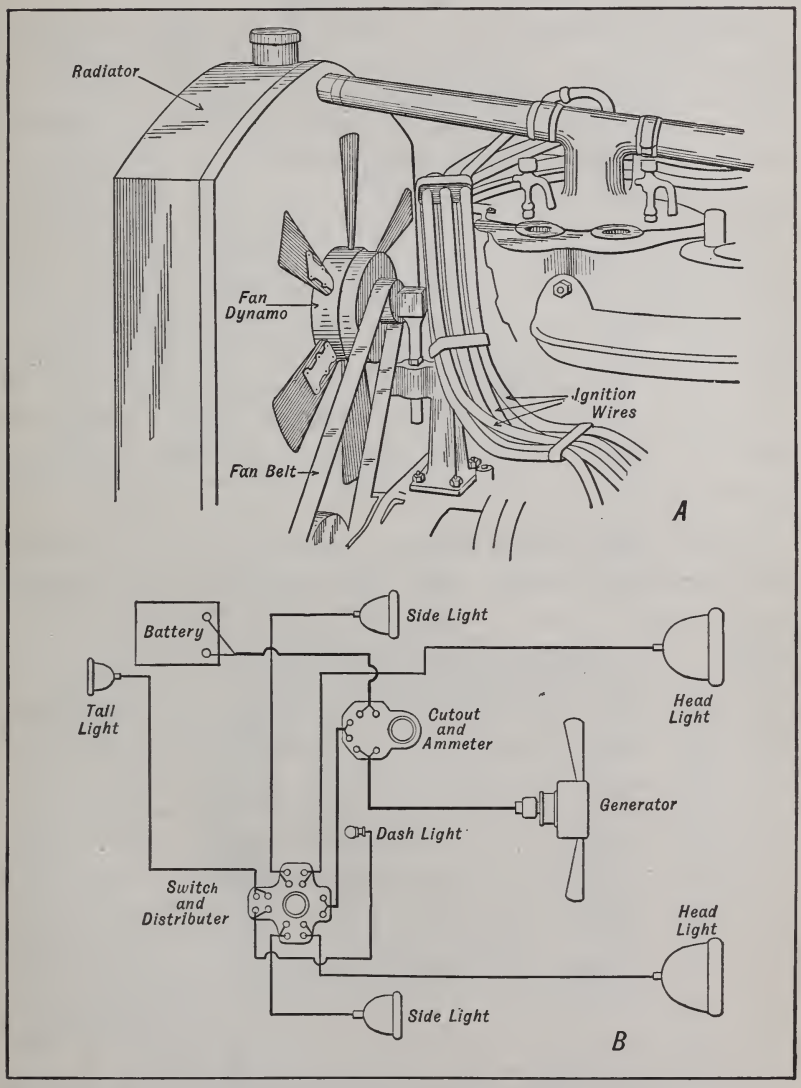


Fig. 690.—Showing Method of Utilizing the Kemco Combined Fan and Dynamo.

The development of the tungsten filament bulb has made it possible to secure very satisfactory light from ordinary dry cell current. Two forms of hand lanterns using dry battery current are shown at Fig. 689, I and J. That at J is a simple fitting designed to be attached to

any dry battery, having a handle by which it may be carried. The form at I has the dry battery inserted in a suitable metal carrying case, which makes a much neater arrangement.

The Kemco Combined Fan and Generator.—Considerable difficulty has been experienced by motorists owning old-model cars and desiring to fit electric lighting systems on account of no provision having been made by the makers of the car for installing or driving a suitable generator of electricity. A combined fan and dynamo which is novel in construction is shown at Fig. 690. In this the rotary member of the generator is provided with a series of fan blades and is intended to replace the cooling fan usually supplied on most cars, whether air or water cooled. The dynamo portion is very compact and very little of the efficiency of the cooling fan is sacrificed to obtain the advantages incidental to electric lighting. The generator is so arranged that it may be driven by the fan belt in just the same manner as the fan originally supplied with the car. A wiring diagram showing the method of installing the various components comprising the Kemco lighting system is presented at B, while the appearance and method of mounting the generator are shown in the drawing above it.

The Care of the Storage Battery.—The storage battery is the part of the lighting and starting system that requires the most attention, and unless this receives periodical inspection it is apt to be seriously damaged. The interior construction of an Exide double seal, burned connector type cell is shown at Fig. 691. The first point to observe is cleanliness of the battery and interior of the battery compartment, which must always be clean and dry. All small articles, especially of metal, must be kept away from the battery. All terminals and connections should be kept coated with vaseline. If any electrolyte has spilled out of the battery, it should be wiped off with waste wet with ammonia and the bottom of the battery compartment covered with a small amount of slaked lime to neutralize the acid. It is essential that pure water be added to all cells regularly and at sufficiently frequent intervals to maintain the solution at the proper height above the plates. This height varies in different batteries, but the important point to observe is that the plates are always covered with solution. The solution should never get below the top of the plates.

The vent plugs are removed to add the distilled water, which may be introduced with a syringe, and should always be screwed down tight after filling. In warm weather, the battery cells should receive distilled water every week and once every two weeks in cold weather. Never add acid to the solution and do not use any water known to contain even small quantities of salts or mineral water of any kind.

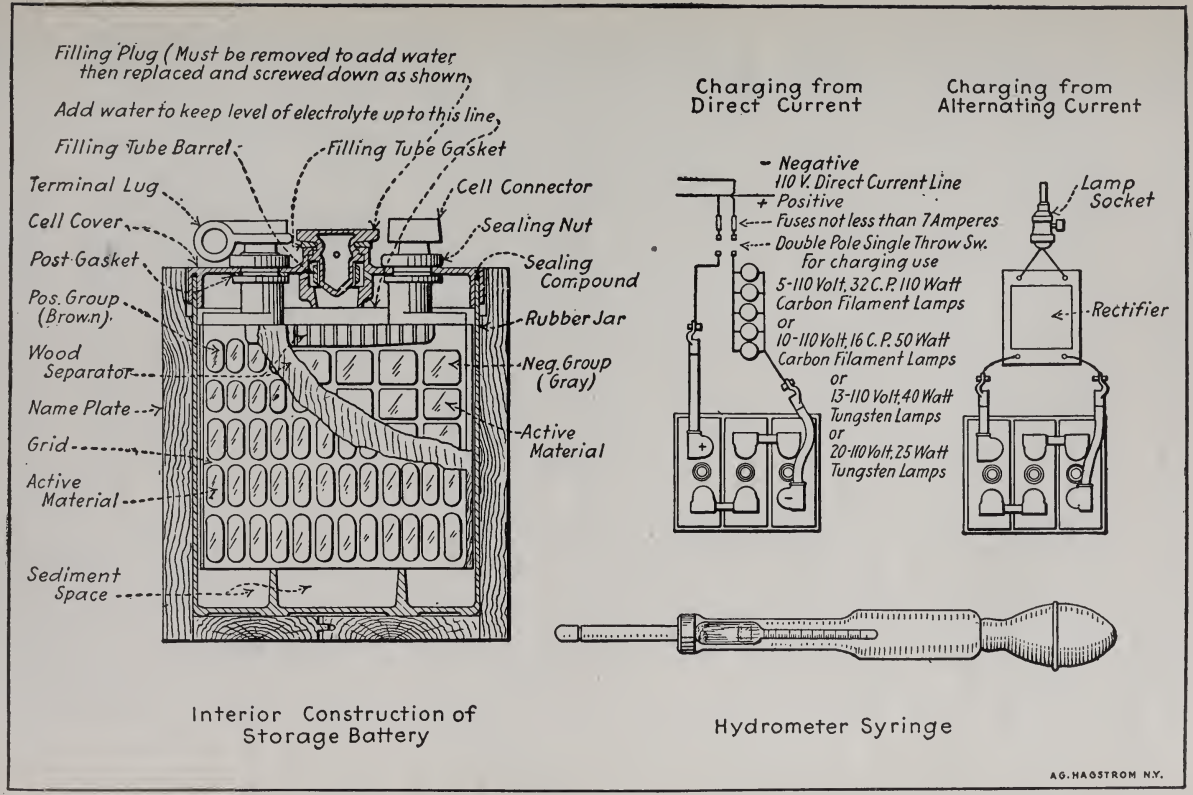


Fig. 691.—Illustrations Showing Sectional View of Storage Battery and Methods of Charging from Direct and Alternating Current. Note also Hydrometer Syringe for Testing Specific Gravity of Electrolyte.

If distilled water is not available, melted artificial ice or fresh, clean rain water may be used. The water should be added at regular intervals as recommended even though the battery may apparently function correctly without it.

The best way to determine the condition of the battery is to test the specific gravity of the solution in each cell with a hydrometer. A convenient time to do this is when water is added, but the reading should always be taken before any water is introduced into the cells. Specific gravity readings are made with a hydrometer syringe of the type shown. To take a reading with this instrument, insert the end of the rubber tube in the cell, being sure to place it below the level of the electrolyte. Squeeze the bulb, then slowly release it to draw up enough electrolyte from the cell to float the hydrometer. The reading is taken from the graduated stem of the hydrometer at the point where it emerges from the solution.

The gravity reading is expressed in "points," the difference between 1.275 and 1.300 being 25 points. After testing, the electrolyte must always be returned to cell from which it was taken. When all cells are in good order the gravity should test within 25 points of being the same in all cells. A reading above 1.200 indicates the battery is more than half charged. The nearly complete charge is indicated by a reading of about 1.275. A reading below 1.150 indicates that the battery is completely discharged. The complete charge is indicated by a reading anywhere between 1.275 and 1.300.

In charging from an outside source, which is often necessary if the car is operated extensively at night and very little in the daytime or if the engine starts hard, there are two possible methods. Only direct current can be passed through the battery, although, of course, the current flowing through the mains may be either direct or alternating. The most convenient method of charging when a direct current is available is to use a lamp bank resistance as indicated in one of the accompanying sketches. This limits the current to the proper charging rate in amperes depending upon the number of lamps used. The ordinary 6-volt battery will be properly charged if five 110-volt, 32-candle power carbon filament lamps or ten 16-candle power carbon filament lamps are used. It will take thirteen 40-watt tungsten lamps to accomplish the same results.

Always connect the positive terminal of the battery, which is that marked "P" or indicated with a plus sign, to the positive charging wire and the negative terminal of the negative charging wire. If connections are reversed, serious injury to the plates will result. The charging wires may be tested for positive or negative polarity by trial

with a voltmeter or by dipping the ends in a glass of water containing a few drops of electrolyte. This will indicate the negative wire by the bubbles formed upon it.

Any storage battery which is to stand idle should first be fully charged. A battery not in active service may be kept in condition by giving a freshening charge at least once a month, but it should also be given a thorough charge before it is replaced in service. In order to avoid freezing the battery it should always be kept in a fully charged condition. A discharged battery will freeze at 20 degrees above zero, while one that is one-quarter discharged and which shows a specific gravity of 1.260 will not freeze at temperatures exceeding 60 degrees below zero.

When 5-32 candle power lamps are used in the lamp bank it means that 5 amperes will flow through the battery. If the battery is completely discharged and it is a 100-ampere-hour type, it will take approximately 24 hours to charge it completely. When alternating current only is used for the lighting mains it is necessary to interpose a rectifier between the line wire and the storage battery. Simple rectifiers that may be connected to any lamp socket may be obtained at relatively small cost from dealers in electrical appliances. During the winter season it is well to remember that a storage battery is only about 50 per cent. as efficient as during warm weather and the lamps should only be used when necessary and no current wasted in useless engine starting. A depleted storage battery always shows when it is discharged by causing the lamps to burn dimly or supplying so little current that the starting motor will barely turn the engine crank shaft over.

Inspection and Care of the Dynamo and Motor.—The manufacturers of starting and lighting systems have made every effort to have the various units function as nearly automatically as possible. At the same time some attention will be needed by the other parts of the system though these do not need the periodic inspection that must be given the storage battery. The dynamo should be looked over and any carbon dust that has been worn away from the brushes due to the abrading action of the commutator and which has fallen to the lower portion of the commutator compartment should be blown out with compressed air because a considerable accumulation of this material, which is a conductor of electricity, may allow a leakage of current to the ground or produce a short circuit between the brush carrier and the generator casing. A blackened or rough commutator must be smoothed down with fine sand paper while the armature is rotating. The makers give positive instructions that emery cloth should not be

used for this purpose. After the commutator has been smoothed, all particles of metal should be removed from the insulation between the copper segments and care should be taken that this insulating material does not project higher than the surfaces of the segments. Any projections should be filed down to a lower level than that of the copper members upon which the brushes bear.

The brushes must not only make perfect mechanical contact with the commutator, but they must also be in good electrical connection with it. Oil or grease on the brush assembly or segments should be removed, and it is well to make sure that there is sufficient spring tension to keep the brushes in positive contact with the commutator. At the same time, the spring tension should not be excessive, because too much spring pressure will cause untimely deterioration of the brushes and will also tend to heat the commutator. The starting motor is subject to the same electrical troubles as the generator. Defects in either the motor or dynamo driving mechanism are of a purely mechanical nature and can be easily corrected by any mechanic. The centrifugal governors used on a number of the generators applied to cars several years old are not apt to give trouble unless parts become broken or the action becomes clogged with gummed oil or grease. Any oil between the clutch faces will prevent proper frictional adhesion, while broken links or springs in the governor mechanism will disturb the continuity of the drive.

Lamp Troubles and Their Causes.—All wiring should be protected from the possibility of becoming covered with grease, oil or water, and in all cases the regular insulation should be supplemented by a conduit or insulating material or a substantial armor. All connections should be gone over to make sure that these are tight. If a fuse is blown or if the protective circuit breaker operates this indicates a "short circuit" between one of the current-conveying wires and the metal frame of the car. A short circuit is often indicated by the action of the ampere meter. If the pointer vibrates on the discharge side it shows that there is a path for the passage of current between one of the wires leading to the lamps or other current-consuming units and the frame. If the lamps do not functuate properly, trouble may be looked for in the wiring or in defective lamps. In many lighting systems the dash and tail lights are wired in series and if one of these goes out it will produce a break in the circuit and automatically make the other go out also. Lamp troubles may be usually laid to defective wiring, "grounds," loose contacts, defective fuses and switches. Dim lights indicate a rundown storage battery.

The user of an electric starting and lighting system will avoid

trouble by observation of the few simple rules which follow and which have been formulated by a prominent manufacturer of these systems:

First—Always be sure that the battery is properly charged and that all connections throughout the system are clean and firm. Second—If the generator is suspected, the only point liable to be at fault is the brush contact at the commutator or accumulations of oil and grease on the commutator. Short circuited armature or field windings are extremely rare. Do not replace worn out dynamo or starting motor brushes with any other than those supplied by the manufacturer and be sure that the brushes are properly fitted to the commutator. Never put oil or grease on the commutator of the generator or starting motor, as this is a point that requires no lubrication. Never turn the hose on the generator, starting motor or any of the regulating devices when washing the car. Third—Inspect the generator driving means from time to time. If a silent chain is used don't tighten up the chain unless the slack becomes excessive from wearing of the link rivets. It is necessary to operate a silent chain reasonably loose to prevent noise and wear. The silent chain drive, if exposed, must be cleaned at frequent intervals and lubricated. Fourth—Never run the car if for any reason the battery is disconnected, unless the chain driving the generator or the generator itself has been removed. Never attempt to propel a car with a starter. Such "stunts" are possible, but expensive! Do not attempt to make any adjustments of any kind in the circuit breaker, regulating relays or dynamo-output governors. Always have this work done by a competent mechanic familiar with the system. Never fuss with the system when it is operating properly.

CHAPTER XIV

MOTOR CAR EQUIPMENT AND ACCESSORIES

Gas-Lighting Appliances and Their Use—Wind-Shield Forms—Shock Absorbers—Bumpers—Speedometers and Mileage Indicators—Tool Equipment for Ordinary Repairs—Miscellaneous Supplies of Value to the Motorist—How Supplies are Carried.

Coincident with the development of the motor car there has been produced a large number of accessories, some of which make for greater comfort while touring and others that have material influence on the safety of the car and its occupants. Many accessories have been devised for application to motor cars of various classes, but many of these are not necessary and have but little real merit. In this exposition the writer will confine his remarks to tried and proven auxiliaries desirable to include in the motor-car equipment and which may really be regarded as necessary to obtain the maximum amount of pleasure and profit possible from motoring.

Many of the devices listed are now supplied by manufacturers as regular equipment because they are considered as much a part of the car as some of the more important components belonging to the mechanism proper. Other devices of considerable value must be furnished by the motorist himself and when one tries to make selections from the stock of the average supply house it is quite difficult to differentiate between the valuable and necessary accessories and those which are not needed unless one is guided largely by the experience of others.

Gas-Lighting Systems.—When the automobile was first invented it was a comparatively slow-speed conveyance, and ordinary oil lamps such as used on carriages or bicycles for illuminating the roadway at night proved adequate for the newer form of conveyance. As cars have become improved it was found necessary to provide stronger radiants than kerosene lamps to illuminate the roadway because of the greater speed capabilities of the improved automobile.

In order to provide higher illuminating powers than would be present by using kerosene alone, the kerosene lamps were supplemented by search lights supplied with burners designed to burn acety-

lene gas, though now electric lighting is practically universal except on some heavy commercial vehicles. As generators and gas tanks are still employed to a limited extent, a brief description of gas lighting means seems advisable. Two methods of furnishing acetylene gas to the burners are in use, one being to use some form of generator which makes the gas as it is needed, the other is to take the gas required from some container where it has been stored under pressure.

The usual form of generator employed in connection with gas lamps is shown at Fig. 692, A. The acetylene gas is generated by combining water with calcium carbide, the latter being a mixture of coke and lime which has been fused together in an electric furnace. Pure calcium carbide will produce about 5.5 cubic feet of gas per pound of carbide decomposed, but the commercial product seldom yields more than 4.5 cubic feet. Acetylene is a very brilliant illuminating gas and gives a white light of about 240 c. p. if burned at the rate of five cubic feet an hour. The strength of illumination can be better judged by comparing it with that produced by burning five cubic feet of good coal gas in the same period of time which will only result in 16 c. p.

A special form of burner is used in the automobile headlight, which mixes a certain amount of air with the gas and the brilliant white light produced is intensified and projected by means of a lens mirror placed at the back part of the lamp. This lens serves to collect and concentrate the rays of light from the flame into a beam composed of parallel rays which have great illuminating power, and which will light up the road for hundreds of feet ahead of the car and permit higher speeds with safety than would be possible with the feeble glimmer of oil lamps.

The generator employed and its mode of action may be easily understood by referring to Fig. 692, A. It consists of a water tank and separate compartments for carbide and gas and a filtering chamber. Water is dropped on the carbide and as soon as the two come in contact the chemical begins to decompose and acetylene gas is liberated while lime dust collects in the bottom of the generator as a residue. The gas collects in a reservoir and forces its way through a filter chamber filled with wool or similar material which filters the gas. The gas is also cooled before it reaches the lamps because the gas outlet pipe and filter is surrounded with water.

When the shut-off valve is opened it permits the water which has collected in the intermediate chamber to drop into the carbide basket through a perforated tube. If the pressure in the intermediate compartment is normal atmospheric pressure, the water will drop freely

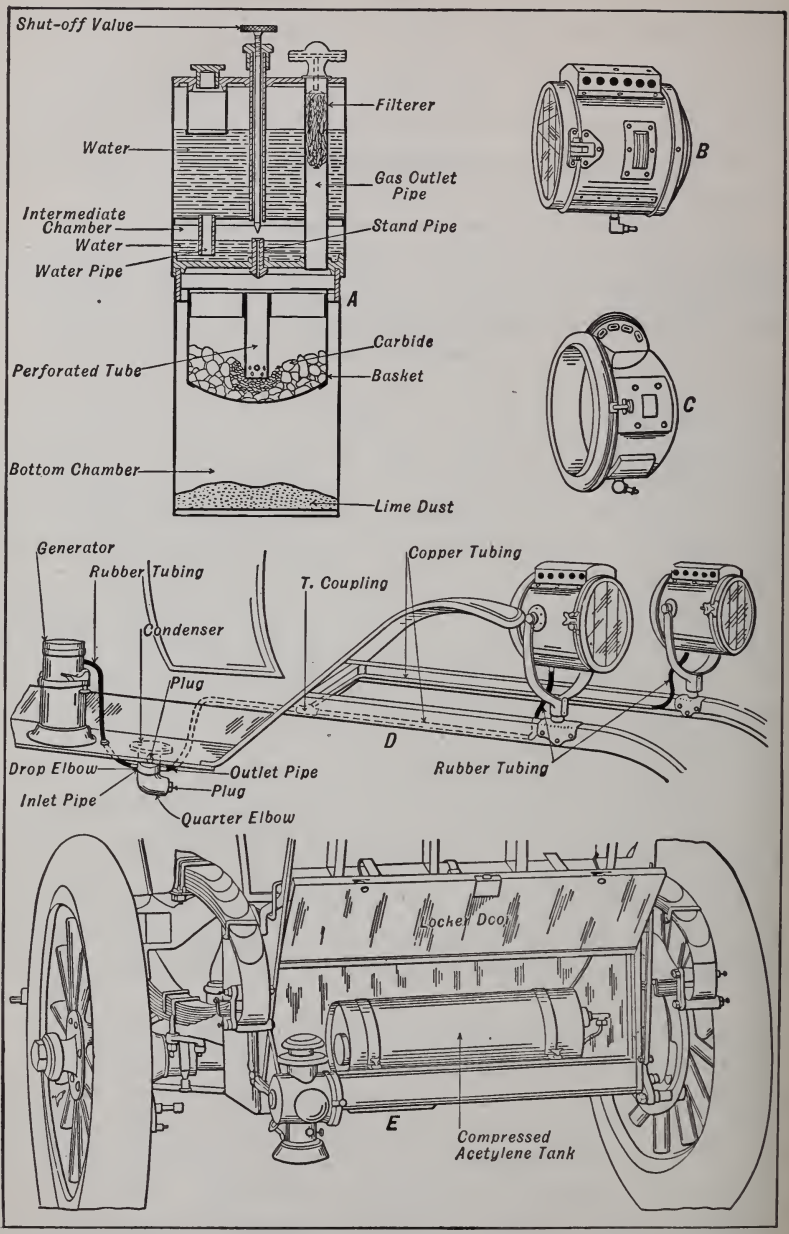


Fig. 692.—Gas Generators and Lamps Used in Connection with Acetylene Headlight Installation.

onto the carbide until considerable gas is liberated. Just as soon as the gas generated has an appreciable pressure it flows into the intermediate chamber and prevents more water reaching the carbide until the gas pressure is lower. The generator will continue to supply gas as long as the supply of water and carbide lasts.

The forms of lamps used are shown at Fig. 692, B and C, and the method of installing a generator and lamp outfit is clearly outlined at D. The headlights are usually placed at the front end of the frame where they are carried by suitable brackets or yokes, and connection with the generator is made by lines of copper and rubber tubing which convey the gas from the generator to the burner. A trap is sometimes interposed between the generator and the burners to arrest any foreign matter or moisture that may have passed through the filtering material in the gas outlet pipe.

The method of installing a compressed acetylene storage tank sometimes used to supply the gas instead of the generator shown at E has advantages in that the tank may be easily reached when it is desired to replace it, and at the same time it is out of sight and not liable to become damaged. When the construction of the car does not permit the use of a separate locker for the gas tank this member is often carried on one of the running boards of the car.

When acetylene lamps are used they are usually supplemented by a set of oil lamps which are provided at the sides of the dash and as a rear signal; while the kerosene lamps do not give much light they are dependable in every way because they are very easy to understand and require no care except an occasional trimming of the wicks and filling with kerosene. If the acetylene lamps did not function properly the kerosene flames would provide sufficient illumination so that the roadway immediately in front of the car would be lit up enough to detect obstacles, and at the same time the lamps would act as a warning signal to other users of the highways. Kerosene lamps are also useful for city driving where the intense glare of the acetylene lamps would be annoying. The old style motor-car lighting system consisted of two headlights, burning acetylene gas, two dash lamps, and one tail light burning kerosene. If a gas generator is kept clean and properly filled with carbide and water there will be no trouble in obtaining adequate supplies of gas. While burners sometimes clog up it is a very easy matter to clean out the openings with a fine piece of wire or to supply a new burner if the defective one cannot be repaired. At the present time practically all pleasure cars and many trucks are equipped with electrical lighting systems.

Utility of Wind Shields.—One of the items of equipment that conduces to comfort of the occupant is the wind shield. In winter this member serves to deflect the cold wind and provide a transparent shelter for those behind it while in summer it is useful in screening the eyes when driving on dusty roads. Wind shields are made in many forms, though the usual materials employed are celluloid and leather or wood, metal, and glass in combination. Typical wind-shield forms are shown at Fig. 693. That at A consists of a metal frame covered

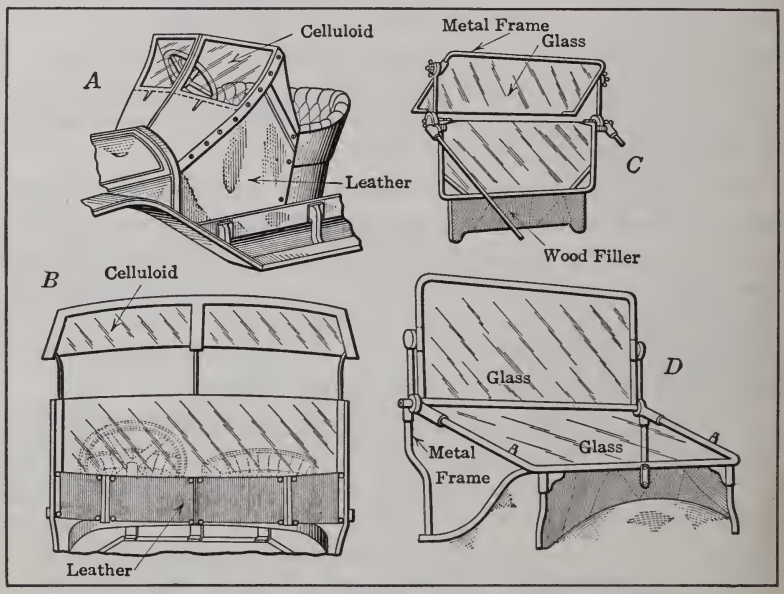


Fig. 693.—Conventional Wind-shield Forms.

with leather and provided with transparent celluloid windows. Side curtains extend from the frame to the sides of the seats and the passengers are completely protected. Another form of celluloid and leather wind shield is shown at B. This differs from the form previously described in that it is vertical, whereas that shown at A is inclined at an angle and will offer less air resistance than the forms which are at right angles to the frame-side member. The advantages of using celluloid are that it is lighter than glass and that it is not liable to become broken. The disadvantage to its use is that it will crack very easily and cannot be looked through as easily as the less opaque glass.

Glass wind shields are usually composed of a frame of brass tubing in which large panes of plate glass are set. The frames are usually

constructed with joints so the top portion of the wind shield may be swung down out of the way when it is not needed. The metal frame which carries the glass is set on a wood filler piece of such form that it will fit the dash, and the whole assembly is braced by means of rods extending from the lower frame to the front or sides of the car, as shown at Fig. 693, C and D. Wind shields are an indispensable item of equipment and no automobile can be considered complete without this useful means of protection.

Function of Shock Absorbers.—Even when the springs of automobiles have been very carefully selected with reference to the loads they are to sustain, as previously stated, it is difficult to make provision for the many variations in loads and speed of the vehicle. A car that will be very easy riding on good roads will be uncomfortable on rough highways because the light springs jounce the occupants around if the car is operated at anything except slow speed. In order to provide smooth riding it is customary to select springs that are a

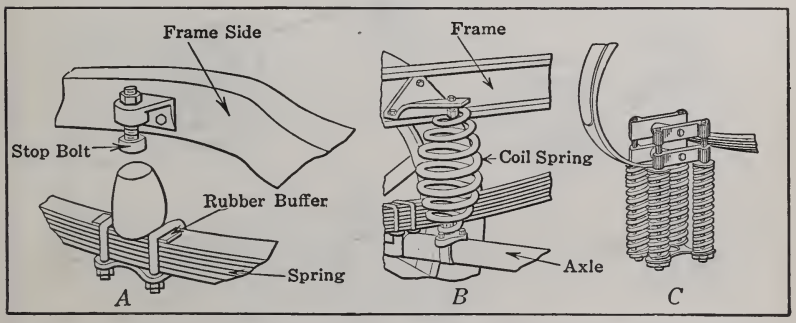


Fig. 694.—Methods of Promoting Easy Riding by Using Auxiliary Springs or Buffer Devices.

compromise and that will not be too hard riding on good road surfaces and yet will not move unduly when the car is run over rough roads.

Various forms of shock absorbers have been devised to supplement the action of the vehicle springs. These may be in two forms, those designed merely to receive shocks caused by sudden spring deflections and other appliances devised to check excessive motion of the springs by providing a dampening action. The simplest form of shock absorber is shown at Fig. 694, A. This is designed for use with springs which are too flexible and which may settle down if the car is loaded to its capacity. A rubber buffer is carried by a clip piece extending under the spring clips to hold the rubber pad in place. An angle

bracket is riveted to the frame-side member if the spring is hung outside of the frame, and this carries a bolt which engages with a rubber bumper to stop excessive movement of either frame or spring.

An auxiliary spring designed to work in conjunction with the main supporting members is shown at Fig. 694, B. This is a heavy coil spring carried inside of the frame member, one end being attached to a forging bolted to the frame side and the other to the axle. Such a spring will not interfere with small spring deflections, but it will prevent excessive motion of the frame or axle either on spring depression or rebound. When springs are so stiff that they will not yield readily to the minor inequalities of the road surfaces it is customary to provide some form of auxiliary spring as shown at Fig. 694, C. A spring of this nature replaces the usual shackle or link, and the small coil springs will yield readily to obstacles that would make no impression on the stronger leaf spring.

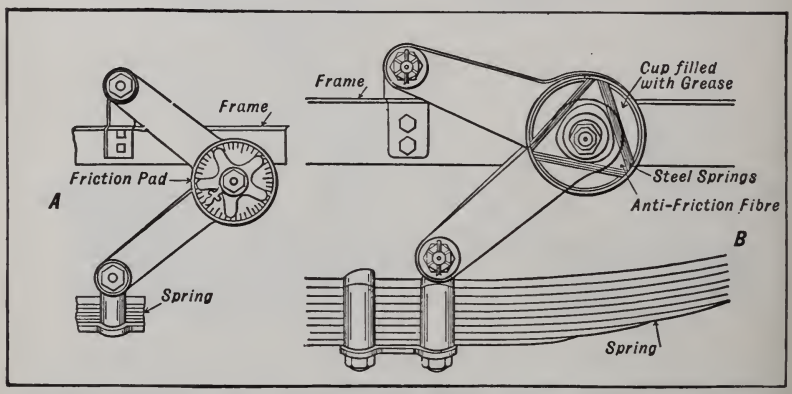


Fig. 695.—Efficient Shock Absorbers that Retard Violent Spring Action on Rough Roads. A—Trufault-Hartford with Friction Pads. B—Connecticut Device Moves Cam Against Spring Resistance.

Shock absorbers that act by producing a dampening effect to check spring movement are shown at Fig. 695. The simplest of these comprises a pair of levers hinged together at one extremity and attached to the frame and spring, respectively. The form shown at A has a friction pad between the two portions at the hinge and this member provides the dampening effect desired. The form shown at B is somewhat different in principle. One of the levers is cup shape while the other carries a cam. A number of steel springs are inserted in the cup and excessive movement of either frame or axle is prevented by the friction effect of the three-point cam on the three compound leaf springs inside of the cup.

Many other forms of shock absorbers have been devised, some consisting of cylinders filled with oil and having a piston to act as a check to prevent too rapid movement of a plunger rod working in the cylinder. One member would be secured to the axle and the other to the frame. Many makers furnish shock absorbers as an item of regular equipment, and if a car which is not equipped with these members does not ride as comfortably as desired the spring action may always be improved by installing some form of shock absorber best adapted to meet the conditions. Springs that are too flexible should either have their action dampened or should be provided with some auxiliary buffer. Hard riding springs can be improved by the use of auxiliary cushion springs as shown at Fig. 694, C.

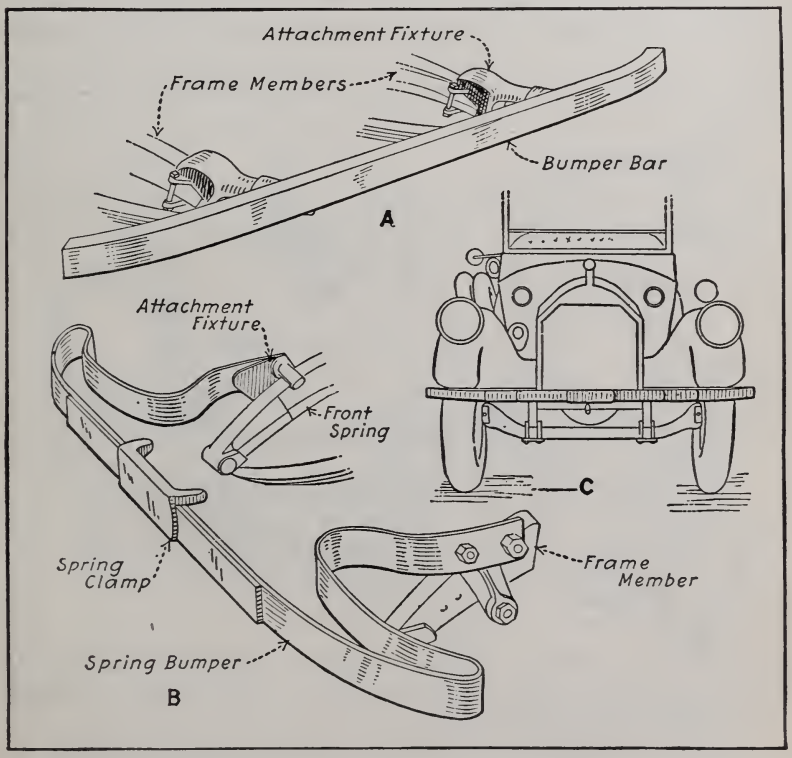


Fig. 696.—Typical Bumpers and How They are Applied to Automobile Frames.

Utility of Bumpers.—A device of comparatively recent development, which is now considered a necessity, is the collision protector or bumper shown at Fig. 696. These are intended to be attached to the front and sometimes to the rear frame members of the chassis.

Their purpose is to take the shock of collision in event of one running into another car, as in dense traffic or having a wagon or other automobile back into the car unavoidably. The forms vary, two popular designs being shown. That at A is a nickeled channel bar of steel attached to spring backed plunger carried in attachment fixtures secured to the frame ends. In that shown at B, the bumper itself is made in the form of a leaf spring, and while it is strong, it is sufficiently resilient to absorb considerable shock. These bumpers are not very expensive, and as they may save a costly radiator or pair of headlights when placed on front or a dented fuel tank or body panel when placed at the rear, they are a good investment. The front view of the car shown at C indicates how a bumper is mounted.

Signals and Alarms.—The laws of all commonwealths make it imperative for the motorist to equip his car with some form of warn-

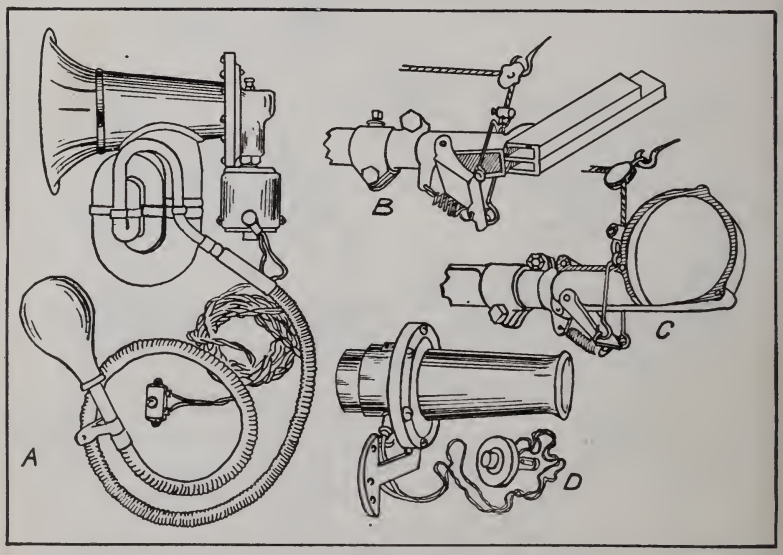


Fig. 697.—Forms of Motor Car Alarms that Give Satisfactory Service. A—Combined Klaxon Signal and Bulb Horn. B and C—Exhaust Whistles. D—Electrically Operated Signal.

ing signal that will be adequate to advise other users of the highway of the car's approach. Many forms have been devised ranging from simple reed horns operated by hand pressure on a small rubber bulb to more complex alarms in which an electric motor serves to actuate a diaphragm and produce a noise that can be heard for a long distance. A combined hand- and electrically operated signal is shown at Fig.

697, A. An ordinary form of bulb-operated reed horn is attached to the sound intensifier of an electrically operated signal. The object of combining the two alarms in one is to provide a hand-operated alarm for ordinary driving, while the louder electrical signal is employed when the sound must be heard for a considerable distance.

The signals shown at B and C are operated by the exhaust gases and are attached to the end of the exhaust pipe. They are operated by depressing a small foot pedal on the foot board, and various sounds may be produced from a mellow note to a shrill whistle depending upon engine speeds. The alarm shown at D is operated by electrical means and the diaphragm is actuated by a small electric motor which will run from the storage battery usually employed for ignition purposes. The advantage of the electrically operated signals that makes them popular is apparent. The push button may be attached to the steering wheel convenient to the driver's hand and the signal may be obtained by a simple pressure of the finger, which is sufficient to close the circuit and actuate the apparatus which produces the sound.

Speed-Measuring Devices.—When one considers the stringent laws of most communities regulating the speed of motor vehicles it will be

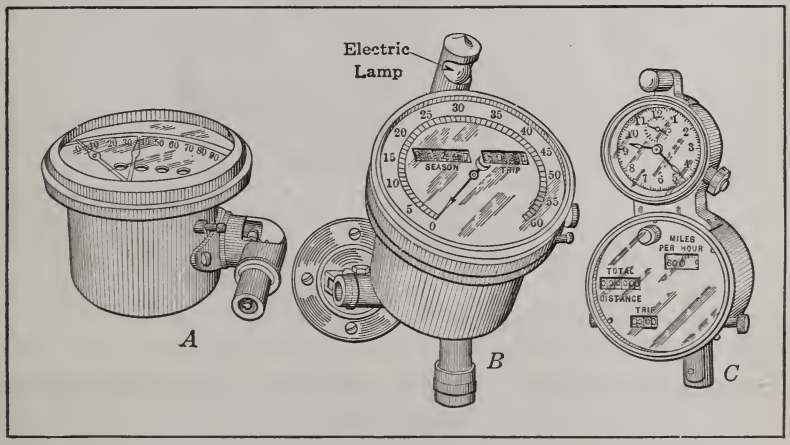


Fig. 698.—Speedometers are Useful for Indicating Speed and Mileage.

evident that some form of speed-indicating device is necessary to show the velocity at which the car is traveling at any time. Speedometers are usually combined with odometers or mileage counters, and it is not uncommon to provide a clock as well. A speedometer has other uses besides merely indicating the rate of travel. It forms an excel-

lent indication of the value of different carburetor adjustments and it enables the motorist to compile definite figures regarding fuel and oil consumption or tire depreciation for a given period of time.

Various speedometer forms are shown at Fig. 698. That at A is a simple instrument to indicate the speed and distance. The type depicted at B indicates the total distance traversed and the number of miles covered on each trip as well as the speed. It is provided with a small electric lamp at the top to illuminate the dial at night. The speedometer shown at C has all of the features of the other two instruments with the added one of having a clock to indicate the time. Speedometers are usually placed on the dashboard of the car and are driven from the front wheels by means of suitable reduction gears mounted on the steering knuckle and a flexible shaft, or in some late practice, the device may be driven from a universal joint or gear-set drive shaft as shown at Fig. 699.

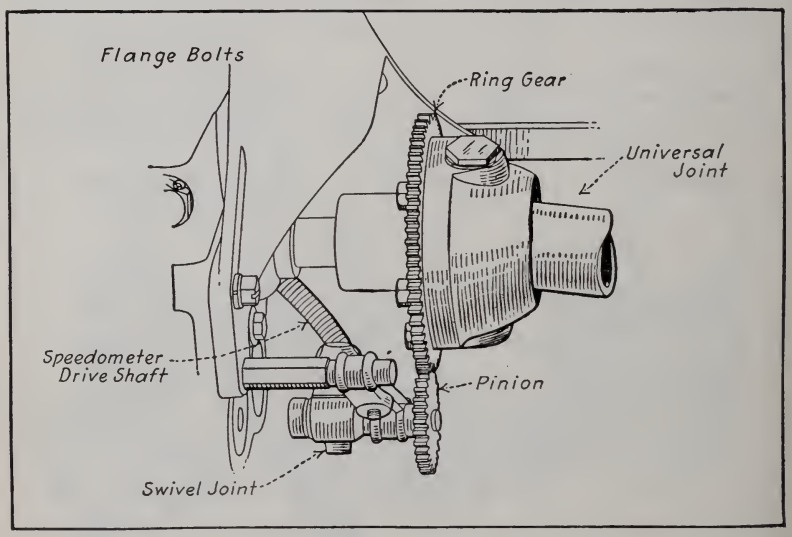


Fig. 699.—Latest Method of Driving Speedometer by Drive Gears from the Universal Joint.

Speed indicators may operate on different principles, some depend on magnetism, or the flow of liquids, others utilize centrifugal force and operate just the same as the fly-ball governor of an engine. An instrument which depends upon the principle of centrifugal force to indicate speed is shown in section at Fig. 700. The driving shaft carries a pair of weights which are thrown out as the speed increases. These weights swing a pair of segments meshing with

the circular rack and impart an up and down reciprocating motion to this member as they revolve. The circular rack meshes with a small spur pinion and its reciprocating motion is converted to an oscillating one by means of the pinion. A pair of bevel gears transmit the motion of the spur pinion to the speed-indicating needle at the top of the apparatus. The weights and their position are so

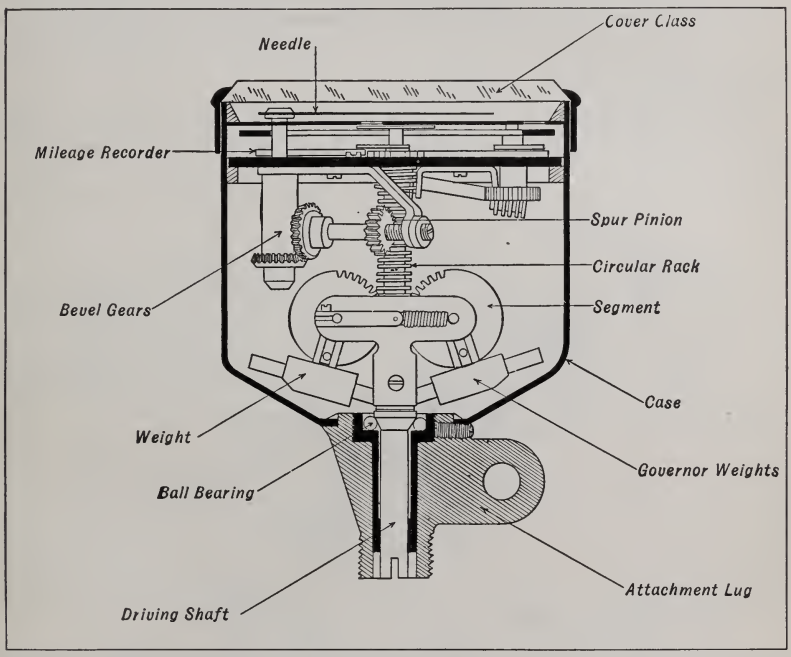


Fig. 700.—Sectional View of a Speedometer which Depends on Centrifugal Force of Governor Weight to Actuate Indicating Needle.

calculated that as the speed increases they fly out from center and pull down the circular rack. This, in turn, moves the spur pinion and bevel gears, and causes the needle to register the speed corresponding to the position of the governor weights.

A small train of gearing similar in principle to that used in a bicycle cyclometer is carried between the speedometer case and the dial, and serves as a distance-recording gauge. The driving shaft to which the governor weights are attached is driven by a flexible shaft connecting to one of the front wheels in the conventional manner. It is contended that speedometers which depend on centrifugal force are more accurate under all conditions than those utilizing either magnetism or the flow of liquids to indicate the speed.

Those who favor the magnetic principle advance the contention that instruments of this character are more sensitive and will register low speeds more accurately than instruments depending upon centrifugal force. All of the many forms on the market have been used with success, however, and any speedometer of a reputable make is certain to furnish satisfactory service. Some form of speed-indicating device should be installed on every car, and their obvious utility can be easily understood when one remembers that the amount of one fine for fast driving will pay for a very efficient speed-indicating and mileage-recording instrument.

Winter Comfort.—A number of heaters have been devised to make motoring more pleasant in cold weather. At Fig. 701, A, the driver's

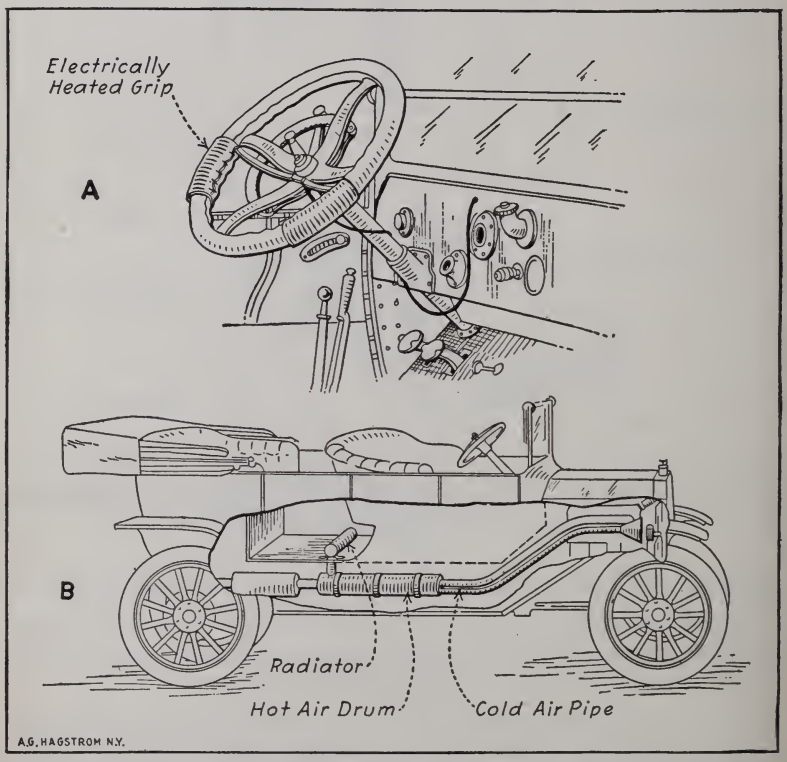


Fig. 701.—Accessories for Winter Driving. A—Electrically Heated Grips on Hand Wheel. B—Heater for Tonneau.

fingers are kept from getting cold by heating the control wheel. Two electrically heated grips are laced to the steering wheel rim, one at each side, and these are connected by a cable which runs down the

steering column to the storage battery. When installed on Ford cars, they may be connected directly to the magneto. The equipment includes wiring and switch. The heat is furnished by resistance coils imbedded in insulating material. The view at B shows a hot air heating system by which the exhaust pipe is made to heat air in a hot-air drum which rises to a radiator that acts as a foot-rail.

Running Board Accessories.—The fitting shown at Fig. 702, A, is reproduced from *The Automobile*. When the interior of a closed car

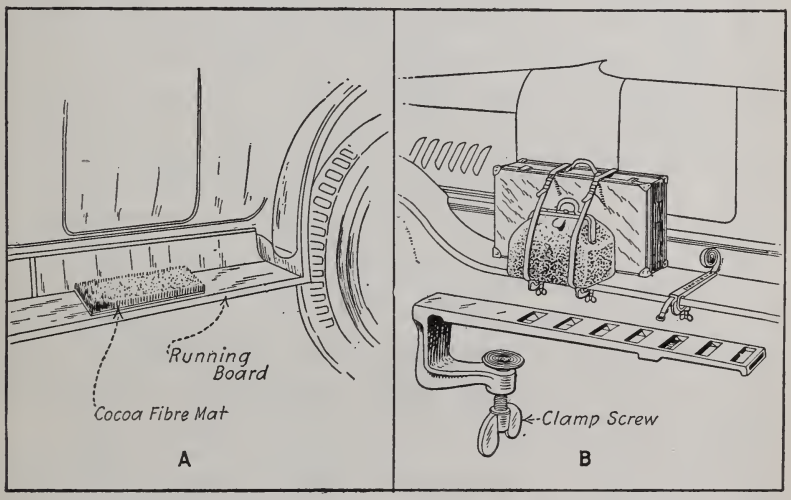


Fig. 702.—Useful Running Board Accessories. A—Mat for Cleaning Dirt from Shoes. B—Simple Luggage Carrier.

is fitted up with delicate trimmings and carpets like a lady's boudoir, and many cars are of this nature, it is an advantage to keep dust and mud off the floor, yet anyone stepping into the car from the street cannot help carrying a little dirt on his shoes.

To avoid this an idea which originated in Paris and ought to be popular in the big cities of America is worth mentioning. This is to have a small piece of stout door mat neatly cut and edged and strapped to the running board just below the door opening. The mat can be sewn to metal end pieces and screwed to the running board, or it can be fixed with screws and washers, the heads of the screws being well buried in the mat. As an accessory a device of this sort should sell well. It would need to be of a quality to suit high-grade cars, but need not cost a great deal.

Kemco luggage carriers, as shown at B, are securely fastened to the running board by means of thumb screws. It is not necessary

to drill any holes through the running board. It is claimed that the device will not rattle or work loose if properly installed. Suit cases, traveling bags, golf bags or parcels of any size may be safely carried and can be quickly strapped in place and removed. They do not touch the side of the body to mar the finish. The carriers may be removed in an instant and stowed away.

Tools and Miscellaneous Equipment.—In equipping a car for the season's use many factors must be considered, as the character of the supplies and spare parts required will vary with the type and make of car, while the tools needed for repairing the mechanism will depend largely upon the mechanical ability of the car owner or the person in charge of the automobile. While a very complete outfit of tools and spare parts would be the best insurance against trouble, it should be remembered that the weight of the tool outfit should be kept to as low a point as possible. As a general rule comparatively few well chosen tools that would be apt to be used often would be superior to an indiscriminately selected bulky outfit by one who has no knowledge of the value of the various appliances or how to use them. In modern motor cars it is easy to find storage room for a very complete assortment of tools and supplies, and while some of these may be considered unnecessary there may be a time when it will be invaluable especially if much touring is contemplated.

The first point to consider is selecting the common tools that one would be apt to need and as a guide a very complete tool roll such as sold by practically all automobile supply houses at a moderate price is shown at Fig. 703. The choice of a container for tools and supplies is very important and while the tool roll depicted, which is made of heavy canvas or leather, is very useful it has the disadvantage of being inconvenient to handle. As it must be unrolled every time certain of the tools would be needed, the ground is usually the only available place for its extension and the contents and casing may become very dirty. The writer prefers to use a tool box in which a number of trays are fitted. These are divided into compartments, each tool having a distinct space and to insure against rattle or injuring the tools the various compartments may be lined with felt or heavy cloth. A very good method of making the trays is to have these composed of or filled in with a wooden block, which is recessed to fit the tools to be carried. A container of this nature is superior to others as the tools needed most often can be placed in the uppermost tray, making them accessible, while in a roll the tools needed most often may be carried in the center. Some motorists throw the tools indiscriminately into a box and the result is that many of the

appliances are damaged by coming in contact with other tools. The cutting edges of cold chisels and wire cutters are nicked, the teeth of files become broken or filled up with dirt, and screw driver points

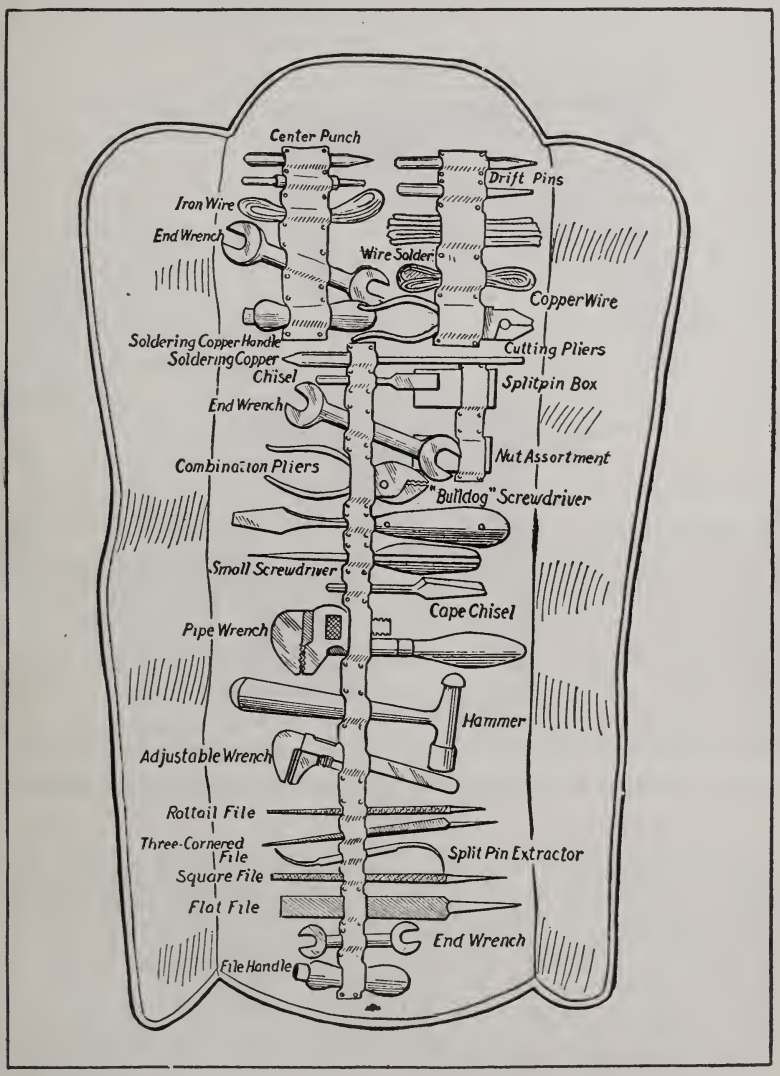


Fig. 703.—Tool Roll Suitable for Making All Ordinary Repairs on Automobile Mechanism.

may become quickly blunted, and their utility reduced. At the same time the handles and polished surfaces of the other tools have

become marred by the edges of the cutting tools. Several of the new 1917 cars make provision for carrying the tools in a series of special pockets in the front door nearest the driver, as shown at Fig. 704.

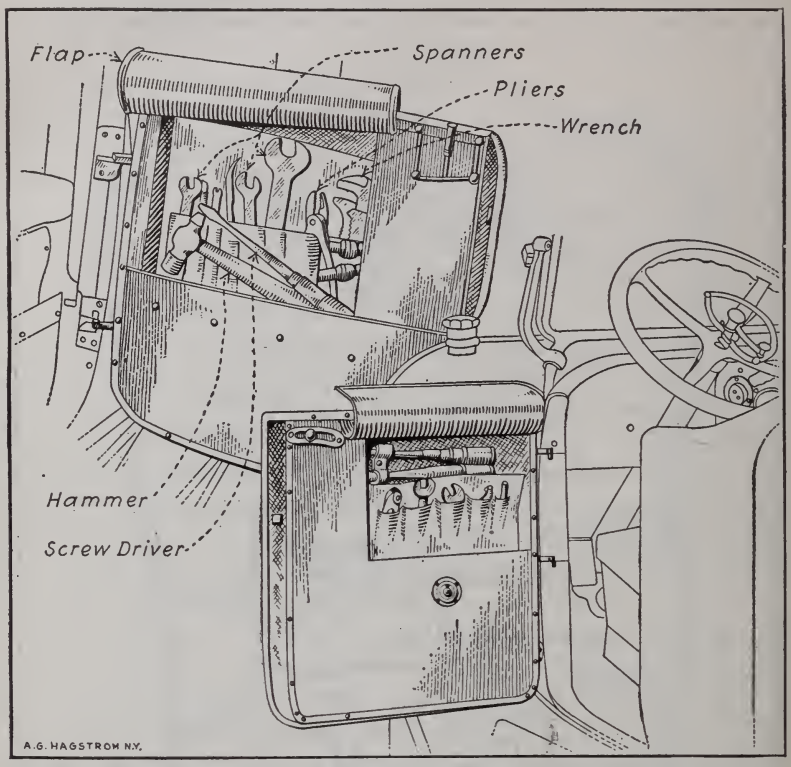


Fig. 704.—Methods of Carrying Tools in Front Door Compartments of Several 1917 Model Cars.

The roll illustrated has a fair assortment of useful tools of good quality. The outfit consists of two screw drivers, two pairs of pliers, two chisels and one center punch, three drift pins, a set of four files, five wrenches, soldering copper and handle, a file handle, a split pin extractor, small roll of wire solder, two small rolls of wire—one soft iron and the other copper, small tin boxes containing extra split pins or locking cotters and lock washers, and a ball pein hammer. The wrenches include a set of three double open-end spanners, one adjustable monkey wrench, and a pipe wrench. Small and large screw drivers are provided and two pairs of pliers, one for handling flat pieces and cutting wire, the other for turning round pieces are included.

In addition to the tools shown in the outfit depicted at Fig. 703, a motorist who intends to make his own repairs will find those shown at Fig. 705 very useful. The valve-spring lifter is employed to compress the valve spring when it is desired to remove the locking key or washer from the bottom of the valve stem, and will be found very useful when the valves are to be removed for cleaning or grinding. The tinner's snips can be utilized to advantage in cutting sheet metal, packings, asbestos brake lining fabrics, stock for shims and many other purposes. The hack saw and a number of extra blades will be found of value when it is desired to cut bars of brass, steel, or iron, and it can be used in cutting wood, fiber, hard rubber, and other materials as well. The adjustable end wrench should be supplied in two sizes, a six inch for small work and one eight inches long for use on larger objects. This form of wrench is especially desirable for motor-car use as the opening between the jaws may be altered to suit requirements, and the angle of the head may be varied so it will work in some very inaccessible places where the ordinary forms of monkey wrench or open-end spanner could not be employed.

A complete file set is an almost indispensable part of the equipment and this should include members of square, round, triangular, and rectangular sections, in order to form various surface profiles needed on motor-car parts. The flat files are usually used for smoothing straight surfaces, and the round and half round are employed on curved pieces. The square file and the "three-square" or "three-cornered" file, as it is often called, are very useful in filing work where sharp corners must be left. In choosing files, one has almost as much latitude as in selecting other tools because they are made in various lengths and with different degrees of cutting power. In purchasing files, it should be remembered that the finer grades are used only for finishing, while those having coarser teeth are employed for roughing out work and removing metal. The file set should include in addition to the forms shown a small fine flat file, about the size of a manicuring file, for fine work on the platinum points of spark-coil vibrators, primary timers or magneto-contact breakers. Files should be carried in cloth or leather cases or wrapped in heavy paper so that the cutting surfaces will be kept clean and away from other objects.

The gasoline blow torch forms part of the soldering outfit and can be used to advantage in heating the soldering copper. It is also useful in heating nuts or bolts that have become rusted in place, and as the flame is very hot the ends of small rods may be heated sufficiently so that they may be bent into eyes or rod ends very

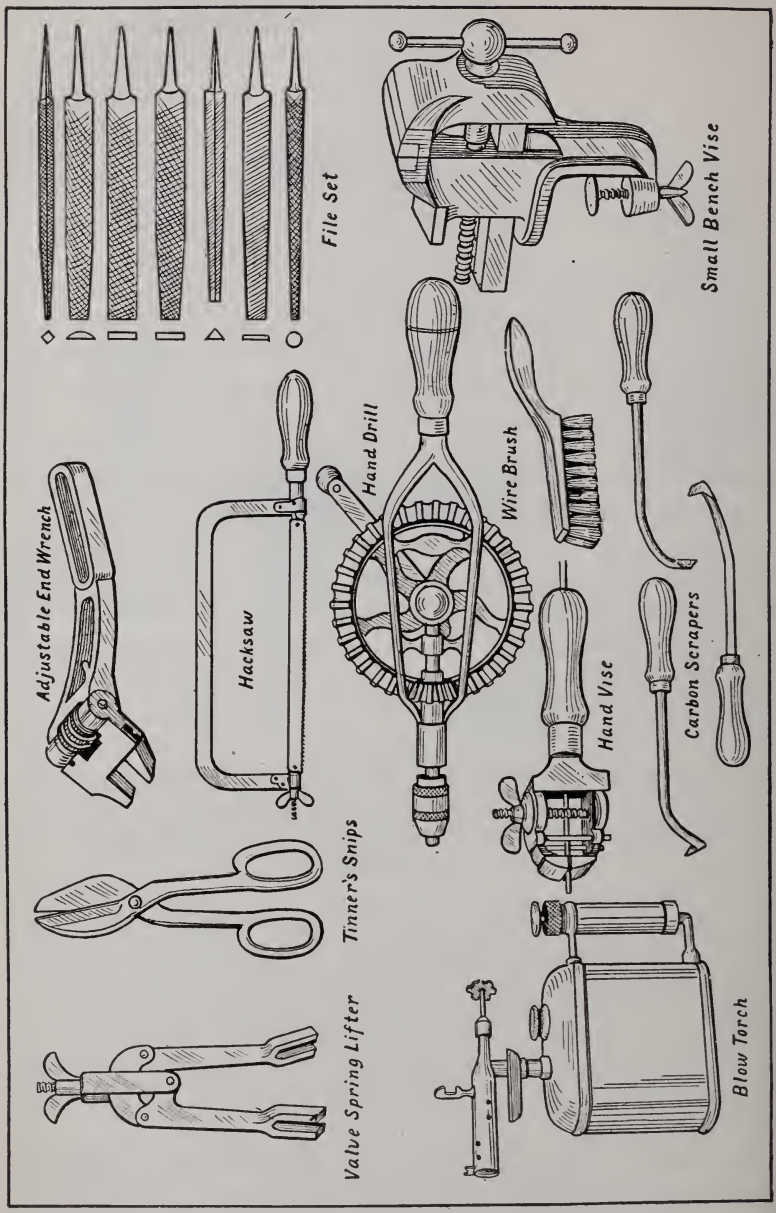


Fig. 705.—Useful Tools that May Be Furnished to Supplement Contents of Tool Roll or Ordinary Small Tool Outfits.

easily. A small hand drill with a number of common sizes of drills ranging from a No. 60 to about five-sixteenths of an inch in diameter can be used so often in fitting small brackets, drilling holes in wood or metal, drilling out broken bolts or studs, and many other uses, that it will soon pay for itself. A wire brush is useful in tire work, where it can be used to roughen up the surfaces of the tube and patch before cementing or vulcanizing and for removing dirt, carbon, or solidified oil from the mechanism and for cleaning the teeth of files.

A set of carbon scrapers may be included with advantage in the outfit because these are formed in such a way that much of the carbon deposit that accumulates in the combustion chamber may be removed through spark plug and valve cage openings by their use without dismantling the engine. A small bench vise that can be clamped to the running board of the car is of value when filing or fitting pieces that could not be held properly with a pair of pliers. A small hand vise is also useful, as this will grip pieces of wire or sheet metal stock much firmer than a pair of pliers, and as the jaws can be clamped together by a winged nut no effort is required to hold the work, which is so securely held that it may be filed or hammered without dislodging it from the jaws of the vise.

In addition to the tools shown a lead- or copper-headed, or reënforced rawhide leather hammer may be included, as this can often be applied for driving bolts in and out without damaging the thread or for use against finished parts because it will not mar the surface. A set of socket or box wrenches and handle will be found useful in reaching bolt heads and nuts which are in inaccessible locations, and it is often desirable to supplement the two or three sizes of fixed spanners or S wrenches usually furnished in a tool roll by a number of other sizes which will permit one to handle practically all standard nuts. A set of five may be obtained that will fit all sizes of bolts from three-sixteenths of an inch to one-half inch, as ten milled openings are supplied which will handle bolt heads or nuts from three-eighths of an inch to fifteen-sixteenths of an inch in diameter.

A ratchet wrench that will fit the spark plug and one that will fit the nuts on the tire lugs have important advantages. With this form of wrench, after the box or end is placed over the nut of bolt head, it is not necessary to remove the wrench each time the handle is moved. The amount of movement permitted will vary with the conditions and sometimes will be only fifteen or twenty degrees. With a ratchet the handle is brought back to the starting point without moving the nut because the ratchet mechanism only holds in one

direction. These wrenches are time savers wherever they can be used.

A word of caution to motorists who are apt to judge tools merely by the price should be heeded. Many men who are not mechanically informed select even the simpler tools by price rather than quality. As a rule the better quality tools only cost a few cents more and will give satisfactory service during a lifetime, while cheaper ones often cannot endure the work of a single season. Cheap chisels and punches are made of soft, improperly tempered steel; cheap wrenches are made from malleable iron castings, instead of steel drop forgings; low-priced screw drivers have the blades of inferior stock and so flimsily secured in the handle that they will turn on the slightest provocation instead of loosening the screw to which they are applied. The motorist who buys cheap tools is penny wise and pound foolish and it is better to purchase fewer tools, but good ones, if economy dictates when the purchase is made.

General Supplies and Spare Parts.—In addition to the tools enumerated there are many miscellaneous appliances that can be carried to advantage. Some of these are necessary only with certain types of cars, and many of the list which follows may be kept at home except when the car is taken on an extended tour which is apt to end at some distance from a convenient base of supplies. The group given at Fig. 706 has been selected because it shows many articles of equipment that have real value.

Funnels to fit the water, gasoline, and oil containers should be carried and it is well to use separate funnels for water, oil, and gasoline. That used for water should have a spout the full size of the filler opening in the radiator and it is desirable that it should include a wire gauze screen to filter the water of any particles of foreign matter that might clog the circulating system. The oil funnel should be small and it can be easily carried by nesting in one of the larger funnels. Sometimes a nest of three funnels may be obtained, one fitting in the other, and the entire set of three takes no more room than one funnel would ordinarily. The gasoline funnel should have a chamois skin through which all fuel would pass when filling the tank. This will remove the water and dirt always present in gasoline and is practical insurance against carburetion troubles.

A collapsible rubber water pail is useful on all types of cars, as it may be used to replenish the supply in the radiator from any wayside source when on the road or to carry water to the car for washing hands after repairs have been made. A small box of some good grease-dissolving hand soap, a clean towel and a piece of toilet soap take

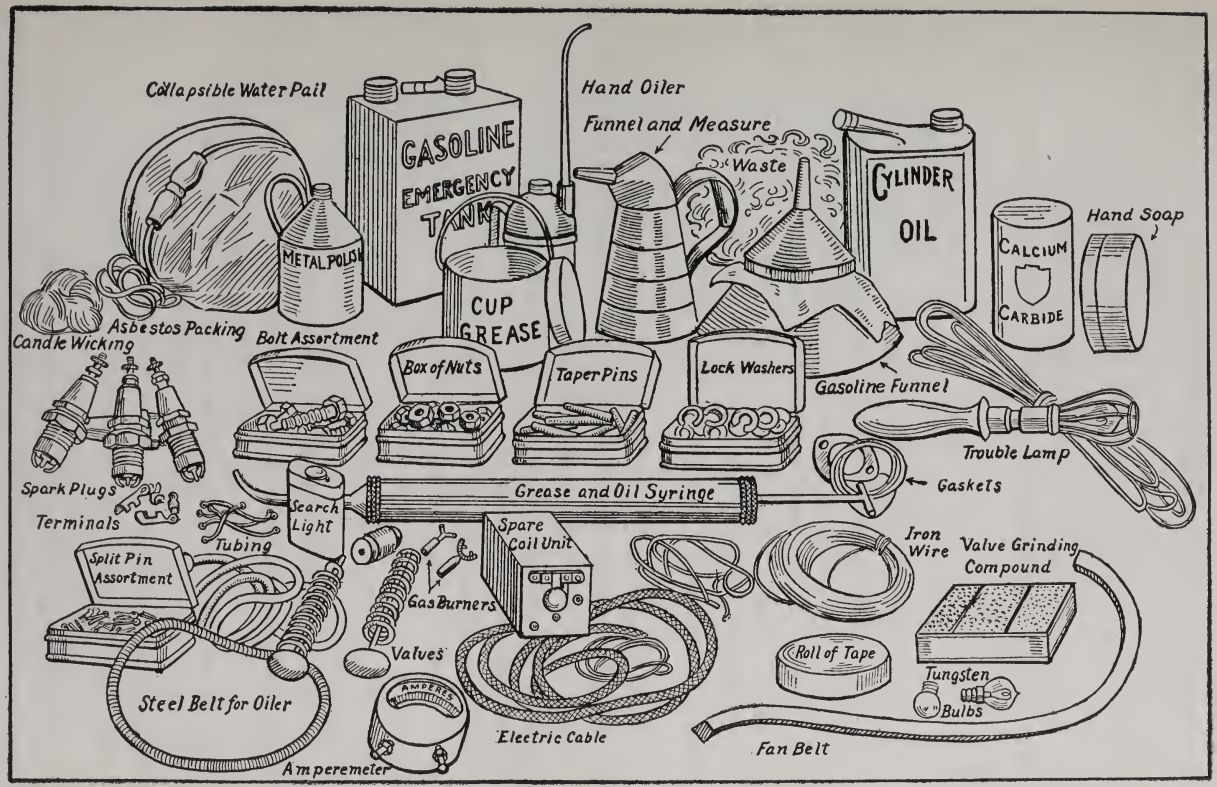


Fig. 706.—Group of Supplies that Can Be Carried to Advantage while Touring or Used in Maintaining Motor Cars.

so little space that they can be stowed away anywhere, and their value is only apparent when a particularly dirty job of tire replacement or car repairing has been necessary on the road. A hand oil can and an oil syringe are needed to lubricate the various parts, the syringe being especially valuable to force oil at points that would not be easily reached with the hand oiler or that would require more lubricant than could be conveniently supplied by that method. A combination funnel and measure is often carried in place of an oil funnel.

It is well to carry a gallon can of cylinder oil and a small can of cup grease any time that one is touring away from home when there might be doubt of obtaining the same grade generally used on the car. With the ordinary single-chamber type of gasoline tank it will be found advantageous to carry a spare container holding two gallons of fuel. This occupies but little space and is practical insurance against being stalled by lack of fuel. Calcium carbide and a pair of extra gas burners should be carried if the car is lighted by acetylene gas from a generator, and extra Tungsten bulbs if the car is electrically lighted. A small hand search light is useful in looking at the gasoline level at night or in inspecting various points about the car where the presence of gasoline fumes would make the use of a naked flame dangerous. For more extended working after nightfall, a small portable trouble lamp, which will take its current from the ignition battery, will often demonstrate its worth.

The character of the spare parts needed will depend entirely upon the make of car, and any component must be chosen with reference to the weaknesses of the machine under consideration. The selection of the smaller parts for replacement should be by an experienced person who has had opportunity to study that make of car. It is well to have a spare valve complete with the spring retention collars and locking key on any make of car. At the present time practically all motor cars use valves that are interchangeable, and but one set for replacement is necessary. If, however, the valves are different sizes it is well to carry one each of the exhaust and intake. It is not necessary to carry these around on ordinary trips and they are merely provided as a safeguard when touring away from a base of supply. It is well to carry at all times assortments of small parts that are easily lost, such as split pins, lock washers, set screws, taper pins, cap screws, semifinished hex nuts, some copper and iron washers, and a few carriage bolts of the sizes used in securing the fenders to the irons or the running boards to the hangers. A roll of soft iron wire and a roll of electric tape are very useful in

general repair work and rubber tubing may be included with advantage for repairs either to the gas piping, conveying acetylene gas to the lamps or the fuel line, leading from the gasoline tank to the carburetor.

Some of the supplies needed that need not be carried on the car are a box of valve-grinding compound, asbestos cord and candle wicking, several sheets of emery cloth and sand paper, and a supply of spare gaskets or packing material, if these are used on any portion of the power plant. If battery-and-coil ignition is used it is well to carry a spare set of batteries, extra primary and secondary wire, battery connectors and terminals, and either a complete coil unit or parts enough to make up a complete vibrator. If ignition is by a high-tension magneto, a complete set of the most important brushes and contact-breaker parts may be obtained at small cost from the manufacturer. No matter what kind of an ignition system is supplied it is well to carry a complete set of spark plugs. These members are liable to give considerable trouble and it is much better to replace a defective member with a new one rather than attempt to repair a poor spark plug on the road.

Spare oiler and fan belts are useful if either the mechanical oiler or cooling fan are driven in this manner. A complete set of tire tools and suitable equipment for tire repairing, such as considered in another chapter, should be provided. It is well to carry all smaller screws and parts in envelopes or small boxes which should be plainly marked so the contents could be ascertained at a glance without requiring examination. Any brightly finished steel part liable to rust should be covered with grease and wrapped in cloth or paper. All goods made of rubber should be wrapped up to protect them from oil, which has a harmful effect. Spark plugs may be carried in wooden or leather cases and they should be wrapped in such a way that they will not be jarred around, as this is liable to break the insulation or bend the sparking points.

One of the various forms of jacks shown at Fig. 707 should be included in the equipment. This member really forms part of the tire-repair outfit, though they are used on many occasions in making repairs when the tires are not at fault. The form at A is a simple lever-operated type having a double ratchet. A series of short strokes will raise the lifting ram, while slightly altering the magnitude of the stroke will allow the lifting ram to fall. In the jack shown at B the lifting ram is raised by means of gearing enclosed in the body of the jack. This is turned by means of a socket wrench, having a handle similar to a bit brace. In the form outlined at C

the lifting ram has a screw thread cut on it and is raised by a bevel gear worked by a hand lever, which includes the ratchet mechanism. A very substantial form of direct lift jack is shown at D. The type

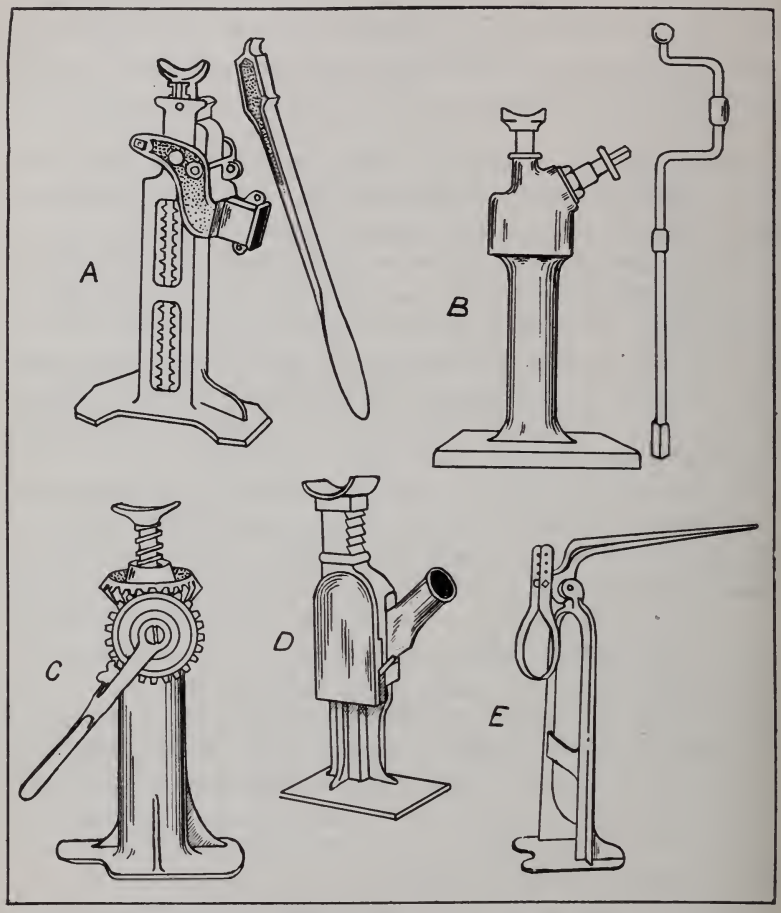


Fig. 707.—Leading Types of Car-Raising Jacks.

outlined at E is used to raise the wheels from the ground quickly and easily and is intended for garage use. These are sold in sets of four and are used by many motorists to raise the wheels from the ground and relieve the tires of the car weight when the vehicle is not liable to be used for a few days or a longer period. The selection of a suitable jack is important, and while almost any form will be adequate to raise a light car, the motorist should be sure that that used in

connection with a heavy vehicle has ample capacity and that it is made of steel instead of treacherous iron castings, such as incorporated in the cheaper jacks.

Among some of the miscellaneous supplies that will be found useful may be mentioned rawhide lacing, fan belt connectors, leather straps, Pyrene fire extinguisher, hose clamps, brass polish and polishing cloths, covers of rubber or fabric for the lamps to protect them in wet weather and chain grips for the tires. If a cone clutch of the leather-faced type is used some clutch compound will be useful in event of harsh action or fuller's earth if the clutch slips. An emergency spring repairer, which comprises a steel forging and two clamps, enables one to make a broken spring operative and may be found of advantage if the car is operated over rough roads without shock absorbers. A coil of rope should be carried on any car that is to tour in comparatively unsettled countries, and special rope made especially for motorists' use may be obtained from the supply houses. These include thirty or forty feet of one-half or three-quarter inch diameter Manila rope, fitted with a heavy galvanized iron hook for attaching. The rope may be used for towing, in connection with a "Spanish Windlass" for pulling the car out of mud holes and ditches, for binding a rear wheel to get increased traction when that member drops in a mud hole, and for securing trunks and packages to the running boards or other portions of the car.

It should be noted that the equipment advised is more than ordinarily complete and it is not likely that any motorist will need more than the articles mentioned, and the majority will be able to get along very well with much less. Many of the supplies enumerated need not be carried on the car except when away from home, but it is well at all times to have a complete outfit of tools and tire repair appliances as well as necessary spare parts for correcting tire troubles or engine derangement.

How Supplies May Be Carried.—A problem with many motorists is how a very complete outfit may be stowed on the average car. The views at Fig. 708 and Fig. 709 show how this difficulty has been solved on some of the leading automobiles of various types. At A the entire outfit necessary for tire restoration is carried at the back end of the car between the rear springs. The trunk case serves as an anchorage for two or three spare casings while the inner tubes and tire repair outfits, as well as many of the general supplies, are easily stowed away in the trunk. In the view of the rear end of the car shown at B a large tool box is placed back of the gasoline tank and has ample capacity to carry all tools and repair parts that

would be needed for ordinary repairing. As the gasoline tank is carried back of the seat there is room under the front seat for many supplies. The form of trunk used in carrying clothing when on a tour is outlined at C. The trunk serves merely as a container and protector for the standard size suit cases that are employed to hold the clothing or supplies.

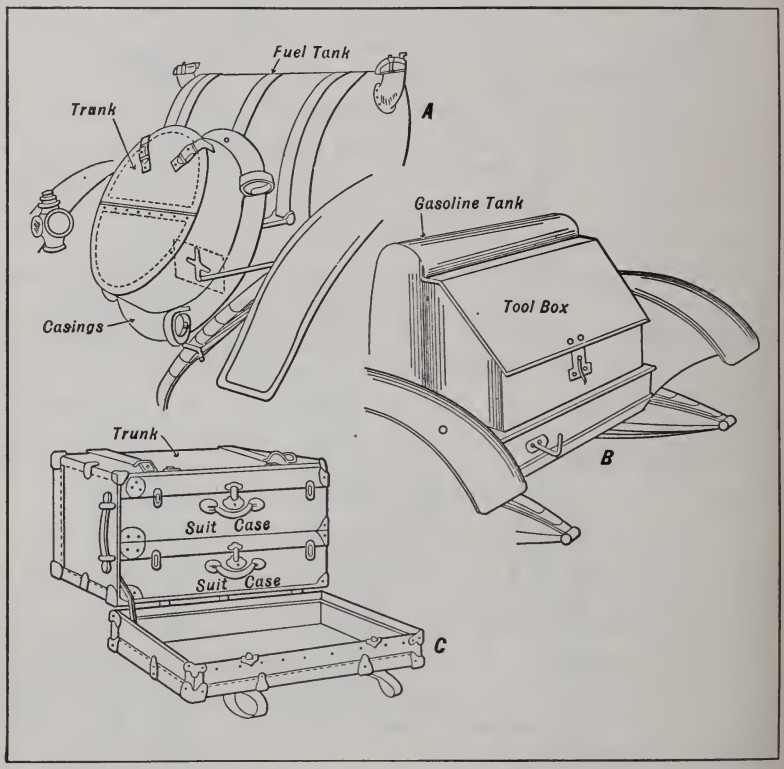


Fig. 708.—Some Conventional Methods of Storing Supplies and Equipment in Automobiles.

At Fig. 709, A, the very ingenious manner in which a prominent maker has utilized the space back of the seat of the torpedo roadster for stowing suit cases is shown. To gain access to these the front seats are pushed forward, the center partition between the seats is raised, and the seat back is allowed to fall. The result is that a large opening is provided through which the suit cases or other bulky supplies may be easily placed in the body compartments. In this the spare tires are carried at the rear end of the car while the tools that

are apt to be often used are stowed away in an easily reached chest on the running board of the car.

At Fig. 709, B, the special case provided for stowing away spare casings. This container is of metal and access to its interior is ob-

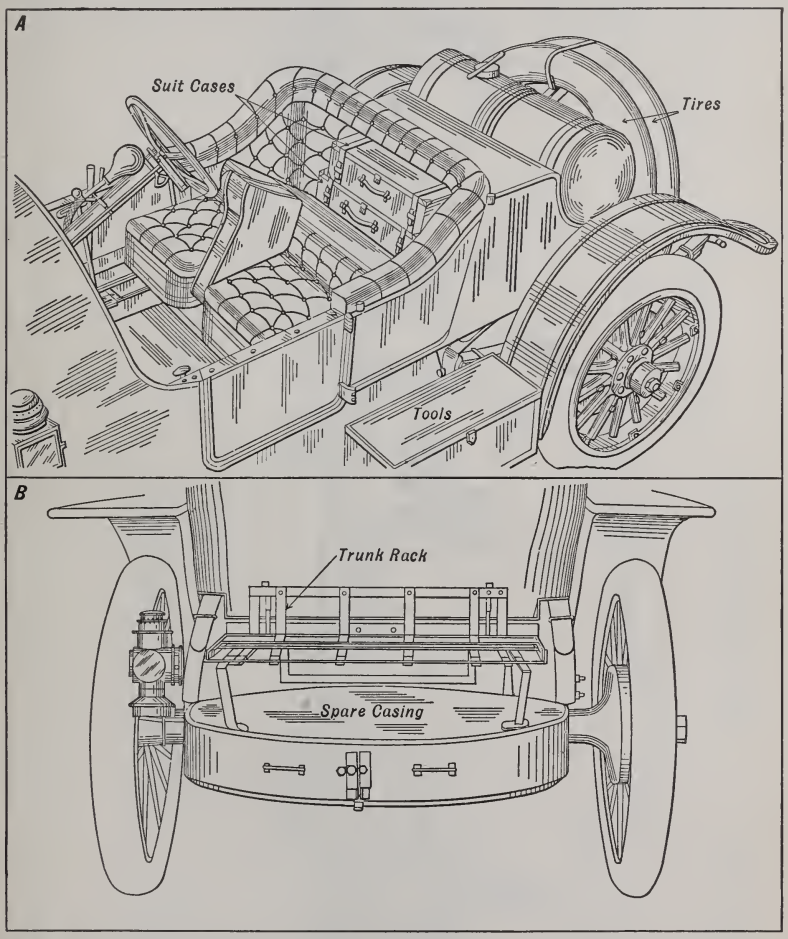


Fig. 709.—How Leading Motor Car Manufacturers Have Made Provision for Carrying Spare Tires and Other Supplies.

tained by releasing the catch and sliding the two semicircular doors around to the back end. This view also shows the form of trunk rack provided on many touring cars to take the automobile trunk shown at Fig. 708, C. A view which shows the practical disposition of the various accessories on the 1917 Pathfinder touring cars is

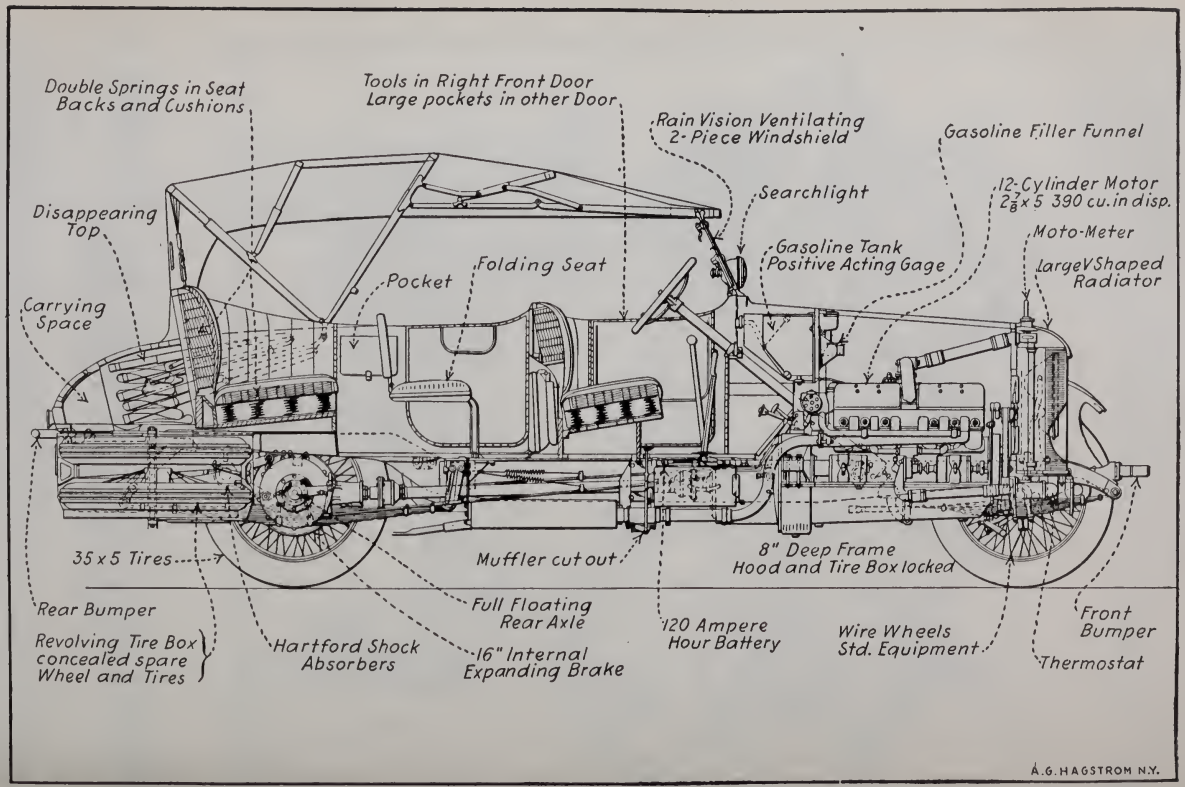


Fig. 710.—Sectional View of Pathfinder 1917 Twelve-Cylinder Model, Showing Disappearing Top and Method of Carrying Spare Wire Wheels.

shown at Fig. 710. A side elevation of the vehicle is given, and the location of the essential accessories and supplies is so clearly shown that it would seem unnecessary to describe these in detail. The placing of the lamps, wind shield, disappearing top, folding extra seats, spare casings and wheels, and various pockets for stowing away the smaller parts may be readily ascertained by a study of the illustrations.

CHAPTER XV

Operating Advice and Explanation of Automobile Control Methods—Utility of Spark and Throttle Levers—Obtaining Various Speed Ratios with Friction Transmission—How Planetary Gearsets are Controlled—Shifting Sliding Gears by Progressive and Selective Systems—Standard Automobile Control Systems Described in Detail—Maintenance Hints of Value—Suggestions for Oiling—Winter Care of Automobiles.

The basic principles of gasoline-motor-car operation are practically the same in all types of cars, though the various forms of speed-changing mechanism demand distinctive methods of control in each specific case. It is not possible to give definite information that will apply to controlling all types of cars, but the general advice given can be applied to all cars, especially the instructions relating to the method of motor-speed control. The methods of regulating the motor speed will be the first point considered; then the control system when the simpler forms of transmission are used, and finally the method of obtaining various speed ratios with sliding gearsets.

How the Motor Should Be Started.—One of the most important points in the education of the novice motorist is the best method of starting the motor if a self-starting device is not provided. Before the engine is set in motion certain precautions must be observed regardless of the make or type of car. The gasoline tank, radiator, and lubricating-oil container should be inspected to make sure there is enough fuel, water, and lubricating oil. The shut-off valve in the pipe line leading from the gasoline tank to the carburetor is opened so the fuel will flow to the vaporizer. The carburetor should be primed by means of a small plunger usually carried in the float-bowl cover, and if a small resistance is felt to the downward movement of the primer or if gasoline escapes from the bottom of the mixing device, this may be considered a positive indication the fuel from the tank has reached the carburetor and that gasoline is present at the spray orifice. The next step is to see that the change-speed lever is in a neutral position or that the clutch pedal is disengaged. The spark-control lever, which is usually carried on the steering wheel, should be set at the full retard point. In some cars this may

be at the back of the sector, while the retard position may be the other extreme in other motor cars.

If one attempts to set an engine in motion by means of a hand crank with the spark lever advanced so that an early spark is obtained, the motor may "kick back," and this reversal of motion, which is due to premature combustion, may sprain the wrist or break an arm. It will be well to open the throttle or gas lever a little to insure that a charge of combustible gas will be inspired into the motor. The engine should be turned over several times as briskly as possible, and then the switch which completes the electrical circuit between the battery and the ignition mechanism should be put into circuit and the switch plug inserted. The hand crank is pushed in until it engages a ratchet member on the front end of the crank shaft, and then the motor should be turned by pulling up on the starting handle with the left hand.

The hand crank should always be engaged so that an upward pull will be necessary to turn the crank shaft, and a point that cannot be too firmly impressed upon the embryo motorist's mind is that gasoline engines should always be started by pulling up on the handle of the starting crank, never by pushing down. If the starting handle has been properly placed and the engine has been turned over enough without the switch so the cylinders hold a gas charge, and the switch circuit is closed when a decided resistance is felt as the crank is turned, indicating that the piston in the cylinder in which the gas charge is about to explode is nearing the compression point, a single, quick, strong pull on the crank should be sufficient to start any properly adjusted motor.

Multiple-cylinder engines, especially those of the four- and six-cylinder type, are started much more easily than the one- and two-cylinder forms. These can often be started by turning the starting handle over briskly so the motor will take in gas but without the switch closing the electric circuit. To start the motor the switch is closed and a spark will be produced in the cylinder about to fire (only in cars equipped with battery ignition) by moving the spark lever from one end of the sector to the other. As soon as the engine becomes started it should be kept from racing by shutting down the supply of gas to the point where the motor will turn freely and yet slowly.

Most hydrocarbon vehicle motors have a certain degree of flexibility, i. e., they may be run slow or fast, and the speed may be accelerated or cut down as desired within a range from 200 revolutions per minute to the maximum, which will vary with the type of motor. This is an important advantage, inasmuch as it permits one to regulate

the vehicle speed on most occasions by a touch of the throttle alone. The engine speed of practically all automobiles is controlled by two levers, though usually these are employed in conjunction. One of these consists of varying the time of the spark in the cylinder, the other regulating the amount of gas supplied.

A typical carburetor-control system is shown in detail at Fig. 711. The throttle, in this case, may be controlled by three distinct means.

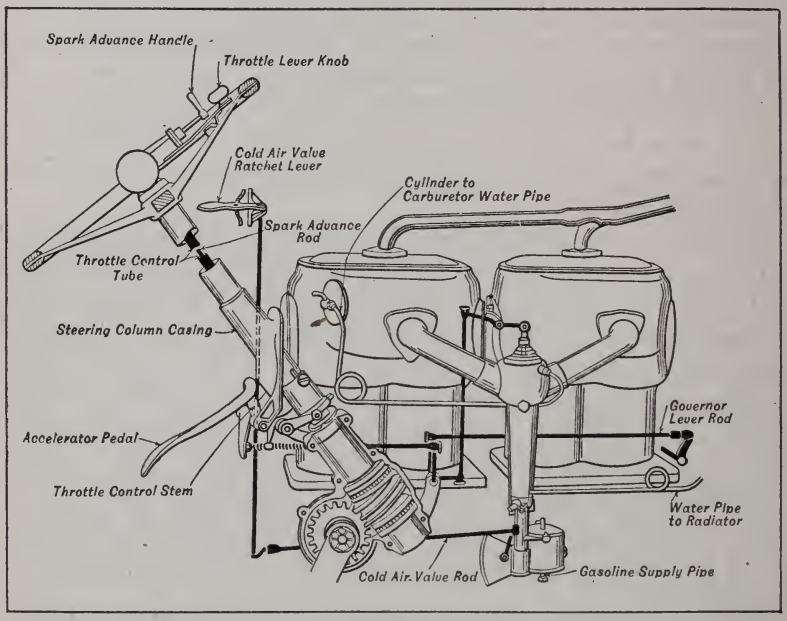


Fig. 711.—Parts of Motor Control System of Early Peerless Car. Spark Advance Regulated by Small Hand Lever, Gas Supply Controlled by Automatic Engine Governor, Accelerator Pedal or Throttle Lever on Steering Wheel.

One of these is a centrifugal governor which shuts off the gas supply automatically if motor speeds exceed a certain predetermined point. The governor may be temporarily dispensed with by pressing down on the accelerator pedal, which will open the throttle directly, or by means of the throttle lever carried on top of the steering column. The usual method of driving is to set the throttle lever at a point which will give the minimum speed desired and depend upon the governor to take care of other speed fluctuations. If it is necessary to get more gas than the governor will allow to pass, the accelerator pedal can be used to operate the throttle directly. The function of the

spark lever is to regulate the time of sparking to the point best suited to the needs of the engine.

The question of motor-speed regulation seems to be a simple one, but many motorists learn proper methods of spark- and throttle-lever placing only after considerable driving experience has been obtained. Motor-speed regulation depends upon two factors. First, advancing the time of sparking to the most efficient point after the engine has once been started, and secondly, increasing the amount of mixture supplied the cylinders. The spark and throttle levers, while designed to be manipulated independent of each other, usually move with a certain definite relation. It would not be good practice to run an engine with the spark lever way advanced and gas-supply throttle nearly closed; nor would good results be obtained if the spark lever was retarded and the throttle opened as it is desired to increase the motor speed. It is not difficult to understand the function of the throttle lever and how the admission of more gas to the cylinders would act in creating more power, just as augmenting the steam supply to a steam engine will increase its capacity.

The rules for manipulation of the spark lever are not so well understood. In order to make clear the reason for intelligent manipulation of the spark handle there are certain points that must be considered. On most automobiles there is a position of the spark lever, usually at the center or intermediate point of the sector over which it moves which corresponds to the normal firing point. If the spark lever is not advanced beyond this position, and the motor is turning over slowly, the gas in the cylinders is being exploded when the pistons reach the end of their compression stroke. When the gas is fully compacted the explosion or power obtained from combustion is more powerful than if the spark fired gas which was not compressed properly. The electric spark is not produced at the exact time that the motor should be fired at all speeds, and if the spark was supplied the very instant of full compression irrespective of the speed of rotation, there would be no need of moving the spark lever.

Not only is the current apt to lag, but it takes a certain definite amount of time to set fire to the gas. It requires the same amount of time to ignite the gas, of given composition, regardless of the speed of the motor. If the motor is only turning at a few hundred revolutions per minute there is ample time to ignite all gas charges positively, but if the motor speed increases and the explosions occur oftener, then one must compensate for the more rapidly occurring combustion periods by arranging to start igniting the gas earlier so the explosion will occur when the piston is at its highest point in the cylinder. The

compensation for lag is made by advancing the spark. The spark lever on the steering wheel or column moves a commutator, if battery system is employed, or the magneto-contact-breaker box, if that form of current producer furnishes the ignition energy. The amount of spark advance needed depends on engine speed and the greater the piston velocity the more the spark should be advanced.

It is possible to advance the spark lever too far, and when this occurs the gas is exploded before the piston reaches the top of its stroke and premature explosion takes place. As a result of this the upwardly moving piston is forced to overcome the resistance exerted by the expanding gas of the ignited charge in completing the remainder of the compression stroke, and before it will return on the power stroke. The injurious back pressure on the piston reduces the capacity of the motor and a pounding noise similar to that produced by loose motor parts gives positive indication of premature ignition due to excessive spark advance.

At the other hand, if the spark lever is not set as far forward as it should be, the explosion may be late because of the "retarded spark." If the spark occurs late in the cycle, the charge is not fired until the piston has reached its highest point and after it has completed a small portion of its downward movement. As the point of maximum compression is passed and the piston moves down in the cylinder, the size of the combustion chamber augments and the gas begins to expand again before it ignites. Owing to the moderate compression the power resulting from explosions is less than would be the case with a higher degree of compression. To secure power it is necessary to supply more gas to the cylinders. Driving with a retarded spark produces heating of the motor and is wasteful of fuel.

For ordinary running the spark lever is usually placed about midway of its travel on the sector, and as a general rule an engine with magneto ignition does not require the frequent manipulation of the spark necessary when current is produced by chemical means. As the engine speed increases the current produced by the magneto is proportionately augmented, and the spark lever need not be advanced from the center position except under conditions which permit of exceedingly high engine speeds.

The diagram presented at Fig. 712 is furnished by the Cadillac Motor Car Company to owners of its four-cylinder cars, and shows the position of the spark and throttle levers to obtain various engine speeds when the car is on the direct drive. At five miles per hour the throttle is practically closed and the spark lever has been advanced about a quarter of the way down the segment. To obtain a speed of eight

miles per hour the spark lever is moved to the point on the steering-wheel sector indicated by the letter C. The throttle lever is not dis-

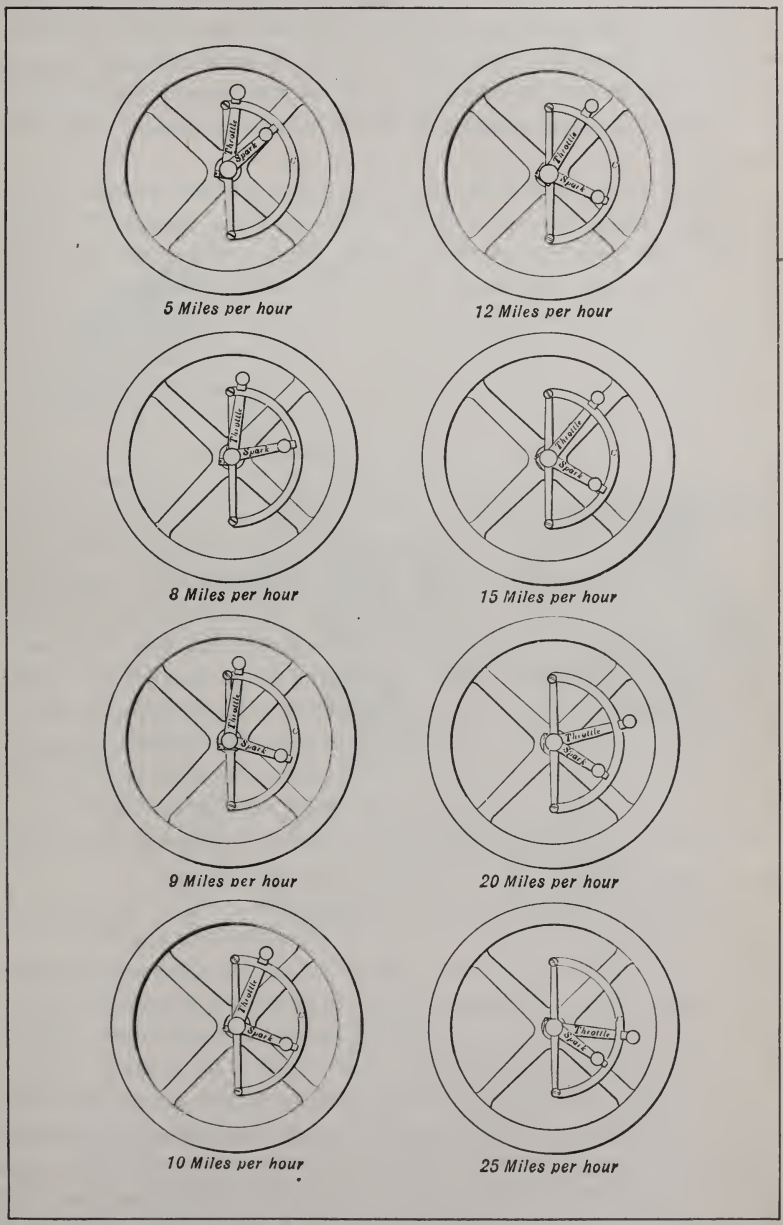


Fig. 712.—Position of Spark and Throttle Control Levers on Cadillac Four-Cylinder Cars to Obtain Various Car Speeds with Gearing in Direct Drive.

turbed. Moving the spark lever about two-thirds of the way on the sector will increase the speed of the car to nine miles per hour. From this point speed ratios are augmented by moving the throttle lever and the car speed increases progressively as the amount of gas supplied the engine is augmented. For higher speeds than twenty-five miles per hour the spark and throttle levers are moved toward the end of the sector and it is usual practice to advance both in conjunction beyond this point.

Summing up, it will be patent that the greatest economy of fuel will result when the car is driven with as little throttle opening as possible, and with the greatest spark advance the motor speed will allow. To obtain maximum power, as in hill climbing on the direct drive, the spark lever should never be advanced beyond center and the throttle should be opened as wide as possible. For extreme high speeds, the throttle should be advanced to a point about midway of its travel before the spark lever is advanced beyond that point. If this does not give the required increase in speed, the spark lever should be advanced as far as possible and the amount of gas increased, by moving the throttle lever from its central position to the extreme position on the sector. Control-lever placing varies on nearly all cars, but the most common position is on top of the steering column, where they are convenient to operate and very accessible. In some cars the spark and throttle levers may be placed under the steering wheel and on one side of the steering post, one being located above the other. In other vehicles they are disposed under the wheel and on opposite sides of the steering post. Some designers do not furnish variable spark when a magneto is provided. The magneto contact breaker is advanced to the point where the best operation under average conditions is attained, and motor-speed regulation is entirely by using the throttle lever or accelerator.

Controlling Cars with Friction Transmission.—After the engine has been started the next point is to put the automobile in motion. The means for obtaining the various speed ratios will determine the steps that should follow. When a friction or planetary transmission is installed the control is very simple and usually a single lever suffices to furnish all desired speed ratios. The Carter Car control system is shown at Fig. 713 and is a good example of the simple method of control possible when friction-disk change-speed gearing is utilized. One hand lever at the side of the car serves to move the driven member to its various positions on the face of the driving member. The inner foot pedal is employed to bring the friction disks together and establish driving contact between them when the proper speed position

has been selected with the hand lever. The other pedal is used to apply a running brake at the rear wheels. Motor speed is regulated by spark and throttle levers on the steering wheel.

With this form of control the friction pedal is released before the engine is started and as this breaks the driving connection between the friction disks, the engine can be turned without moving the vehicle.

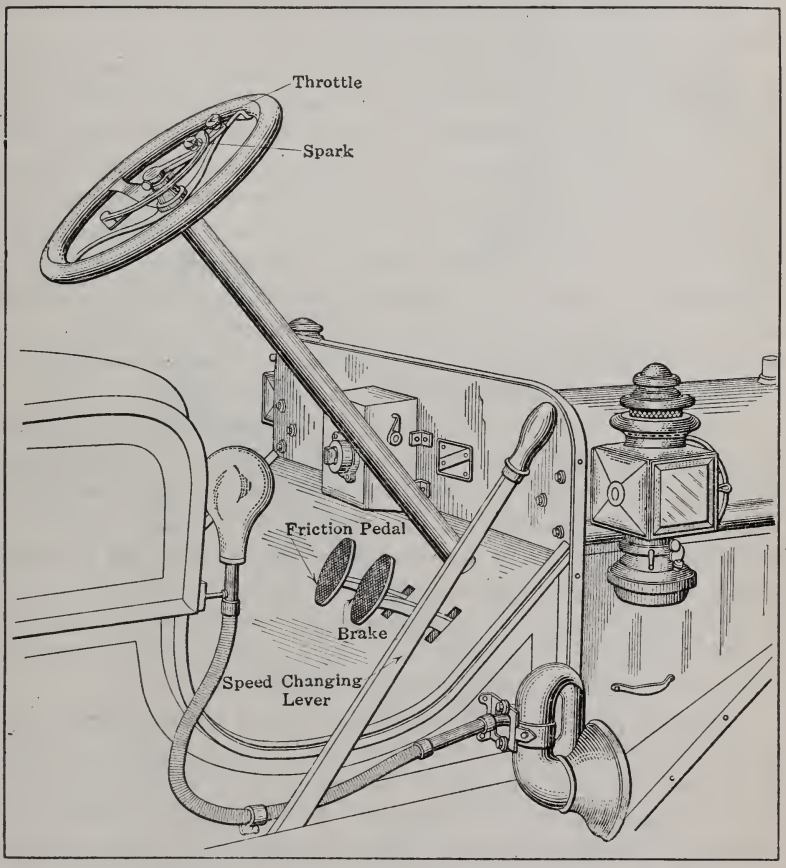


Fig. 713.—Control System of Carter Car, an Early Type which Utilized Friction Transmission.

After the motor is started in the manner previously indicated, the speed-changing lever is placed at a position about midway in its travel or so it will line up with the bulb of the horn shown in illustration. This gives one of the lowest speed ratios. To start the car the friction pedal is pressed with the left foot until sufficient pressure exists to cause the driving member to turn the driven wheels and transmit the

engine power to the rear wheels. After a certain degree of headway has been attained, the friction pedal is allowed to return to its free position and the hand lever is pushed forward a few inches to give a slightly higher speed. The friction pedal is again depressed and when sufficient pressure is exerted the car will move forward at a higher speed. The farther forward the handle is placed, the higher the vehicle speeds, and if the handle is brought back beyond a central position a reverse motion is obtained.

The friction pedal may be locked at any desired point by tilting the foot pad up by raising the heel. When it is desired to stop the car the friction pedal is released by bearing down on the lower portion of the foot pad, which loosens the ratchet lock, and by pushing on the brake pedal. It is important that the friction pedal be applied gradually and that it is not pressed down any farther than is necessary to drive the car. The amount of pressure will depend on the road conditions, and the lighter the degree of pressure the less wear will take place on the friction-wheel fiber ring. When on a hill, or in sand, the friction pedal will have to be pushed up harder than when the car is driven on a level highway with a good surface.

Before the hand lever is changed from one position to another the friction pedals should always be released. An emergency braking effect may be obtained by pushing the hand lever in reverse position and applying the friction pedal if the car is going forward, or vice versa, if the car is traveling in a reverse direction. One of the advantages of the friction transmission is that it is difficult to injure it by careless handling because there are no gears to be stripped if these are not meshed properly. The transmission is practically noiseless and speed changes are effected easily and noiselessly.

Planetary Gears Easily Controlled.—One of the advantages of the planetary gearset, when applied in the two-speed forward and reverse forms, is that the method of obtaining the various speed ratios is very simple and easily understood. At Fig. 714 the control system of some of the lighter Maxwell cars is shown and the various positions of the lever to obtain the different speeds are clearly indicated. On these cars, the speed of rotation of the double-cylinder motor is regulated by a small pedal connected to the throttle of the carburetor and a spark lever at the top of the steering column, under the steering wheel. The speed changes are obtained by a single hand lever and the hub brakes are applied by the usual form of pedal.

Five positions of the handle give two neutral points, one reverse motion, and two forward speeds. Ordinarily the lever is in an approximately vertical position and is at the neutral point between the

reverse and slow speed. When pulled back from this position a reverse motion is obtained. If pushed forward the slow-speed gears are put into action. Moving the hand lever from the slow-speed position forward gives the second neutral point, while the high speed or direct

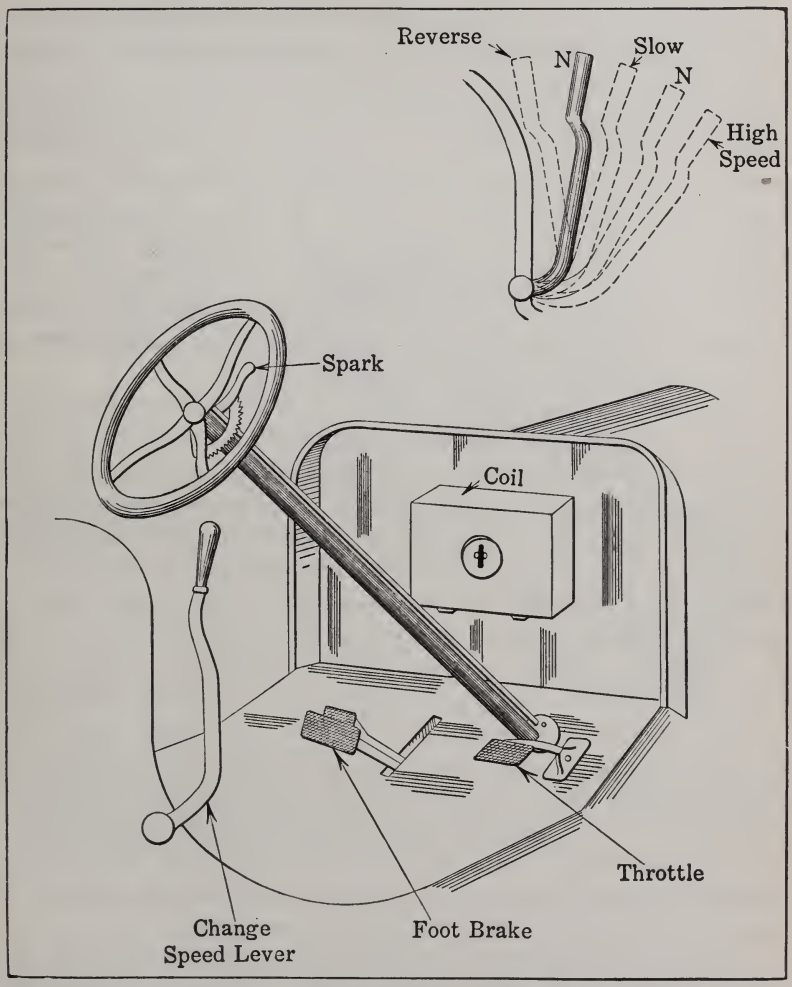


Fig. 714.—Simple Speed Regulation Methods on Early Maxwell Cars Furnished with Planetary Gearsets.

drive is obtained by pushing the lever to the extreme forward position. The lever must be held in the reverse position but can be locked into low and high speeds.

When running the car under conditions where it is not necessary

to go into the reverse the lever may be pulled from the high-speed position to the neutral point between high and slow speeds. If the car is stopped it can be easily started forward again by pulling the handle back into slow speed from neutral position and then forward to engage the direct drive. If the handle is pulled way back out of high speed into neutral position between slow and reverse, either of these ratios may be easily obtained. A point necessary to consider when operating a planetary transmission is that the slow and reverse speed must be applied gradually and that the engine be speeded up pretty well before either reverse or slow-speed bands are tightened. After the car has attained a certain degree of momentum on the low speed the lever should be put forward into the high-speed position gradually in order to avoid the sudden jump which always obtains when changing from the low to the high speed of a two-speed car. This jump is caused by a sudden acceleration due to the higher gearing, provided by the direct-drive position which is much higher than the maximum speed permitted by the slow-speed gears.

The Ford car is one of the most popular of moderate-priced automobiles and over 1,000,000 of the Model T are now on the road. The control system of this car is extremely simple and yet it is different from that of any other automobile. The gearset, which has been previously described, is a planetary type which gives two forward speeds and a reverse motion. The conventional form of steering wheel is used to control the direction of car travel, and spark and throttle levers are mounted on the steering column beneath the wheel to control the speed of the power plant. It is in the method of obtaining the various speed ratios that the control system is distinctive. As will be seen by referring to Fig. 715, three pedals and a hand lever are provided on the left side of the car. The pedal on the extreme left is used to control the high- and low-speed clutches and is marked " C." That next to it, which is marked " R," is used to constrict the reverse band of the transmission and obtain reverse motion. The pedal at the right, which is provided with a letter " B " cast on its surface, is used to apply the foot brake.

The hand lever engages the high-speed or direct-drive clutch when thrown forward and when pulled back it actuates the emergency brake. An interlocking connection is provided so the emergency brake cannot be applied without releasing the direct-drive clutch. The lever may be set in a neutral position and the clutch will be released without applying the brake when it is approximately vertical. When the high speed is in and the hand lever is thrown way forward the high-speed clutch may be released by a light pressure on pedal

"C" and a further movement of this pedal will apply the low speed. Thus one pedal gives control of both high and low speeds forward and the clutch can be released in exactly the same manner as that of a sliding-gear car when it is desired to slow up, such as for turning a corner, descending a hill or passing another vehicle.

Before starting the car the hand lever must be in a vertical position, this releasing the clutch and applying the emergency brakes.

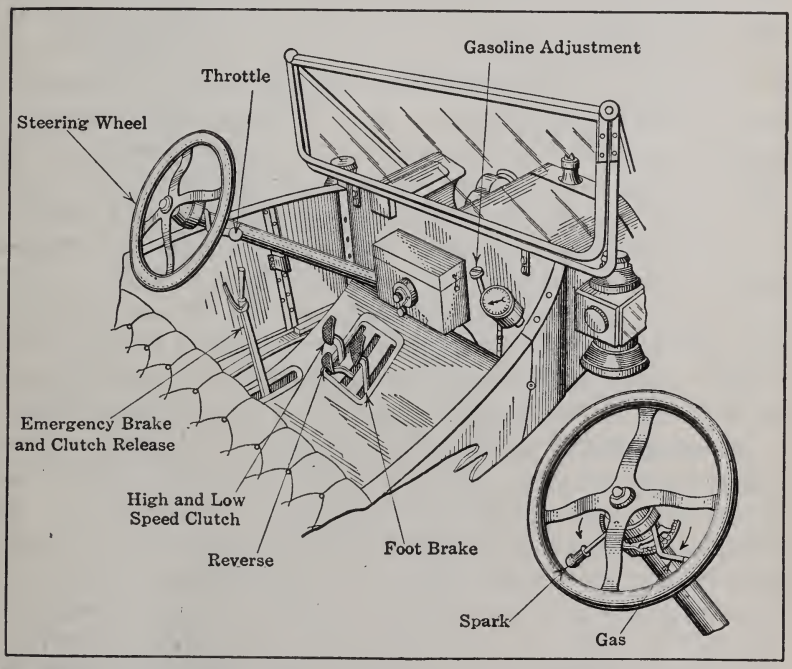


Fig. 715.—Outlining Distinctive Control System of the Ford Model T Automobile, which Employs Two-Speed and Reverse Planetary Gearing. Location of Spark and Throttle Levers Clearly Shown in Inset.

To start the car, after the engine has been started in the usual manner, the foot is placed on the clutch pedal to keep it in a neutral position, while the hand lever is thrown as far forward as it will go. The engine is then accelerated and the clutch pedal is pushed forward until the slow-speed band tightens around the drum of the transmission and the car gathers headway on the lower ratio. After it has attained a certain momentum, the clutch pedal is allowed to

Note.—For full information on Ford automobiles, see "The Ford Model T Car," by Pagé. Price, $1.00. The Norman W. Henley Pub. Co., 2 West 45th Street, New York City.

drop back gradually into the high-speed position. The foot may then be removed until such times that the clutch must be disconnected. Before applying the foot brake, which is done by pressing with the right foot upon the pedal marked "B," the clutch pedal should be put in neutral position with the left foot.

To reverse the car, it must first be brought to a standstill. The engine is kept running and the clutch is disengaged with the hand lever, which is placed in the neutral position but not pulled far enough back to apply the emergency brake. The reverse pedal marked "R" is then pushed forward with the left foot, leaving the right one free to use on the brake pedal if needed. To stop the car, the throttle is closed so that the engine will not race; the high speed is released by pressing the clutch pedal forward into its neutral position and applying the foot brake slowly, but firmly, until the forward motion of the car is arrested. It is imperative that the foot be retained on the clutch pedal until the hand lever is pulled back to its neutral position. The placing of the spark and throttle levers is clearly shown in the inset in the right-hand corner of the cut, both levers being pulled back to accelerate the motor and pushed forward to slow it down. The same rules previously given for the manipulation of the spark and throttle levers apply just as well to this make of car.

Operating Sliding Gearsets.—Two sliding gear systems are fitted to motor cars, but at the present time the progressive system of control has been almost entirely superseded by the selective system. The principles of operation are practically the same as relate to clutch operation and gear engagement, but in the progressive system it is necessary to move the gear-shift lever from one end of a segment to the other to obtain the range of speed. In the selective system a gate segment is utilized and the hand lever is moved only short distances to select the speed required.

The control system of a typical selective sliding-gear car is shown at Fig. 716 and 716A. Engine-speed regulation in the former is by spark and throttle levers at the left side of the steering wheel operated in the usual manner. Two pedals are provided and two hand levers. The pedal that is to be worked by the left foot is used to release the clutch, while that which is applied by the right foot actuates the running brake. The outer hand lever works on a notched segment and is pulled toward the operator to apply the emergency brakes. The inner lever works in a gated segment and is employed to obtain the varying speed ratios.

How Selective Gearsets are Operated.—The arrangement of guiding gates which are used with selective systems of gearset control

are shown at Fig. 717. In all of these the neutral point is usually at the center of the bars dividing the segment into slots and the lever can be easily moved in either direction to engage the speed desired.

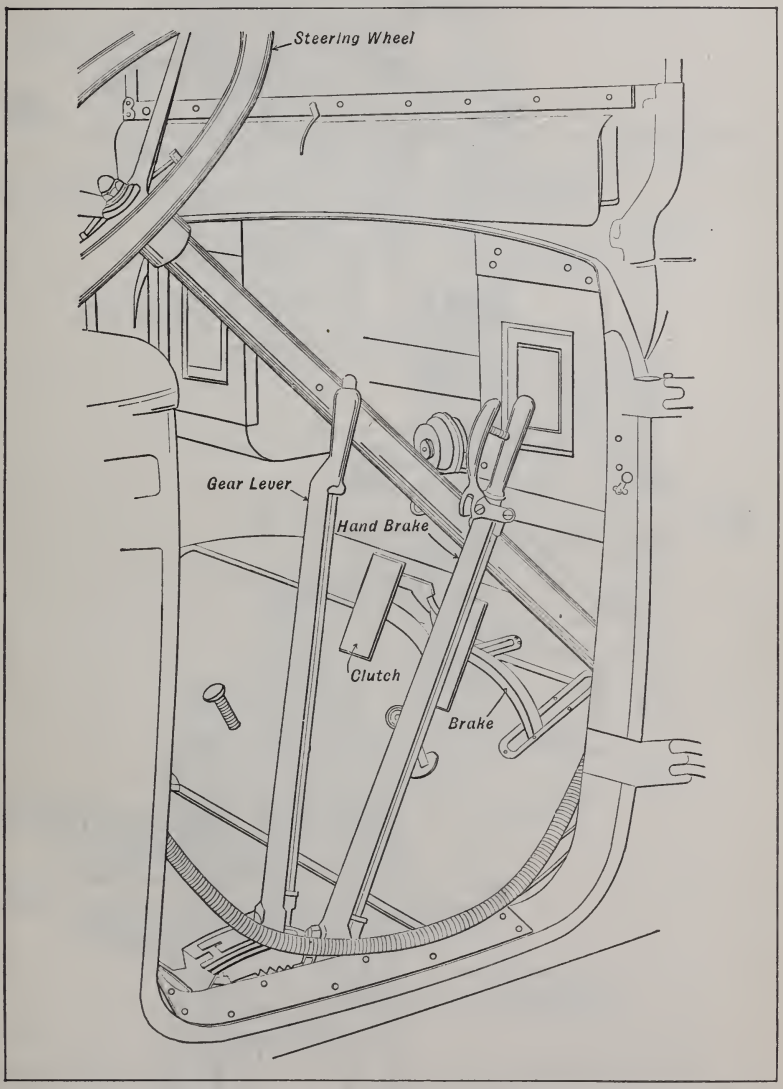


Fig. 716.—Side Control Levers and Pedals of Pierce-Arrow Sliding-Gear Cars.

On the Peerless cars, which are provided with a four-forward speed and reverse gearset, there are three positions or slots for the speed-changing lever at the front end of the segment and two at the rear.

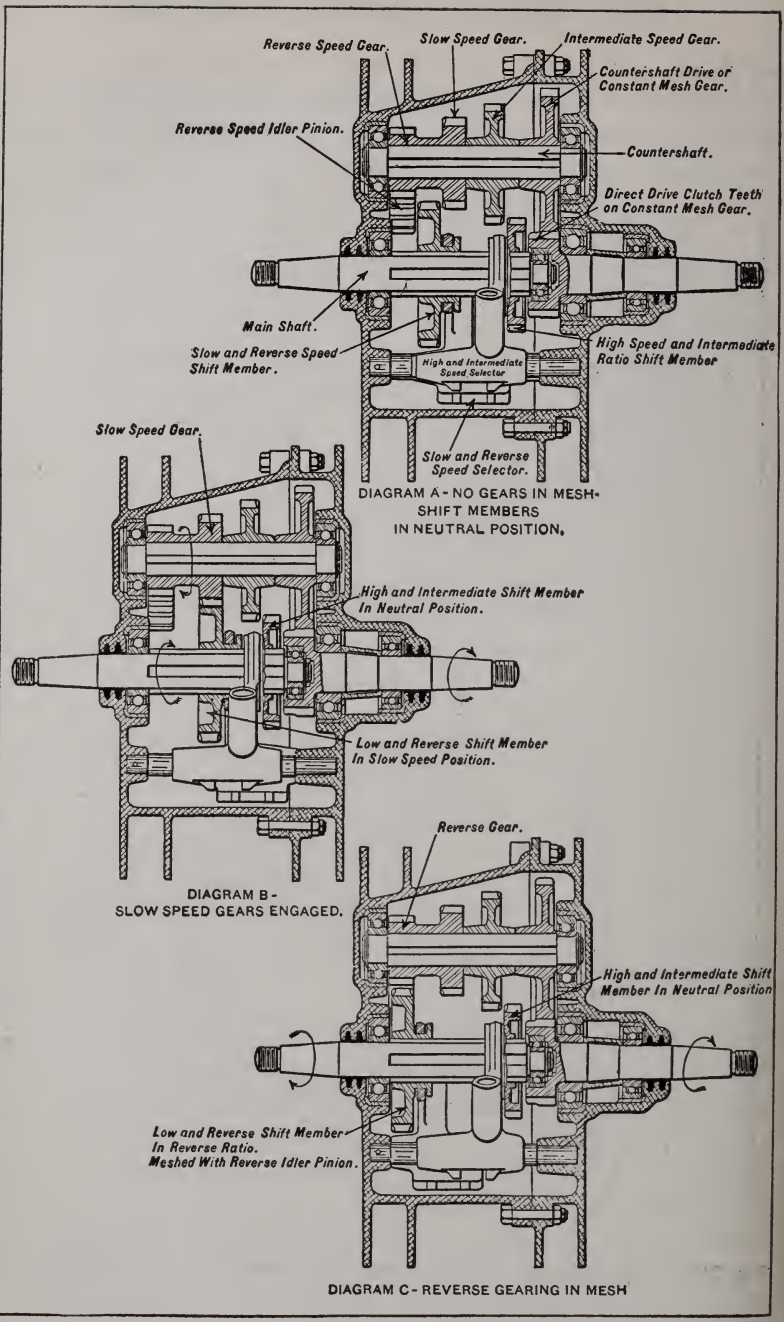

Reverse Speed Gear.
Slow Speed Gear.
Intermediate Speed Gear.
Countershaft Drive or Constant Mesh Gear.
Reverse Speed Idler Pinion.
Countershaft.
Direct Drive Clutch Teeth on Constant Mesh Gear.
Main Shaft.
Slow and Reverse Speed Shift Member.
High and Intermediate Speed Selector
High Speed and Intermediate Ratio Shift Member
Slow and Reverse Speed Selector.
DIAGRAM A - NO GEARS IN MESH- SHIFT MEMBERS IN NEUTRAL POSITION.
Slow Speed Gear.
High and Intermediate Shift Member In Neutral Position.
Low and Reverse Shift Member In Slow Speed Position.
DIAGRAM B - SLOW SPEED GEARS ENGAGED.
Reverse Gear.
High and Intermediate Shift Member In Neutral Position
Low and Reverse Shift Member In Reverse Ratio. Meshed With Reverse Idler Pinion.
DIAGRAM C - REVERSE GEARING IN MESH

Chart Showing Action of

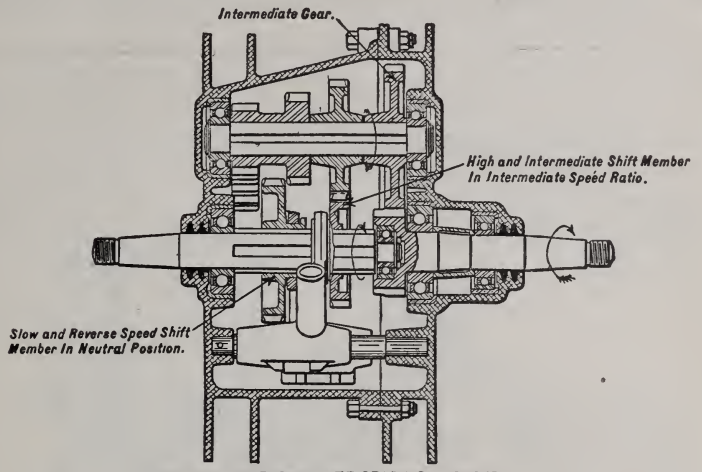

Intermediate Gear.
High and Intermediate Shift Member In Intermediate Speed Ratio.
Slow and Reverse Speed Shift Member In Neutral Position.

DIAGRAM D - INTERMEDIATE GEARING ENGAGED.

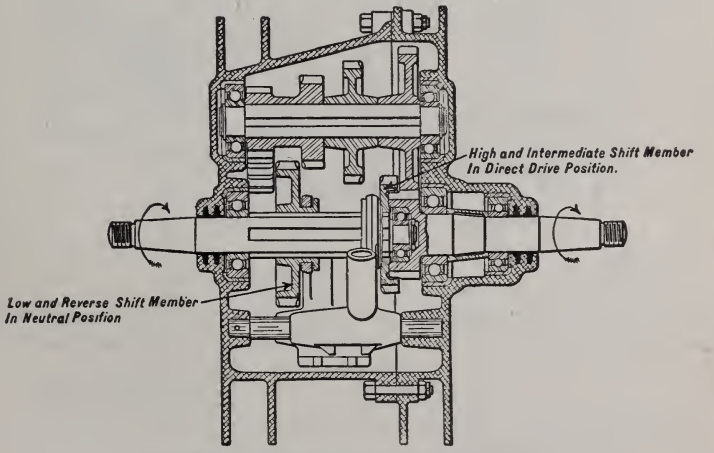


DIAGRAM E - DIRECT DRIVE CLUTCH IN POSITION.

Selective Sliding Gearset.

To engage the reverse gear the lever would be placed in the slot indicated by the letter "R." To give the lowest forward speed the lever would be pulled out of the reverse slot and pushed forward into

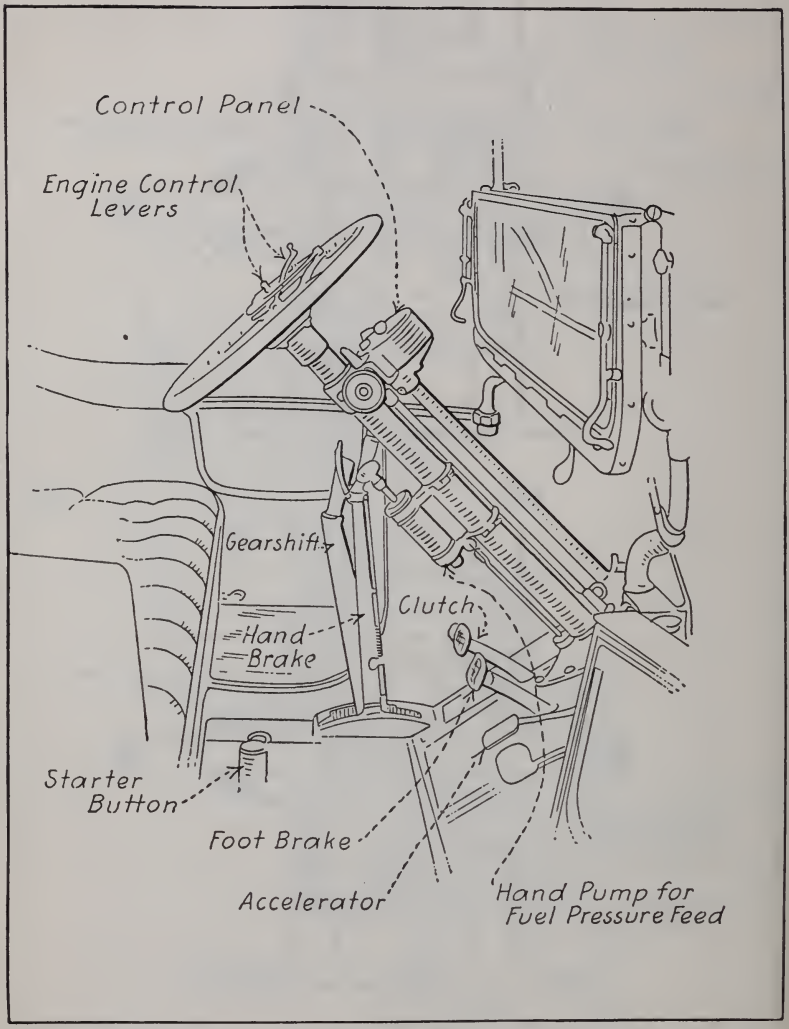


Fig. 716A.—Control System of 1917 Model Packard Twin-Six Automobile.

the adjacent one, indicated by number one; pulling the hand lever back out of this slot, into that marked number two will give the second speed. To engage the third speed the shift lever would be pulled out of the center slot and into the outside one and pushed forward until it

filled the slot marked three. For the highest speed, the hand lever would be pulled from slot three to the outside rear slot four.

On the Locomobile cars a four-speed transmission is provided, but the arrangement of the control slot differs somewhat from that used on the early Peerless cars. As shown in the cut, the lever is in neutral position and can be moved sideways into either the inner or outer slot. To obtain the reverse speed the handle is pushed as far forward in the outer slot as it will go. Pulled back from this position but keeping it still in the outer slot will give the first speed. Pulling the lever back from point indicated by one to slot two will engage the

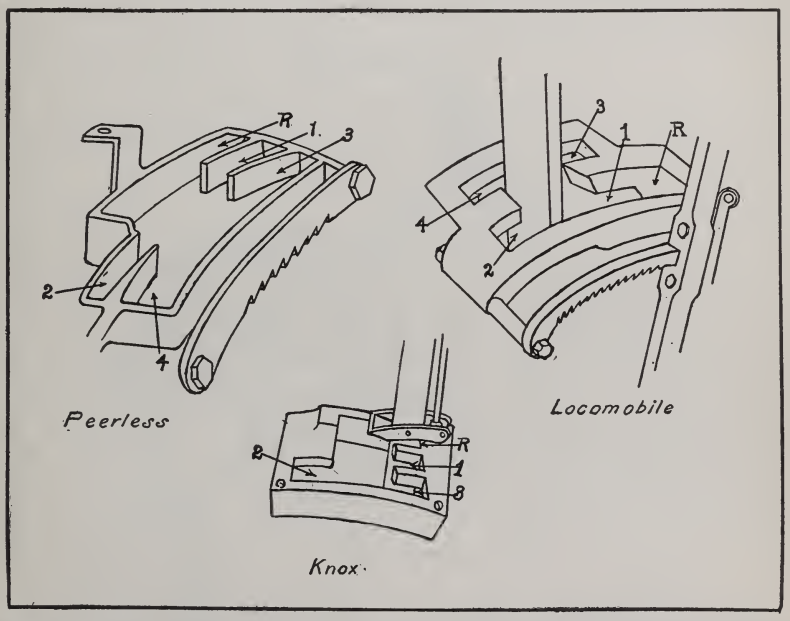


Fig. 717.—Change-Speed Gates for Three- and Four-Speed Selective Transmissions.

second speed. The higher ratios are obtained in the inner slot. A forward movement of the lever engaging the third speed, while a pull back will engage the highest ratio.

On Knox cars, where three forward speeds are provided, the guiding gate is arranged in such a manner that the reverse, first, and third speeds are obtained by pushing the lever into one of three slots at the front end of the gate, while the second-speed gears are meshed by pulling the hand lever back into the one rear slot.

In operating a car with the selective method of control it is necessary that the gear-shift lever be in a neutral point if the clutch is

engaged before starting the engine. After the motor has been started and is running at the proper speed, and it is desired to start the car, the first step is to release the emergency-brake lever and depress the clutch pedal so that the driving connection between the engine and gearset is interrupted. With the clutch pedal depressed fully the hand lever is pushed into the slot which will give the slowest speed; then the clutch is allowed to engage slowly and the start forward is made on the lowest speed. After a certain degree of momentum has

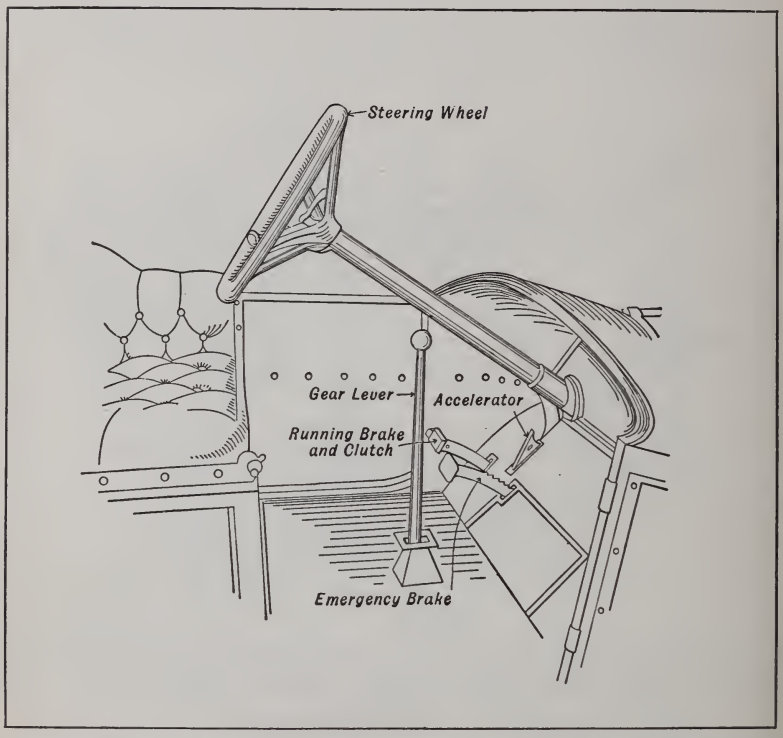


Fig. 718.—Reo Control System, with Single Centrally Located Gearshift Member and Steering Wheel on Left Side.

been attained the clutch pedal is again depressed and the speed lever shifted into the next higher speed ratio. The velocity of the car is thus gradually increased by moving the lever in steps from the lowest to the highest ratio. With any form of sliding-gear transmission it is imperative that the clutch be released every time a change of speed is to be made and the clutch should not be engaged again until the gearing is positively in mesh.

When one desires to stop the car the first step is to release the clutch by pushing forward on the clutch pedal with the left foot and apply the foot brakes with the right foot. The gear-shift lever is brought into a neutral point and then the clutch may be engaged again, if desired. On many cars the emergency-brake lever and clutch-shifting mechanism are interlocked in such a manner that the clutch is released automatically when the hand-brake lever is applied. The emergency brakes of the average car are seldom used in normal operation, the main reliance of most drivers being foot-operated service brakes. When it is desired to lock the car the emergency-brake lever is pulled back until the brakes are engaged and is retained in that position by a locking ratchet that engages suitable teeth cut into the brake-lever segment.

There is some difference of opinion regarding the placing of the steering wheel and whether it should be on the right or left side of the car. Most American motor cars, which originally were copies of foreign productions, placed the wheel and control levers at the right side of the car, because they were disposed in this manner on the European cars from which the first American vehicles were copied. The road rules in Europe are different than in this country in that a driver has to pass a vehicle going in the same direction on the right and must keep to the left of the road. This made the right hand placing of the wheel logical and desirable. In this country, however, the rules of the road are that all vehicles must keep to the right and when one passes another conveyance going in the same direction it should be passed on its left side. This makes the right-hand control, which is logical and desirable in Europe, unsuitable for road laws of this country.

To be logical the steering wheel of American cars should be placed at the left side instead of the right. A large number of designers follow this rule, but in order to conform as much as possible with American practice the gear-shift lever is placed in the center of the car where it can be operated by the right hand instead of at the left side. A typical left-hand control system is shown at Fig. 718. In this a single-hand lever is mounted in the center of the floor board and is moved in four directions. It may be rocked to the right or left and pulled back or pushed forward in either of these positions. When the lever is straight up and down it is at the neutral point, the three forward speeds and reverse motion are obtained by rocking the lever from side to side and pushing it forward or backward as conditions demand. Two pedals are provided. That at the extreme left serves to release the clutch and apply the service brake, while the one oper-

ated by the right foot actuates the emergency brakes. When a single pedal is used for service-brake application and clutch release, it is depressed about half its travel to disengage the clutch and applies the running brake from that point to the end of its radius of movement.

Many designers who favor the right hand placing of the steering post locate the gear shift and emergency-brake levers in the center of

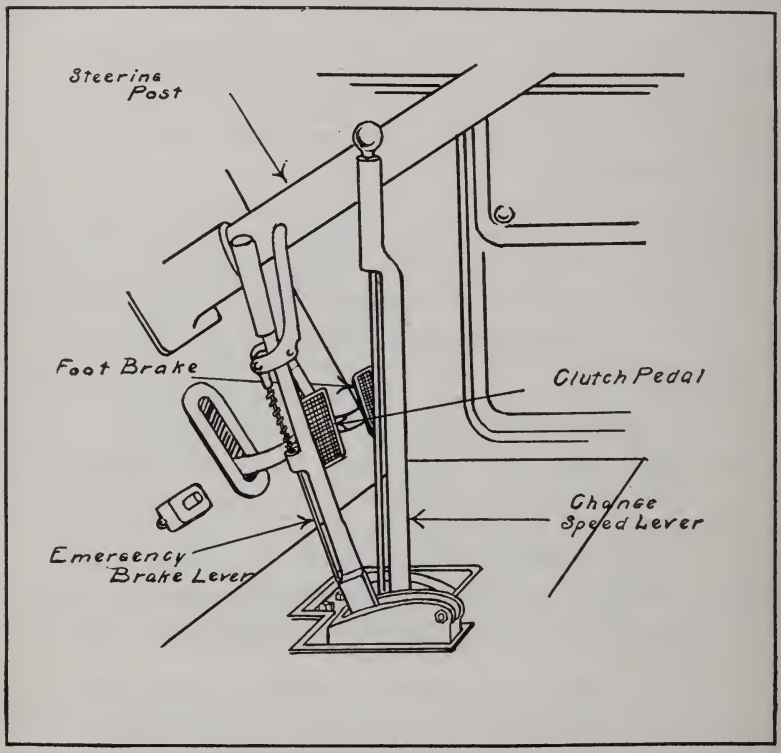


Fig. 719.—Typical Change-Speed Lever and Foot Pedal Arrangement When Centrally Located Control Levers are Used.

the floor in order that the torpedo body, with which the cars are fitted, may present an unbroken and smooth appearance without any projecting part or levers when viewed from either side. The placing of the change-speed and emergency-brake levers on the latest Knox cars is shown at Fig. 719. The complete control system of Mitchell cars is shown at Fig. 720. The placing of the hand levers on the Jackson car and the functions of the foot pedals are clearly depicted at Fig. 721.

The instructions given for operating one type of car with selective sliding-gear transmission applies just as well to all other forms, which are controlled in practically the same manner and which differ only in the arrangement of the slots in the guiding gate and the location

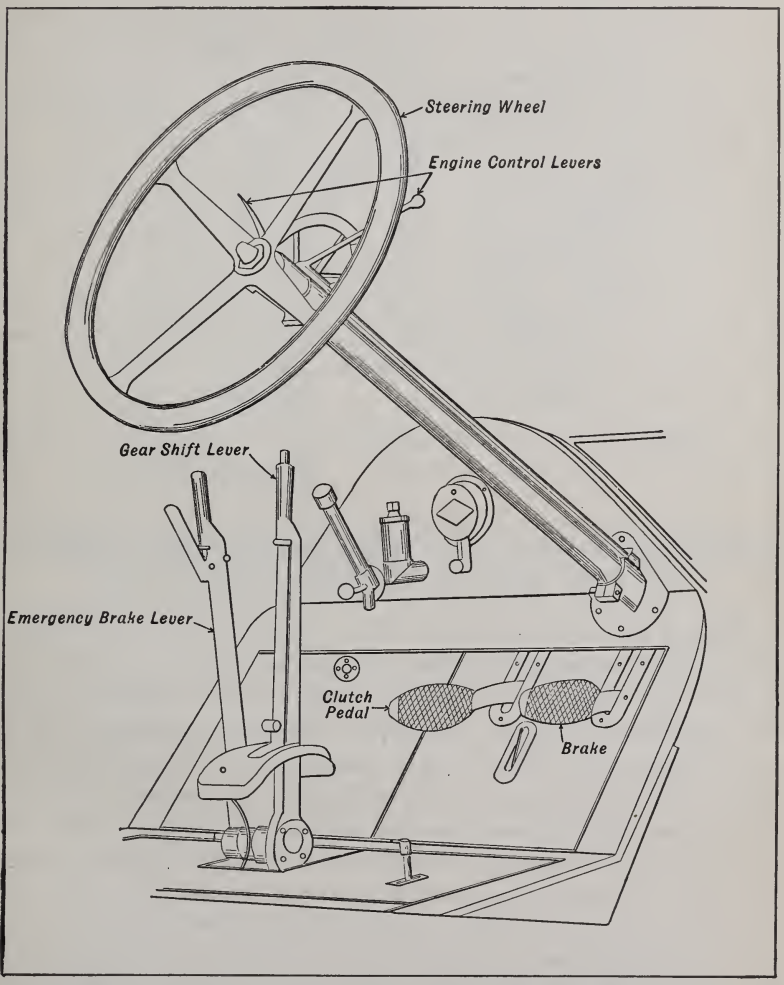


Fig. 720.—Complete Control Group of Early Mitchell Motor Car.

and direction of movement of the spark and throttle levers. Practically the same units are used in all control systems of sliding-gear cars, i. e., two pedals and two hand levers are usually provided. One of the pedals invariably releases the clutch while the other applies the

service brake. One hand lever, always the one nearest the operator, is used to shift the gears, while the one that works on a notched segment is depended upon to apply the emergency brakes.

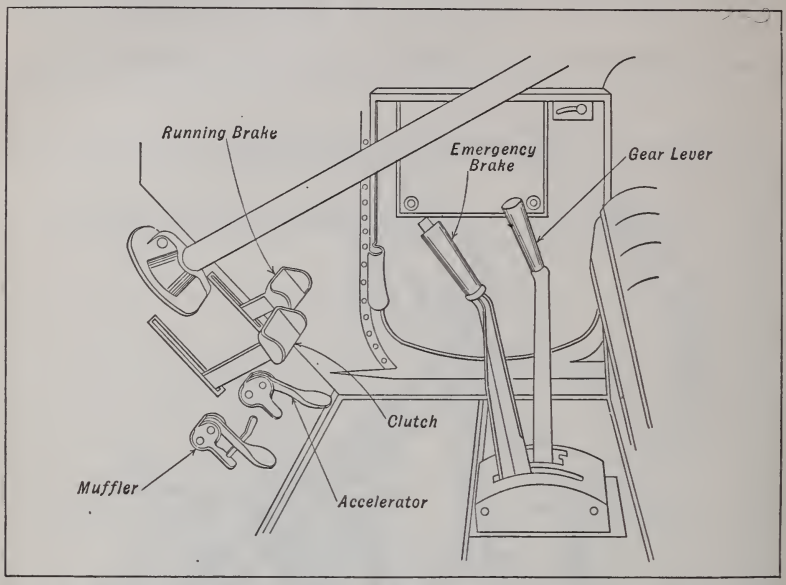


Fig. 721.—Center Control Levers of Jackson Cars and Pedals for Clutch, Running Brake, Accelerator, and Muffler Cut-out Operation.

General Driving Instructions.—The following instructions apply to all types of gasoline automobiles and may be followed to advantage by all motorists. The gear-shift lever should always be placed in a neutral position when the car is stopped, whether it is left alone or attended. Gear-shift levers should always move easily and the clutch pedal of all cars equipped with sliding-gear transmission should be fully depressed before attempt is made to shift speeds. The clutch should always be applied gradually and as slowly as possible because too sudden or harsh engagement will produce stresses that will injure the tires or mechanism of the chassis. Never allow the engine to race or run excessively fast when shifting gears, and it is well not to undertake to change speeds with either motor or car running at high speed. When changing down, i. e., from a higher to a lower gear, allow the car to slow down until its speed is about the same as that which will be produced by the lower gear ratio desired before the clutch is again engaged after the gear lever has been shifted.

If difficulty is experienced in meshing the gears do not try and force them in mesh but hold the clutch pedal out for a few minutes,

let the car come to almost a stop, apply the clutch quickly, and release it at once and the chances are that the troublesome shift member will have turned to a position where it will engage more easily. Sometimes one or more of the gear teeth on the shift member or the gear with which it engages may be burred up on the edges and will not engage promptly, whereas other portions of the same members will have undamaged teeth that will easily slip into engagement.

Always drive a car slowly and cautiously until you are thoroughly familiar with the control mechanism and the methods of stopping the car. When driving up grades on the higher ratios, if the motor shows any tendency to labor, shift back into a lower gear ratio which has been provided for that purpose. Many motorists believe that the best test of a car's ability is to rush all hills, or bad spots in roads, on the direct drive. It should be remembered that the lower speed ratios were provided for use at all times when employing the third or fourth speeds might produce strains in the motor. All unusual noises should be investigated at once, as these sounds usually presage more or less serious trouble. A gasoline car should never be driven with a slipping clutch, and it is imperative that the brakes and steering gear be frequently inspected to make sure that they are in proper order.

One should never attempt to drive cars at high speeds unless the tire casings are in perfect condition and the road surfaces good. In driving on clay or muddy roads, or on wet asphalt, care must be taken in turning corners and the car should be driven cautiously to avoid dangerous side slipping or skidding. When driving on unfavorable highway surfaces always keep one side of the car on firm ground, if possible. Brakes should always be carefully applied, especially if the road surfaces are wet. An automobile should never be brought to a stop in mud, clay or sand, snow or slush, if it can be avoided. Whenever road conditions are unfavorable the smooth tread tires of the driving wheels should always be fitted with chain-tire grips to insure having adequate traction.

All motorists should familiarize themselves as much as possible with the mechanism of their cars and should be competent to make the ordinary adjustments and minor repairs before any long trips are attempted. A full equipment of tools and spare tires and casings should be carried at all times. It is well to remember that the manufacturer of the car has issued a set of instructions for its care and maintenance, and these should be followed as closely as possible because intelligent care of any piece of machinery means long life and reliable service and the automobile is no exception to the rule.

Convertible Six- or Twelve-Cylinder Engine.—Considerable difference of opinion exists relative to the best type of pleasure car power plant. Some motorists favor the six-cylinder type, others want an engine of twice that number of cylinders. In order to meet these two radically different requirements an American automobile maker has provided his twelve-cylinder engine with a simple attachment by which one of the cylinder groups may be put out of action as long as desired and the car driven by six cylinders. This end is attained by comparatively simple mechanism. An auxiliary camshaft is carried on the top of one of the cylinder blocks, as shown at Fig. 722,

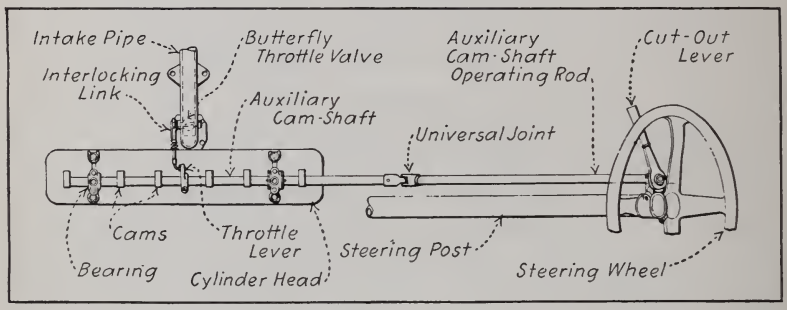


Fig. 722.—Simple Arrangement to Permit Using Either Six or Twelve Cylinders of a Twin-Six Power Plant.

this being operated by a cut-out lever placed beneath the steering wheel and readily accessible to the operator. When the auxiliary camshaft is rocked all the exhaust valves of one block of cylinders are opened to relieve the compression and are kept open as long as it is desired to keep that group of cylinders inactive. An interlocking link closes a butterfly throttle valve in the induction pipe so that gas from the carburetor is drawn only into the operative cylinder block. Locking the auxiliary camshaft in a reverse direction will allow the valves to function normally and open the throttle valve so that the carburetor will supply gas to both sets of cylinders. A simple movement of a lever, therefore, gives the motorist a six-cylinder engine for economical operation when but little power is needed, as on good roads, and the full power of twelve cylinders when operating conditions demand it.

Winter Care of Automobiles.—While motoring throughout the entire year is not unusual, many owners of cars, especially in those portions of the country where the winter climate is exceptionally severe, put up their car for a period. If the car is to be kept in service the most important thing to do is to provide some good antifreezing compound

in order to prevent the water in the radiator and cylinders from congealing. There is some difference of opinion regarding the best solution to use to prevent cracked water jackets and burst radiators. Before we attempt to answer the questions often asked regarding the best antifreezing compound, it will be well to consider the requirements of such compounds. To begin with it should have no deleterious effects on the metals or rubber used in the circulating system. It must be easily dissolved or combined with water, should be reasonably cheap, and not subject to waste by evaporation or be of such character that it will deposit foreign matter in the pipes. The boiling point should be higher than that of water to prevent boiling away of the solution at comparatively low temperature.

Solutions of calcium chloride seem to be very popular with motorists, and the writer will first discuss the use of this substance. The freezing point of the solution depends upon the proportions of the salt to the water. An important factor to be considered is that if the parts of the circulation system are composed of different metals there is liable to be a certain electrolytic action between the salt and the dissimilar metals at the points of juncture, a certain corrosion taking place, and the intensity of this corrosive effect is only dependent upon the strength of the solution. As calcium chloride is derived from hydrochloric acid, which has very strong effect on metals, and as there may be particles of free acid in the solution, a certain undesirable corrosive action may take place.

In using calcium chloride when compounding an antifreezing solution care must be taken that commercially pure salt is employed as the cruder grades will liberate a larger percentage of free acid. The mistake should not be made of using chloride of lime, which has much the same appearance, but whose corrosive action is very great. Galvanized iron tanks and cast aluminum water manifolds and pump casings prohibit the use of this salt as its destructive action is great on these metals.

It is well to test a solution of calcium chloride for acid before placing in the radiator. A piece of blue litmus paper may be obtained at any drug store and immersed in the solution. If the paper turns red it is a sign that there is acid present. Acid may be neutralized by the addition of a small quantity of slacked lime.

The solutions may be made in these proportions:

Two pounds of salt to the gallon of water will freeze at eighteen degrees Fahrenheit.

Three pounds of salt to the gallon of water will freeze at one and five-tenths degrees Fahrenheit.

Four pounds of salt to the gallon will freeze at seventeen degrees Fahrenheit below zero.

Five pounds of salt to the gallon will freeze at thirty-nine degrees Fahrenheit below zero.

It must be remembered that the more salt to the solution, the greater the electrolytic effect and the greater the liability of the deposit of salt crystals, which may obstruct the free flow of the liquid.

Glycerin is usually considered quite favorably, but it has disadvantages. It often contains free acid, though the action on metals will be imperceptible in average solutions. While it does not attack metal piping to any extent it is sure destruction to rubber hose and should not be used in a car in which part of the circulation-system piping is of rubber. Glycerin is expensive and it is liable to decompose under the influence of heat and proportions added to the water must be higher than that of some other substances.

Denatured alcohol is without doubt the best substance to use as it does not have any destructive action on the metals or rubber hose, will not form deposits of foreign matter, and has no electrolytic effect. A solution of sixty per cent water and forty per cent alcohol will stand twenty-five degrees below zero without freezing. The chief disadvantage to its use is that it evaporates easily and its boiling point is quite low. Alcohol volatilizes more rapidly than water and the solution is liable to become too light as proportion of alcohol to water is concerned. The percentages required are shown in the following:

Water ninety-five per cent, alcohol five per cent, freeze at twenty-five degrees Fahrenheit; water eighty-five per cent, alcohol fifteen per cent, freeze at eleven degrees Fahrenheit; water eighty per cent, alcohol twenty per cent, freeze at five degrees Fahrenheit; water seventy per cent, alcohol thirty per cent, freeze at nine degrees Fahrenheit below zero; water sixty-five per cent, alcohol thirty-five per cent, freeze at sixteen degrees Fahrenheit below zero.

Various mixtures have been tried of alcohol, glycerin, and water, and good results obtained. The addition of glycerin to a water-alcohol solution reduces liability of evaporation to a large extent, and when glycerin is used in such proportions it is not liable to damage the rubber hose.

The proportions recommended are a solution of half glycerin, half alcohol to water. The glycerin in such a solution will remain practically the same, not being subject to evaporation, and water and alcohol must be supplied if amount of solution in radiator is not enough. The freezing temperatures of such solutions of varying proportions are as follows: Water eighty-five per cent, alcohol and glycer-

in fifteen per cent, freeze at twenty degrees Fahrenheit; water seventy-five per cent, alcohol and glycerin twenty-five per cent, freeze at eight degrees Fahrenheit; water seventy per cent, alcohol and glycerin thirty per cent, freeze at five degrees Fahrenheit below zero; water sixty per cent, alcohol and glycerin forty per cent, freeze at twenty-three degrees Fahrenheit below zero.

The proper proportions to be used must of course be governed by conditions of locality, but it is better to be safe than sorry, and make the solutions strong enough for the extreme that may be expected.

Oils of various kinds are sometimes used exclusively, as it is obvious that oil and water would not form a very good mixture. They are of the character that is often used to lubricate ice-making machinery, and are made especially to withstand low temperatures. The oil will not absorb heat as readily as water, and should only be used where exceptionally good methods of cooling are provided, such as a large radiator, all metal piping and a very positive pump. This oil will attack rubber hose and gaskets, however. It would seem to the writer, from actual experience, that wood-alcohol solutions were preferable to others as combining the greatest number of the requirements of a practical antifreezing compound.

After due care has been taken with the cooling system to prevent freezing, the next point to observe is the lubrication of the motor. This will depend on the oil system used and the grades of oil which are normally employed. As a general rule it is well to use a lighter grade in the winter than that utilized during warmer weather. If the clutch is a multiple-disk member it should be filled with light oil of as high cold test as it is possible to obtain. If sight-feed glasses and exposed tubing forms part of the lubricating system or the oil tank or mechanical lubricator is carried in an exposed position it should be remembered that this part should be inspected frequently to make sure that the oiling system is functioning properly.

If an acetylene-lighting system utilizing a gas generator is fitted it is necessary that the water used in the water tank or the water jacket provided on some generators be drained off and replaced with a solution of denatured alcohol and water of the proper consistency for the degree of temperature liable to be met with. During cold weather a certain amount of difficulty is always experienced in starting the car, especially when one considers the low grade of gasoline used at the present time.

If the motor is provided with compression relief or priming cocks, a small hand oil can should be filled with gasoline and ether mixture of proportions about half and half and kept tightly corked to prevent

evaporation of the volatile liquids. On a cold morning when the motor is hard to start, this liquid may be injected into the cylinders, through the priming cock or by removing the spark plugs if relief cocks are not provided and the motor will be started without difficulty. If no priming can is available one of the methods of securing gasoline shown at Fig. 723 for priming purposes may be used to advantage.

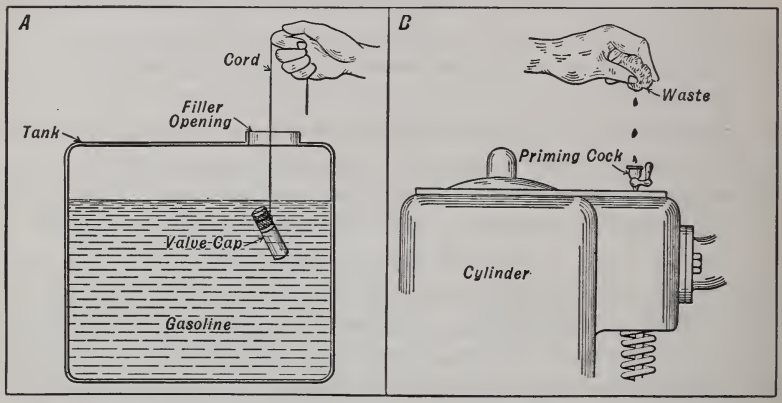


Fig. 723.—Two Methods of Obtaining Gasoline from Container to Prime Cylinders and Facilitate Motor Starting in Cold Weather.

At A one of the tire valve caps is utilized as a cup to remove a certain portion of gasoline from the tank. It is utilized by tying a piece of cord or wire to the end and then dropping it into the gasoline tank through the filler opening. One of these caps will hold enough gasoline to start the ordinary four-cylinder motor. Another method of accomplishing the same result is shown at B. In this a piece of waste is tied into a ball and dropped into the gasoline tank. When removed it is saturated with fuel and enough gasoline may be squeezed from the waste into the priming cocks to prime the motor. If an oil squirt gun forms part of the tool equipment, this may be used to draw gasoline from the tank without difficulty.

In extreme cold weather many motorists disconnect the fan belt in order that the air draught through the radiator will not cool the water to such a point that the engine will not run efficiently. Other motorists provide some form of a lined leather shield for the front of the radiator, as shown at Fig. 724. At A the shield is shown partly opened so that a large area of the radiator is exposed to the air. At B the openings in the shield have been closed by the shutter-like closure and the radiator is protected in such a way that the water will be kept warm if a stop of any consequence is made.

Spot-Removing Preparations.—A point that worries many motorists, especially those of the gentler sex, is the methods of removing oil spots which frequently are present upon the clothing of motorists. The following rules will be found valuable in this connection:

Most frequent among the various kinds of spots are those due to oil or grease. Materials in delicate colors require a special treatment so their shade will not be changed. If a grease spot is to be removed, the main portion of the grease is first carefully scraped off by means of a knife blade. A plaster of Fuller's earth, prepared by diluting the earth with a little water, is applied to the surface affected. This remains in place for several minutes, and is then scraped off. Any particles of Fuller's earth remaining on the cloth can be washed off with water. By lightly ironing out the affected portion of the garment it will be completely renovated.

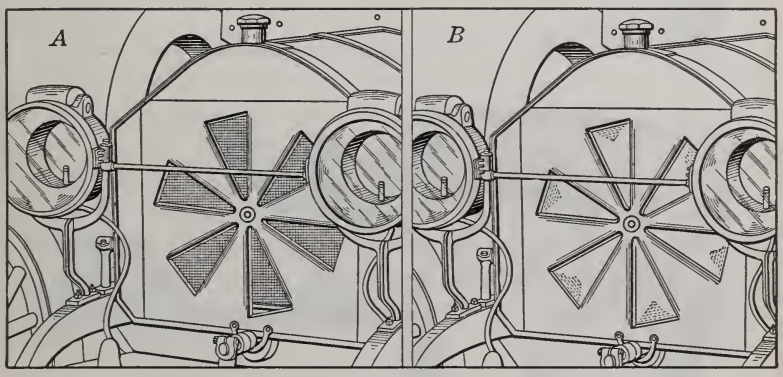


Fig. 724.—Special Cover to Protect Radiator During Cold Weather and Retain Heat, which Makes for Easy Starting.

In no case should a solvent (benzene or gasoline) be used for removing spots from materials dyed in light shades, as there is danger that the dye will be dissolved with the grease. Cotton and linen garments, whether white or dyed, can be restored by local treatment with soap. Materials that are not dyed and broadcloth may be easily cleaned by means of benzol, gasoline or alcohol-benzol mixtures, the latter being the best solvent.

Material of light weight is stretched between the hands and the solvent is poured on it drop by drop until the cloth is penetrated. The degreasing process is completed by pressing the moist portion between two pieces of clean linen. If the material is heavy—such as broadcloth—the spot is rubbed repeatedly with a rag of linen soaked with one of the solvents mentioned above, until the material is

moistened all through, and care must be taken to discard the rag as soon as it becomes dirty, and use a clean one.

Kerosene spots, which are easily formed, should first be treated with a slight coating of vegetable oil (lubricating oil; or, better, olive

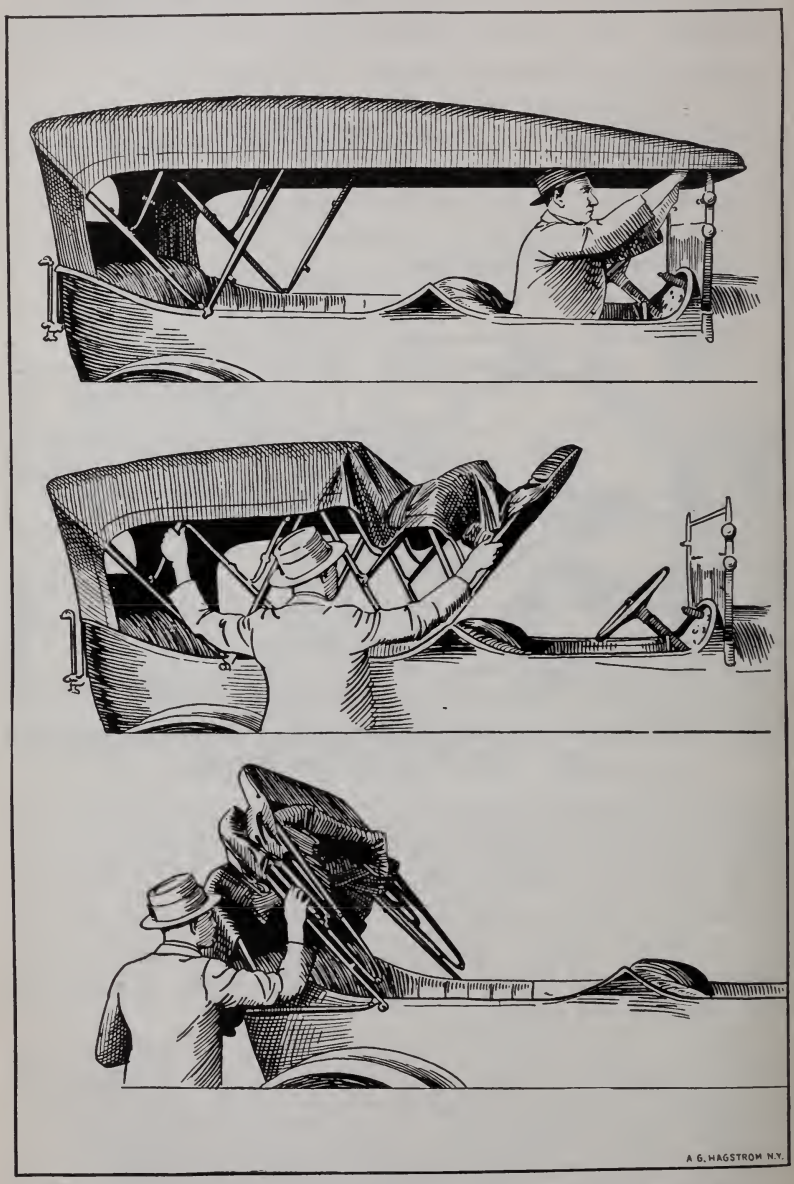


Fig. 725.—Showing Steps in Folding Latest Type One-Man Top.

oil), so as to absorb the kerosene, and then treated with the Fuller's earth plaster, which absorbs the whole quite rapidly.

Authorities recommend a number of liquid compositions for removing grease spots from cloths which are not delicate. One of the simplest of these consists of

Wood alcohol	2 parts
Alcoholic essence of soap	2 parts
Ammonia	4 parts
Turpentine	4 parts

The alcoholic essence of soap is prepared by dissolving some white Marseilles soap in sixteen times the amount of ninety degrees alcohol, and adding ten parts of water. The white Marseilles soap is probably substantially the same as Ivory soap. Any druggist will undertake to prepare this essence. It is sufficient to apply it moderately with a linen rag.

Finally, on a road only recently tarred the motorist's clothes may be spattered with tar and their treatment is a rather delicate matter. If washable garments or fast-color materials are spotted by this material, one may, after having removed the greater portion of the tar by scraping, pour either benzol or gasoline drop by drop on the back side of the material, so the solvent will run through the spotted part. If the material is light colored it may be nearly completely cleaned by using a rag soaked in gasoline, and taking care to touch only the spot. This latter treatment calls for considerable skill, but with patience one is usually successful.

CHAPTER XVI

Practical Hints to Assist in Locating Power-Plant Troubles—Systematic Detection of Conditions to which Imperfect Operation Can Be Ascribed—Faults in the Ignition System—Derangements of the Carburetion Group and Their Symptoms—Cooling and Lubrication Group Troubles.

One versed in motor-car construction and repair processes does not have any difficulty in tracing the common motor troubles to their source and the expert readily recognizes the symptoms which denote faulty action of any of the power-plant components. The average motorist, who has but little mechanical experience, is apt to become hopelessly confused when even the simpler derangements, liable to occur at any time, materialize. One who is not thoroughly familiar with motor-car construction will seldom locate troubles by haphazard experimenting and it is only by a systematic search that the cause can be discovered and the defects eliminated. In this chapter the writer proposes to outline some of the most common power-plant troubles and to give sufficient advice to enable those who are not thoroughly informed to locate them by a logical process of elimination. It is understood that this treatise cannot cover repairing to any extent, so the reader interested in mechanical processes and auto repairing will find the companion volume of this one, "Automobile Repairing Made Easy," of great value.

The internal-combustion motor, which is the power plant of all gasoline automobiles, is composed of a number of distinct groups, which in turn include distinct components. These various appliances are so closely related to each other that defective action of any one may interrupt the operation of the entire power plant. Some of the auxiliary groups are more necessary than others and the power plant will continue to operate for a time even after the failure of some important parts of some of the auxiliary groups. The gasoline engine in itself is a complete mechanism, but it is evident that it cannot deliver any power without some means of supplying gas to the cylinders

Note.—"Automobile Repairing Made Easy," by Victor W. Pagé. Price $3.00. Published by The Norman W. Henley Pub. Co., 2 West 45th Street, New York City.

and igniting the compressed gas charge after it has been compressed in the cylinders. From this it is patent that the ignition and carburetion systems are just as essential parts of the power plant as the piston, connecting rod, or cylinder of the motor. The failure of either the carburetor or igniting means to function properly will be immediately apparent by faulty action of the power plant.

To insure that the motor will continue to operate it is necessary to keep it from overheating by some form of cooling system and to supply oil to the moving parts to reduce friction. The cooling and lubrication groups are not so important as carburetion and ignition, as the engine would run for a limited period of time even should the cooling system fail or the oil supply cease. It would only be a few moments, however, before the engine would overheat if the cooling system was at fault, and the parts seize if the lubricating system should fail. Any derangement in the carburetor or ignition mechanism would manifest itself at once because the engine operation would be affected, but a defect in the cooling or oiling system would not be noticed so readily.

The careful motorist will always inspect the motor mechanism before starting on a trip of any consequence, and if inspection is carefully carried out and loose parts tightened it is seldom that irregular operation will be found due to actual breakage of any of the components of the mechanism. Deterioration due to natural causes matures slowly, and sufficient warning is always given when parts begin to wear so satisfactory repairs may be promptly made before serious derangement or failure is manifested.

A Typical Engine Stoppage Analyzed.—Before describing the points that may fail in the various auxiliary systems it will be well to assume a typical case of engine failure and show the process of locating the trouble in a systematic manner by indicating the various steps which are in logical order and which could reasonably be followed. In any case of engine failure the ignition system, motor compression, and carburetor should be tested first. If the ignition system is functioning properly one should determine the amount of compression in all cylinders and if this is satisfactory the carbureting group should be tested. If the ignition system is working properly and there is a decided resistance in the cylinders when the starting handle is turned, proving that there is good compression, one may suspect the carburetor.

If the carburetor appears to be in good condition, the trouble may be caused by the ignition being out of time, which condition is possible when the timer is attached to the cam shaft by a set screw or the magneto timing gear to the armature shaft by a taper and nut retention instead of the more positive key or taper-pin

fastening. It is possible that the inlet manifold may be broken or perforated, that the exhaust valve is stuck on its seat because of a broken or bent stem, broken or loose cam, or failure of the cam-shaft drive because the teeth are stripped from the engine shaft or cam-shaft gears; or because the key or other fastening on either gear has failed, allowing that member to turn independently of the shaft to which it normally is attached. The gasoline feed pipe may be clogged or broken, the fuel supply may be depleted, or the shut-off cock in the gasoline line may have jarred closed. The gasoline filter may be filled with dirt or water which prevents passage of the fuel.

The defects outlined above, except the failure of the gasoline supply, are very rare, and if the container is found to contain fuel and the pipe line to be clear to the carburetor, it is safe to assume the vaporizing device is at fault. If fuel continually runs out of the mixing chamber the carburetor is said to be flooded. This condition results from failure of the shut-off needle to seat properly or from a punctured hollow metal float or a gasoline-soaked cork float. It is possible that not enough gasoline is present in the float chamber. If the passage controlled by the float-needle valve is clogged or if the float was badly out of adjustment, this contingency would be probable. When the carburetor is examined, if the gasoline level appears to be at the proper height, one may suspect that a particle of lint, or dust, or fine scale, or rust from the gasoline tank has clogged the bore of the jet in the mixing chamber.

If the ignition system and carburetor appear to be in good working order, and the hand crank shows that there is no compression in one or more of the cylinders, it means some defect in the valve system. If the engine is a multiple-cylinder type and one finds poor compression in all of the cylinders it may be due to the rare defect of improper valve timing. This may be caused by a gear having altered its position on the cam shaft or crank shaft, because of a sheared key or pin having permitted the gear to turn about a half of a revolution and then having caught and held the gear in place by a broken or jagged end so that cam shaft would turn, but the valves open at the wrong time. If but one of the cylinders is at fault and the rest appear to have good compression the trouble may be due to a defective condition either inside or outside of that cylinder. The external parts may be inspected easily, so the following should be looked for: a broken valve, a warped valve head, broken valve springs, sticking or bent valve stems, dirt under valve seat, leak at valve-chamber cap or spark-plug gasket. Defective priming cock, cracked cylinder head (rarely occurs), leak through cracked spark-plug insulation, valve plunger

stuck in the guide, lack of clearance between valve-stem end and top of plunger caused by loose adjusting screw which has worked up and kept the valve from seating. The faulty compression may be due to defects inside the motor. The piston head may be cracked (rarely occurs), piston rings may be broken, the slots in the piston rings may be in line, the rings may have lost their elasticity or have become gummed in the grooves of the piston, or the piston and cylinder walls may be badly scored by a loose wrist pin or by defective lubrication. If the motor is a type with a separate head it is possible the gasket or packing between the cylinder and combustion chamber may leak, either admitting water to the cylinder or allowing compression to escape.

Conditions that Cause Failure of Ignition System.—If the first test of the motor had showed that the compression was as it should be and that there were no serious mechanical defects and there was plenty of gasoline at the carburetor, this would have demonstrated that the ignition system was not functioning properly. If a battery is employed to supply current the first step is to take the spark plugs out of the cylinders and test the system by turning over the engine by hand. If there is no spark in any of the plugs, this may be considered a positive indication that there is a broken main current lead from the battery, a defective ground connection, a loose battery terminal, or a broken connector. If none of these conditions are present, it is safe to say that the battery is no longer capable of delivering current. If there is no spark at the plugs, but the spark-coil vibrator functions properly, this shows that the primary wiring is as it should be and that the fault must be looked for in either the wires comprising the secondary circuit, or at the plugs.

The spark plugs may be short circuited by cracked insulation or carbon and oil deposits around the electrode. The secondary wires may be broken or have defective insulation which permits the current to ground to some metal part of the frame or motor. The battery strength should be tested with volt or ampere meter to determine if the voltage and amperage are sufficient. Storage-battery capacity is usually gauged by measuring the voltage while dry cells are judged by their amperage. A storage battery should show at least two volts per cell, while dry batteries that indicate less than seven amperes per cell are not considered reliable or satisfactory for ignition service.

Note.—Very complete information on all kinds of electrical apparatus may be found in "Automobile Starting, Lighting and Ignition Systems," by Pagé. Price, $1.50. The Norman W. Henley Pub. Co., 2 West 45th Street, New York City.

If there is no vibration at the coil trembler or vibrator the trouble may be due to weak current source, broken timer wires, or defective connections at the vibrator or commutator contact points. The electrodes of the spark plug may be too far apart to permit a spark to overcome the resistance of the compressed gas, even if a spark jumps the air space, when the plug is laid on the cylinder.

If a magneto is fitted and a spark is obtained between the points of the plug and that device or the wire leading to it from the magneto is in proper condition, the trouble is probably caused by the magneto being out of time. This may result if the driving gear is loose on the armature shaft or crank shaft, and is a rare occurrence. If no spark is produced at the plugs the secondary wire may be broken, the ground wire may make contact with some metallic portion of the chassis before it reaches the switch, the carbon collecting brushes may be broken or not making contact, the contact points of the make-and-break device may be out of adjustment, the wiring may be attached to wrong terminals, the distributor filled with metallic particles, carbon, dust or oil accumulations, the distributor contacts may not be making proper connection because of wear and there may be a more serious derangement, such as a burned out secondary winding or a punctured condenser.

If the motor runs intermittently, i. e., starts and runs only a few revolutions, aside from the conditions previously outlined, defective operation may be due to seizing between parts because of insufficient oil or deficient cooling, too much oil in the crank case which fouls the cylinder after the crank shaft has revolved a few turns, and derangements in the ignition or carburetion systems that may be easily remedied. There are a number of defective conditions which may exist in the ignition group, that will result in "skipping" or irregular operation, and the following is the logical order in which the various points should be inspected; the parts which demand inspection oftenest are considered first: weak source of current due to worn out dry cells or discharged storage batteries; weak magnets in magneto, or defective contacts at magneto; dirt in magneto distributor or poor contact at collecting brushes. Dirty or cracked insulator at spark plug will cause short circuit and can only be detected by careful examination. The following points should also be checked over when the plug is inspected: Excessive space between electrodes, points too close together, loose central electrodes, or loose point on plug body, soot or oil particles between electrodes, or on the surface of the insulator.

When testing a dry battery, the terminals should be gone over carefully to make sure that all terminal nuts are tight and that there

are no loose or broken cell connectors. The wiring at the coil, timer, and switch should be inspected to see that all connections are tight and that the insulation is not chafed or cracked. Defective insulation will allow leakage of current, while loose connections make for irregular operation. In testing a storage battery care should be taken to remove all the verdigris or sulphate from the terminals before attaching the testing wires. If a magneto is used there may be a short circuit in the ground wire or a poor connection at either switch lever or switch key.

The timer or distributor used with a battery-ignition system may be dirty and if the device wabbles or has loose bearings, the primary contact will be very poor. The insulating ring at the timer or distributor, or the fiber or hard-rubber bushings at magneto or timer may allow loss of current if they are cracked. If the ignition system employs low-tension sparking plates the igniter should be removed and examined with particular reference to the sparking or contact points which should be clean and free from pits or irregular projections. The bushing which insulates the fixed contact or anvil from the plate should be clean and free from oil or cracks. Wear in the operating mechanism of the igniter will cause irregular operation. A poor ground contact at a commutator of the high-tension system will cause irregular ignition.

If a vibrator coil is employed the trembler platinum contact points should be examined for pits or carbonized particles that would interfere with good contact. If defective, they should be thoroughly cleaned and the surfaces of the platinum point on both vibrator spring and adjusting screw should be filed smooth to insure positive contact. The tension of the vibrator spring should not be too light or too heavy and the vibrator should work rapidly enough to make a sharp, buzzing sound when contact is established at the timer. The adjusting screw should be tight in the vibrator bridge and when proper spring tension is obtained the regulating screw should be locked firmly to prevent movement.

If the vibrator operates satisfactorily, but there is a brilliant spark between the vibrator points and a poor spark at the spark plug, one may assume that the coil condenser is punctured. Short circuits in the condenser or internal wiring of induction coils or magnetos, which are fortunately not common, can seldom be remedied except at the factory where these devices were made. If an engine stops suddenly and the defect is in the ignition system the trouble is usually never more serious than a broken or loose wire. This may be easily located by inspecting the wiring at the terminals. Irregular operation

or misfiring is harder to locate because the trouble can only be found after the many possible defective conditions have been checked over, one by one.

Common Defects in Fuel Systems.—Defective carburetion often causes misfiring or irregular operation. The common derangement of the components of the fuel system that are common enough to warrant suspicion and the best methods for their location follows: First, disconnect the feed pipe from the curburetor and see if the gasoline flows freely from the tank. If the stream coming out of the pipe is not the full size of the orifice it is an indication that the pipe is clogged with dirt or that there is an accumulation of rust, scale, or lint in the strainer screens of the filter. It is also possible that the fuel shut-off valve may be wholly or partly closed. If the gasoline flows by gravity the liquid may be air bound in the tank, while if a pressure-feed system is utilized the tank may leak so that it does not retain pressure; the check valve retaining the pressure may be defective or the pipe conveying the air or gas under pressure to the tank may be clogged.

If the gasoline flows from the pipe in a steady stream the carburetor demands examination. There may be dirt or water in the float chamber, which will constrict the passage between the float chamber and the spray nozzle, or a particle of foreign matter may have entered the nozzle and stopped up the fine holes therein. The float may bind on its guide, the needle valve regulating the gasoline-inlet opening in bowl may stick to its seat. Any of the conditions mentioned would cut down the gasoline supply and the engine would not receive sufficient quantities of gas. The air-valve spring may be weak or the air valve broken. The gasoline-adjusting needle may be loose and jar out of adjustment, or the air-valve spring-adjusting nuts may be such a poor fit on the stem that adjustments will not be retained. Air may leak in through the manifold, due to a porous casting, or leaky joints in a built up form and dilute the mixture. The air-intake dust screen may be so clogged with dirt and lint that not enough air will pass through the mesh. Water or sediment in the gasoline will cause misfiring because the fuel feed varies when the water or dirt constricts the standpipe bore.

It is possible that the carburetor may be out of adjustment. If clouds of black smoke are emitted at the exhaust pipe it is positive indication that too much gasoline is being supplied the mixture and the supply should be cut down by screwing in the needle valve on types where this method of regulation is provided, and by making sure that the fuel level is at the proper height in those forms where the spray nozzle has no means of adjustment. If the mixture contains

too much air there will be a pronounced popping back in the carburetor. This may be overcome by screwing in the air-valve adjustment so the spring tension is increased or by slightly opening up the gasoline-supply regulation needle. When a carburetor is properly adjusted and the mixture delivered the cylinder burns properly, the exhaust gas will be clean and free from the objectionable odor present when gasoline is burned in excess.

If a muffler cut-out is provided the character of combustion may be judged by the color of the flame which issues from it when the engine is running with an open throttle after nightfall. If the flame is red, it indicates too much gasoline. If yellowish, it shows an excess of air, while a properly proportioned mixture will be evidenced by a pronounced blue flame, such as given by a gas-stove burner.

Defects in Oiling Systems.—While troubles existing in the ignition or carburetion groups are usually denoted by imperfect operation of the motor, such as lost power, and misfiring, derangements of the lubrication or cooling systems are usually evident by overheating, diminution in engine capacity, or noisy operation. Overheating may be caused by poor carburetion as much as by deficient cooling or insufficient oiling. When the oiling group is not functioning as it should the friction between the motor parts produces heat. If the cooling system is in proper condition, as will be evidenced by the condition of the water in the radiator, and the carburetion group appears to be in good condition, the overheating is probably caused by some defect in the oiling system.

The conditions that most commonly result in poor lubrication are: Insufficient oil in the engine crank case or sump, broken or clogged oil pipes, screen at filter filled with lint or dirt, broken oil pump, or defective oil-pump drive. The supply of oil may be reduced by a defective inlet or discharge-check valve at the mechanical oiler or worn pumps. A clogged oil passage or pipe leading to an important bearing point will cause trouble because the oil cannot get between the working surfaces. When simple compression pressure feed lubricators are employed the check valves may be defective or the container may leak. Either of these conditions will prevent the accumulation of pressure on the surface of the oil and the feed will not be positive. The sight-feed glasses may fill with oil because the pipes leading from them to the engine are full, or because the conductor is clogged with oil wax. This gives sufficient warning, however, and the oil pipe may be easily cleared by removing it and blowing it out with air or steam under pressure. It is well to remember that much of the trouble caused by

defective oiling may be prevented by using only the best grades of lubricant, and even if all parts of the oil system are working properly, oils of poor quality will cause friction and overheating.

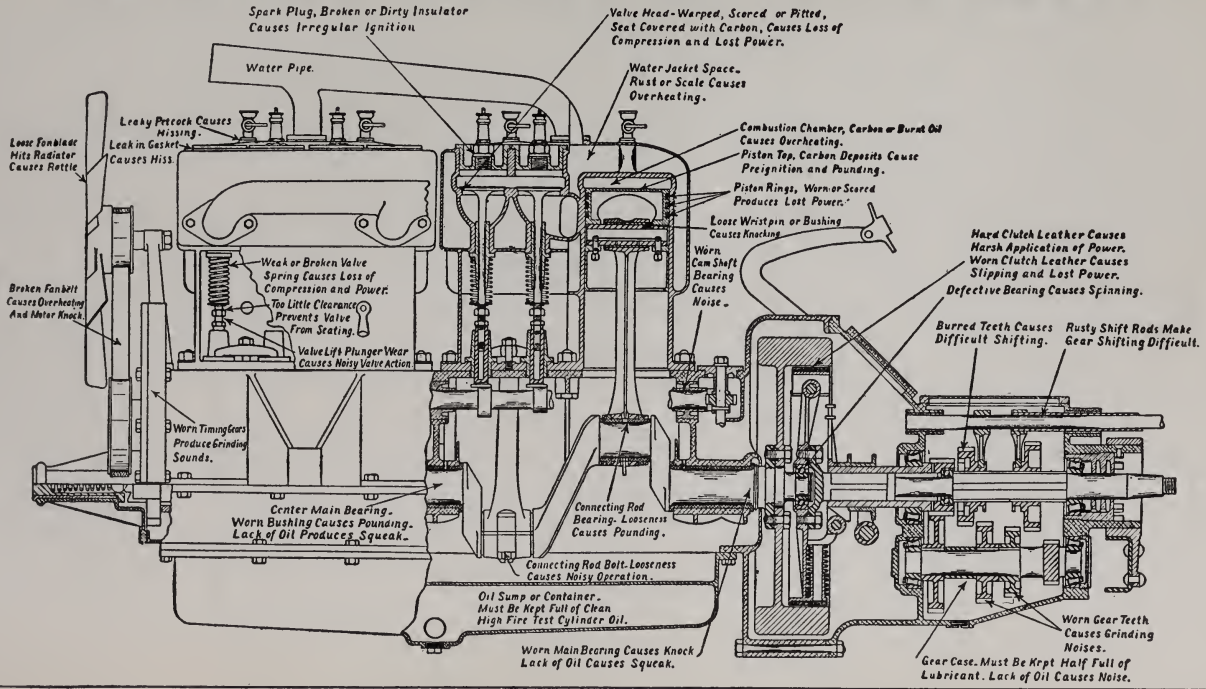
Defects in Cooling Systems Outlined.—Cooling systems are very simple and are not liable to give trouble as a rule if the radiator is kept full of clean water and the circulation is not impeded. When overheating is due to defective cooling the most common troubles are those that impede water circulation. If the radiator is clogged or the piping or water jackets filled with rust or sediment the speed of water circulation will be slow, which will also be the case if the water pump or its driving means fail. Some cooling systems are so closely proportioned to the actual requirements that the stoppage of a cooling fan will be enough to cause the engine to overheat. Any scale or sediment in the water jackets or in the piping or radiator passages will reduce the heat conductivity of the metal exposed to the air, and the water will not be cooled as quickly as though the scale was not present.

The rubber hose often used in making the flexible connections demanded between the radiator and water manifolds of the engine may deteriorate inside and particles of rubber hang down that will reduce the area of the passage. The grease from the grease cups mounted on the pump-shaft bearing to lubricate that member often finds its way into the water system and rots the inner walls of the rubber hose, this resulting in strips of the partly decomposed rubber lining hanging down and restricting the passage. The cooling system is prone to overheat after antifreezing solutions of which calcium chloride forms a part have been used. This is due to the formation of crystals of salt in the radiator passages or water jackets, and these crystals can only be dissolved by suitable chemical means, or removed by scraping when the construction permits.

Overheating is often caused by some condition in the fuel system that produces too rich mixture. Excess gasoline may be supplied if any of the following conditions are present: Bore of spray nozzle or standpipe too large, auxiliary air-valve spring too tight, gasoline level too high, loose regulating valve, fuel-soaked cork float, punctured sheet-metal float, dirt under float control shut-off valve or insufficient air supply because of a clogged air screen. If pressure feed is utilized there may be too much gas pressure in the tank, or the float controlled mechanism operating the shut-off in either the auxiliary tank on the dash or the float bowl of the carburetor may not act quickly enough.

Some Causes of Noisy Operation.—There are a number of power-plant derangements which give positive indication because of noisy

CHART SHOWING COMMON TROUBLES CAUSING DEFECTIVE OPERATION OF UNIT POWER PLANT.


Spark Plug, Broken or Dirty Insulator Causes Irregular Ignition
Valve Head-Warped, Scored or Pitted, Seat Covered with Carbon, Causes Loss of Compression and Lost Power.
Water Pipe.
Water Jacket Space. Rust or Scale Causes Overheating.
Leaky Petcock Causes Missing.
Loose Fanblade Hits Radiator Causes Rattle
Leak in Gasket Causes Hiss.
Combustion Chamber, Carbon or Burnt Oil Causes Overheating.
Piston Top, Carbon Deposits Cause Preignition and Pounding.
Piston Rings, Worn or Scored Produces Lost Power.
Loose Wristpin or Bushing Causes Knocking
Worn Cam Shaft Bearing Causes Noise.
Hard Clutch Leather Causes Harsh Application of Power.
Worn Clutch Leather Causes Slipping and Lost Power.
Defective Bearing Causes Spinning.
Weak or Broken Valve Spring Causes Loss of Compression and Power.
Too Little Clearance Prevents Valve From Seating.
Broken Fanbelt Causes Overheating And Motor Knock.
Valve Lift Plunger Wear Causes Noisy Valve Action.
Burred Teeth Causes Difficult Shifting.
Rusty Shift Rods Make Gear Shifting Difficult.
Worn Timing Gears Produce Grinding Sounds.
Center Main Bearing. Worn Bushing Causes Pounding. Lack of Oil Produces Squeak.
Connecting Rod Bearing. Looseness Causes Pounding.
Connecting Rod Bolt. Looseness Causes Noisy Operation.
Oil Sump or Container. Must Be Kept Full of Clean High Fire Test Cylinder Oil.
Worn Gear Teeth Causes Grinding Noises.
Worn Main Bearing Causes Knock Lack of Oil Causes Squeak.
Gear Case. Must Be Kept Half Full of Lubricant. Lack of Oil Causes Noise.

operation. Any knocking or rattling sounds are usually produced by wear in connecting rods or main bearings of the engine, though sometimes a sharp metallic knock, which is very much the same as that produced by a loose bearing, is due to carbon deposits in the cylinder heads, or premature ignition due to advanced spark-time lever. Squeaking sounds invariably indicate dry bearings, and whenever such a sound is heard it should be immediately located and oil applied to the parts thus denoting their dry condition. Whistling or blowing sounds are produced by leaks, either in the engine itself or in the gas manifolds. A sharp whistle denotes the escape of gas under pressure and is usually caused by a defective packing or gasket that seals a portion of the combustion chamber or that is used for a joint as the exhaust manifold. A blowing sound indicates a leaky packing in crank case. Grinding noises in the motor are usually caused by the timing gears and will obtain if these gears are dry or if they have become worn. Whenever a loud knocking sound is heard careful inspection should be made to locate the cause of the trouble. Much harm may be done in a few minutes if the engine is run with loose connecting rod or bearings that would be prevented by taking up the wear or looseness between the parts by some means of adjustment.

As a general rule the average motorist is not sufficiently informed mechanically to undertake repairs of worn motor parts, and whenever repairs of a mechanical nature are necessary it will be much more satisfactory and cheaper to have them done by experienced mechanics or repairmen. Ordinary adjustments may be attempted by even the inexpert, but it should be remembered that nothing may be changed without a good reason existing for making the alteration. It is not proposed to discuss the various causes of noisy operation at length because the defective conditions which are evident by noisy action can usually be remedied only by skilled labor. The common defects of the auxiliary groups have been mentioned in detail, however, because these troubles may occur on the road and it is well for the motorist to be familiar with the common derangements that may result in irregular engine operation or loss of power.

It is not in the scope of a work of this nature to analyze fully the mechanical derangement and methods of restoration because a separate volume would be needed to bring these points out adequately enough to be of value. If the motorist follows the hints given in this chapter he is not likely to be stalled on the road by simple defects which he can remedy as well as the more expert. It is well to remember that common troubles can only be located by systematic search and that causes of imperfect engine action are often located by those who

do not recognize the symptoms because they follow a logical process of elimination. It must be evident that all of the defects outlined will never happen within the average experience, but the conditions defined have been named because they have occurred often enough and are sufficiently common to warrant suspicion if trouble is experienced.

Brief Summary of Hints for Locating Engine Troubles.—First make sure that all cylinders have compression. To ascertain this, open pet cocks of all cylinders except the one to be tested, crank over motor and see that a strong opposition to cranking is met with once in two revolutions. If motor has no pet cocks, crank and notice that oppositions are met at equal distances, two to every revolution of the starting crank in a four-cylinder motor. If compression is lacking, examine the parts of the cylinder or cylinders at fault in the following order, trying to start the motor whenever any one fault is found and remedied. See that the valve push rods do not touch valve stems for more than approximately $\frac{1}{2}$ revolution in every 2 revolutions, and that there is not more than 1/32 inch clearance between them. Make sure that the exhaust valve seats. To determine this examine the spring and see that it is connected to the valve stem properly. Take out valve and see that there is no obstruction, such as carbon, on its seat. See that valve works freely in its guide. Examine inlet valve in same manner. Listen for hissing sound while cranking motor for leaks at other places.

Make sure that a spark occurs in each cylinder as follows: If using battery and vibrating coil system, get commutator rotor on contact. Put switch in "on" position. See that vibrator works. Examine adjustment of vibrator. Test condition of battery. Take out spark plug, widen gap to nearly $\frac{1}{4}$ inch, lay it on the cylinder and, with switch on and vibrator working, see if spark occurs. Be sure to bring plug points closer together, almost 1/32" before replacing in cylinder. If gap in plug cannot be widened, try another plug (from a cylinder that does work). Examine all wires for proper position, good connections, breaks and short circuits. See that commutator is timed correctly. If magneto or magneto and battery with non-vibrating coil is used: Disconnect wire from spark plug, hold end about $\frac{1}{8}$ inch from cylinder. Have motor cranked briskly and see if spark occurs. Examine adjustment of interrupter points. See that wires are placed correctly and not short circuited. Take out spark plug and lay it on the cylinder, being careful that base of plug only touches the cylinder. Have motor cranked briskly and see if spark occurs. Check timing of magneto and see that all brushes are making contact.

See if there is gasoline in the carburetor. See that there is gaso-

line in the tank. Examine valve at tank. Prime carburetor and see that spray nozzle passage is clear. Be sure throttle is open. Prime cylinders by putting about a teaspoonful of gasoline in through pet cock or spark plug opening. Adjust carburetor if necessary.

Note.—For complete instructions on automobile repairing, see "Automobile Repairing Made Easy," by the same author, intended as a companion volume to this one. Price, $3.00. The Norman W. Henley Pub. Co., 2 West 45th Street, New York City.

CHAPTER XVII

Keeping Up the Motor-Car Chassis—Common Defects of Clutches and Gearsets—Faults in Chain- and Shaft-Driving Systems—Troubles in Front and Rear Axles—Adjustment of Brakes—Care of Miscellaneous Chassis Components—Maintenance of Body Finish, Tops, and Upholstery.

When any defects exist in the power plant they are immediately evidenced by lost power, misfiring, overheating, or other positive indications that cannot be neglected. There are many points in the chassis that may wear and be faulty in action that will not be immediately apparent. Deterioration may exist in the power-transmission elements which will mean a serious diminution in power, but as the motor car will run more or less capably the faults are not generally known and cannot be definitely located by motorists. There are some points where wear or loose parts may directly concern the safety of the occupants of the car. For instance, any defect in either the steering gear or the brakes might result disastrously in event of failure. It is not possible to discuss all the points that may need attention or to consider at length the restoration of defective components, but it is well to consider some of the common troubles which may result in imperfect operation and which can be easily eliminated.

Common Defects in Clutches.—Considering first the member of the transmission system that will affect the efficiency of the entire assembly when deranged, it will be well to discuss the troubles common to the various types of clutches. The defective conditions that most often materialize are too sudden engagement which causes "grabbing," failure to engage properly, slipping under load, and poor release. Clutches utilizing a leather facing will cause trouble after a time because of natural wear or some defect of the friction facing. The leather may be charred by heat caused by slipping, or it may have become packed down hard and have lost most of its resiliency. The clutch spring may be weakened, or broken; this will cause the clutch to slip even if the leather facing of the cone is in good condition. The two troubles usually met with by the motorist are harsh action, as one extreme condition, and loss of power through slippage as the other.

When a cone clutch engages too suddenly it is generally caused by the surface of the leather lining becoming hard and not having sufficient resiliency to yield to some extent when first brought into frictional contact. To insure gradual clutch application the facing should be soft and elastic. If the leather is not burned or worn unduly it may often be softened by rubbing it with neatsfoot oil. Kerosene oil is often enough to keep the clutch leather pliable and it possesses so little lubricating value that the clutch members are not liable to slip because of a reduced coefficient of friction such as often caused by the application of more viscous lubricants. Kerosene has other advantages, among which may be mentioned quick penetration of the leather and not collecting grit or gumming.

When a cone clutch slips it is usually due to a coating of oil on the frictional material that decreases the value of the coefficient of friction to such a point that the pressure of the clutch spring is not enough to maintain sufficient frictional contact between the male and female members to insure driving. The remedy for this condition is to absorb the surplus oil by rubbing a small quantity of Fuller's earth into the leather surface. When the clutch cone is in place it is not easy to reach the surface of the leather, so the first step would be to disengage or release the clutch and to place enough of the Fuller's earth on a piece of paper or card so it can be sprinkled into the space left between the male and female members when the former is properly released. Borax is sometimes recommended for the same purpose and when the earth or borax are not available the carbide dust or lime residue from the acetylene-gas generator may be used to advantage. If slipping is caused by weakening of the clutch spring it may be prevented by substituting springs of proper strength or by increasing the degree of compression of the weak springs by some means of adjustment if provided for the purpose.

Another annoying condition that sometimes obtains when a cone clutch is used is spinning or continued rotation of the male member when clutch-spring pressure is released. This may be the result of natural causes but it is sometimes caused by a defect in the clutch mechanism. If the bearing on which the cone revolves when disengaged seizes because of lack of lubricant the male member of the clutch will continue to rotate even when spring pressure is released. The ball-thrust bearing employed to resist spring tension may become wedged by a broken ball and this will cause the rotation of the crank shaft to be imparted to the cone member, through the spring, which must turn with the crank shaft instead of remaining stationary, as would be the case if the ball-thrust bearing was functioning properly.

On those cars fitted with multiple-disk clutches the same troubles may be experienced as with other types. If a multiple-disk clutch does not release properly it is because the surfaces of the plates have become rough and tend to drag. The plates of a multiple-disk clutch should be free from roughness and the surfaces should always be smooth and clean. Harsh engagement also results by the absence of oil in those types where the disks are designed to run into an oil bath. Spinning or continued rotation of a multiple-disk clutch often results from seizing due to gummed oil, the presence of carbon or burned oil between the plates and sometimes by a lack of oil between the members. When a multiple-disk clutch slips, it is generally caused by lack of strength of the clutch springs or distortion of the plates. To secure the best results from a multiple-disk clutch it is imperative that only certain grades of oil be used. If one uses a cheap or inferior lubricant it will gum and carbonize because of the heat present when the plates slip or it will have such viscosity that it will gum up between the plates. Most authorities recommend a good grade of light or medium cylinder oil in multiple-disk clutches where lubricant is required. In some cases faulty multiple-disk clutch action is due to "brooming," which is the condition that exists when the sides of the keyways or the edges of the disk become burred over and prevent full contact of the plates.

Faulty clutch action has often been traced to points separate from the clutch mechanism. Some cases of failure of clutch to release have been found due to imperfect relation of interlocking levers and rods or wear in some mechanical parts. If a clutch-shifting collar is worn unduly or the small pins in the rod connecting the clutch pedal with the release mechanism have worn to any extent the pedal may be fully depressed and yet the pressure of the spring depended upon to keep the parts in contact will not be reduced to any extent. Sometimes the emergency-brake lever may have an interlocking leverage to release the clutch when it is applied, and when the brake rods are shortened to compensate for wear of the brakes the change in length of the operating rods may throw out the clutch mechanism slightly and cause slipping of the clutch because the spring pressure may be partially relieved.

Derangements in Change-Speed Gearing.—As previously explained, the simplest form of gearing to obtain various speed ratios is the friction-disk type. Failure to drive properly may result from excessive oil on either the face of the driving disk or the periphery of the driving wheel, lost motion, wear or spring at various points in the operating mechanism, or deterioration of the surfaces of either driving disks or driven wheel. If trouble is experienced in a friction trans-

mission the first point to inspect is the condition of the friction surfaces. If excessive deposits of oil have caused slipping it should be thoroughly removed with gasoline and the surface of both disk and wheel sprinkled with talc powder. If the face of the aluminum-alloy driving disk is grooved or roughened, slipping is inevitable until the disk is refaced absolutely true. The strawboard-fiber friction band of the driven wheel may "broom" out, and this will cause slipping because the surface is not true. As a general rule, the fiber ring of the friction transmission should be renewed after it has been used from 2,500 to 3,000 miles. Wear at the countershaft bearings will produce a tendency for the driven wheel to crowd toward the center or edge of the driving disk, depending upon the relation of the actual line of contact with the theoretical contact line drawn through the disk. Lost motion or spring in the parts serving to engage the friction surfaces will cause slipping because the degree of pressure necessary to secure the frictional adhesion required between the members to secure positive driving will be reduced.

The chief trouble with a planetary transmission is caused by slipping clutch bands. These are provided with adjustments that can be tightened in case of wear and should grip positively. If either the slow or reverse bands are adjusted too tight they will bind on the drums and produce friction, which in turn will decrease the efficiency of the drive. Noisy action of planetary gearing is usually caused by lack of lubrication or excessive wear in the gearing. If the oiling is properly taken care of this condition will be practically eliminated. Sometimes the high-speed clutch may slip, but most planetary gears are provided with adjustable clutches so any wear may be readily taken up.

When sliding-gear transmissions are used the most common defect is difficulty in shifting gears and noisy operation. The difficulty met with in gear shifting is usually caused by the edges of the teeth of the shifting members having burred over so that they do not pass readily into the spaces between the teeth of the gears they engage with. Another cause of poor gear shifting is deterioration of the bearings which may change the center distances of the shafts to a certain degree, and the relation of the gears may be changed relative to each other so they will not slide into mesh as freely as they should. Noisy operation is usually due to a defective condition of lubrication, and if the gears are not worn too much it may be minimized to a large extent by filling the gear case with oil of sufficient consistency to cushion the gear teeth and yet not be so viscous that it will not flow readily to all bearing points. A difficulty in shifting is sometimes due

to binding in the control levers or selective rods, and these should always work freely if prompt gear shifting is required. If considerable difficulty is experienced in meshing the gears and the trouble is not found in the gearset, it will be well to examine the clutch to make sure that the driven member attached to the gearset main shaft does not "spin" or continue to revolve after the foot pedal is depressed.

Faults in Chain- and Shaft-Driving Systems.—While power transmission by chains is not as common at the present time in pleasure-car practice as it has been in the past, side-chain drive is used to considerable advantage in motor-truck work so the following hints on chain care and adjustment will prove timely. Much of the trouble experienced when chain drive is employed can be traced to faulty design as a basis. The teeth of the sprockets may not be properly shaped and may not be of the form best adapted for the chain designed to run over them. As most chains are exposed and run without a covering of any kind, the action of the road dust and gravel is to combine with the grease often rubbed on the outside on the pretext of oiling the chain and form an abrasive that will produce rapid wear between chain and sprocket and the various links of which the chain is composed.

To obtain the best results from chain drive the chains must be maintained in correct adjustment by the radius rods provided for the purpose. If a chain is allowed to run too loose it will "whip" and is liable to climb the teeth of the sprocket. If the chain is adjusted too tight, there will be a strain on all parts and it is liable to "snap" when it leaves the sprocket, especially if the teeth are worn hook shape. A safe rule to remember when adjusting chains is to have them tight enough so that it is not possible to raise it from the first tooth with which it meshes on either sprocket, even with the aid of a lever such as large screw driver or tire iron.

Chains must be kept clean and properly oiled. The best method of removing the dirt is to take the chain off the sprockets and let it soak long enough in a large pan containing kerosene so all the dirt and gummed oil is removed thoroughly from all the interior bearing surfaces. It should be gone over thoroughly with a stiff bristle brush until each link works freely. The chain is then immersed in a pan of gasoline to remove any small particles of grit that the kerosene may have failed to dissolve. After the gasoline bath it is wiped with a clean cloth until it is dry and clean. The proper method of chain lubrication is not generally understood and in many instances it is accomplished by coating the outside of the chain with a graphite-

grease combination that serves no useful purpose, and acts merely as a collecting agent for dust and grit. The proper method of chain oiling is by immersing the cleaned chain in a molten mixture of tallow or mineral grease and graphite. The entire chain is immersed in this mixture, which is kept hot so it will penetrate all the minute interstices of the chain links and produce a thin coating of lubricant at all the working surfaces. The chain is removed from the bath of lubricant and while still hot all surplus oil is wiped off until the outside of the chain is dry and clean. This method insures proper lubrication of the many small joints usually neglected and should be done every thousand miles.

But little trouble is experienced with shaft-driving systems because the driving gearing and universal joints are so well enclosed on modern axles. The bevel-driving gears are packed in lubricant as a rule, and but little wear is noted, even after several seasons of use. An important point to observe with all forms of axles is to make sure that the antifriction bearings are kept properly cleaned and oiled. The oil used should contain no acid and should be of the best quality. Care should be taken in washing the car so that water will be prevented from entering the bearing points. If the bevel gears of the rear axle grind it is due to improper adjustment or excessive wear between the teeth. Grinding sounds usually result from meshing the gears too deeply, while loose adjustment is manifested by rattling.

Care of Front Axles and Steering Connections.—The wheels of front axles, especially on the lighter runabouts fitted with ball bearings of the pressed steel cup and adjustable cone type, should be carefully examined from time to time. As a general rule, the wear upon the cones of such bearings is rapid because of the stresses obtaining at this point. It is well to jack up the axle from time to time and turn the wheels by hand to insure that they turn freely, and to move them to see if there is any play or lost motion that would indicate either wear or poor adjustment of the bearings. When examined the balls should be perfectly round and smooth and the cones and races should have unbroken surfaces. Care should be taken in adjusting the cone so the wheels turn freely and yet they should be tight enough so no play will exist between the front wheel and the bearings. If the cones are adjusted up too tight the balls will be wedged in such a way that they will soon cut into the race ways. As a general rule, annular ball bearings will need but little attention. The steering knuckles should be looked over to see that the spindle bolts are right, and the various joints of the drag link and tiebar should be carefully

examined for any lost motion. It is desirable to encase all the small joints forming part of the steering system in small leather bags packed with lubricant, because if these joints are kept well oiled and protected from grit there will be but little wear at those points.

Adjustment of Brakes.—The means of adjusting brakes may be easily ascertained by inspection. If brakes do not hold properly and the friction facing is in good condition and free from oil, the failure to grip the drum is probably due to wear in the operating leverage. On some form of brakes, notably those which are expanded by a toggle joint or cam motion, compensation for wear of the brake shoes is often made by shortening the rods running from the brake to the operating lever. External brakes are usually provided with an adjustment on the brake band, which permits one to draw the ends of the band closer together and take up much of the lost motion between the band and the brake drum. When adjusting brakes it is necessary to make the adjustment so the brakes will take hold together. If one member is adjusted so that it will grip its drum before the other does, there will be considerable strain on the tires and a tendency to side slipping every time the brakes are applied. After the brakes are adjusted it is well to jack up the axle to make sure that the wheels turn freely and that there is no binding between the brake members and the drums on the hubs. If the brakes are adjusted too tightly the friction will cause heat after the car has been run a short distance, and this increase in temperature is a very good indication of power loss by friction between the brake and the drum. If the brakes are not adjusted sufficiently tight a full movement of the pedal or hand lever will prove inadequate to apply the brakes tight enough to stop rotation of the wheels. The bearings used in rear wheels are usually of the nonadjustable antifriction types and require practically no attention except to keep them properly oiled and cleaned.

Care of Miscellaneous Chassis Components.—A common trouble with all types of motor-car frames is that after a period of use they may sag down at the center. This condition may produce difficulty in clutch shifting or gear actuation because it may cause cramping or binding of the operating mechanism. A sagging frame is usually strengthened and brought back into place by a strut rod and turn buckle arrangement which may be installed under the defective member by any competent mechanic. The various frame members sometimes become loose owing to the play in the rivets caused by the frame distortions. Another point of importance is lost motion in spring hangers and shackles and often the bolts passing through the spring eye and the shackle links may be found worn half through if in-

spected after a season's use. On many cars no provision has been made for lubricating these points and the deterioration produces squeaking and rattles when the car is operated over rough roads. If the spring action is harsh and if these members squeak the spring leaves should be pried apart after the spring clips have been loosened a trifle and oil introduced between the leaves.

Back lash in the steering mechanism is often a source of annoyance to motorists, but if it is present only in the reduction gears at the bottom of the steering posts it is not a serious defect. On some types of worm and worm-wheel gears the worm-wheel shaft is provided with eccentric bushings and a certain amount of wear may be taken up by turning these so that the gear teeth are brought into closer relation. In cases where the control-lever rods go down through the center of the steering column accumulations of rust will sometimes cause stiff action. This condition is easily remedied by removing the rod and surrounding tube member, cleaning out the rust, and putting the parts back after they have been thoroughly oiled.

The suggestions given in this chapter and the preceding one should prove of value to all motorists by assisting them in securing a knowledge of the more common troubles incidental to motor-car operation. The general suggestions given cannot be considered applying to any specific case because they are so general in character, and obviously the differences in construction of the various cars will have to be taken into consideration in attempting to apply the suggestions given advantageously. Enough of the ordinary defects have been mentioned so that almost any ordinary derangement can be located and remedied.

Maintenance of Body and Upholstery.—Many motorists are at loss to understand the reason for quick deterioration of the brightly varnished surfaces of a motor-car body that has been in use for some time. The paint may be blistered or cracked or the finish may be spotted at various points. Bodies that were formerly black will assume a bluish tinge and bright varnish will soon become dull. If the car is an expensive one, the motorist is justified in expecting a degree of finish that will endure, but those who purchase cheaper cars must expect to lose the bright finish after the car has been used for a time. Where cars are manufactured in large quantities, the varnish is often applied before some of the under coats are thoroughly dried, and the result will be a series of blisters. Another result of hasty manufacture and of putting the car in service soon after painting is spotting. This is produced by dry mud which extracts some of the oil or gum from the varnish and may often be caused by actual chemical action of

alkaline mud. The mud of city streets, especially at points where there is a great deal of animal traffic, is highly charged with ammonia, and in certain clay or lime districts the mud is very destructive to the varnish luster.

Even when a car has been properly varnished and finished there are many conditions for which the motorist is directly or indirectly to blame which will ruin even the highest grade of paint and varnish. For instance, when cars are cleaned at garages various soaps and washing compounds are used which contain alkaline materials to assist in removing dirt and oil but which are very destructive to the highly finished, varnished surfaces. Most of the soaps upon the market contain ingredients which have a chemical action on the oils of paint and causes it to deteriorate. There are soaps which do not damage painted surfaces, but these are usually more costly and require more care and labor to remove the dirt accumulation so they are not apt to be generally used. The grades of soap that act the quickest in cutting grease are those that will more quickly dull the surfaces of the body.

Some very good carriage painters go so far as advising that no soap be used on finely varnished surfaces. Some painters advise against dusting off a car and claim that accumulations of this substance should be removed from the surface by washing. It is contended that wiping off the dust will have the effect of scratching the varnished surfaces and that the best method of removing either dust, mud, or dirt, is to flush the surfaces with water from a hose. After as much of the dirt has been removed by this method as possible a sponge may be used, but care must be taken that no grit is permitted to collect beneath the sponge and that the stream of water from the hose be always kept at work ahead of the sponge.

If any grease is present on the running gear it should be removed with gasoline or benzene, and while these substances may deaden the varnished surfaces temporarily the blemish will not remain if the dull varnish is polished with a clean soft cloth wet with linseed oil. The finish of many automobiles is ruined by allowing accumulations of oil or asphalt from freshly tarred or oiled roads to remain on the body work. These substances should not be allowed to remain any longer than possible, and if the oil or asphalt has become hardened, it may be dissolved by using naphtha, vaseline, or even butter. After the oily accumulations have been dissolved the car should be very carefully washed to remove all traces of the oily mud or the solvents.

Of course there are portions of the car where it is difficult to have the paint stay in good condition. The paint is often burned off that part of the hood on a gasoline machine adjacent the exhaust pipe or

on those portions of the hood of a steam car which cover the boiler or burner. Any part of the hood subjected to considerable heat will become discolored after a time and if the heat is intense the paint will burn and blister. If care is taken to keep the body properly washed by using only the best grade of carriage soap obtainable and only clean water, sponges, and chamois cloths, the body finish will be preserved for a much longer time than if washing is neglected and the mud or dirt allowed to dry on the varnished surfaces. The use of quick-acting soaps should be avoided as much as possible and tar or oil accumulations should be removed as soon as conditions will permit. If a car is kept in a barn or shed housing horses or cattle, or adjacent to a stable the fumes of ammonia will soon cause deterioration of the paint and varnish. One should never touch dusty surfaces with the hands or attempt to remove the dust by brushing off with a cloth. As a general rule, an automobile body will need to be gone over every season. The first year that the car is in use the paint should be in good enough condition, if proper attention has been paid to washing, so that a coat of varnish will suffice to restore the body to its pristine brilliancy. A car that has been used more than one season will need both painting and varnishing to make a good job.

The matter of cleaning and caring for tops and upholstery is also one that should be considered to some extent. Mohair tops are usually fitted to high-grade cars, leather to medium-priced cars, and imitation leather or pantosote on the cheaper cars. In cleaning mohair tops, it is necessary to remove not only dust and dirt but particles of grease or oily matter thrown up against it by the wheels from either the road surface or portions of the mechanism. Dust should be removed with a moist sponge, while grease or oil stains can be taken off by a sponge and good soapsuds. Leather and imitation-leather tops should be treated with some form of preservative. Some dressings may be purchased all ready mixed and may be applied by the motorist himself. Others may be prepared at very little expense. Shabby leather may be made to look brighter by rubbing over the surface with either linseed oil or the well-beaten white of an egg mixed with a little black ink. Before applying any type of dressing, it is advised to go over the surface with neatsfoot oil until it has been properly softened, and often the oil treatment will be sufficient for all practical purposes.

The following recipe is given as a good preservative for leather. It is composed of six parts of spermaceti, eighteen parts of beeswax, five parts of asphalt varnish, five parts black vine twig, two parts Prussian blue, one part nitrobenzol, one part powdered borax, and

sixty-six parts oil of turpentine. The wax is melted and the borax is added, after which the mixture is stirred until a jellylike mass is formed. In another pan the spermaceti is melted, the varnish which has been previously mixed with turpentine is added, and the mass stirred well and added to wax mixture in the other vessel. The color is the last ingredient added, this having been previously rubbed smooth with a little of the mixture. The material is applied with a brush about once a week in small quantities and is wiped well with a soft cloth to polish after application.

Another formula for giving new life to leather tops or upholstery is given as follows:

Ground Ruby Shellac	2.25 parts
Dark Resin	.91 parts
Sandaric	.115 parts
Gum Resin	.115 parts
Aniline Black (Spirit Soluble)	.115 parts
Lamp Black	.115 parts
Wood Alcohol	22.50 parts

The first step in preparing this mixture is to dissolve the sandaric, dark resin, gum resin, and shellac in the alcohol; next the aniline black is added and finally the lamp black, which has been ground to a paste with a little of the liquid, is mixed in. After the whole has been thoroughly mixed it is filtered. This is applied to the top or upholstery with a brush and is polished with a soft cloth or brush.

On genuine leather tops, upholstery, and for the leather straps holding the top a good grade of harness oil is often sufficient. The following will be found an effective mixture:

Oil of Turpentine	2 ozs.
Lamp Black	½ oz.
Neatsfoot oil	10 ozs.
Vaseline	4 ozs.

The lamp black is mixed with the turpentine and the neatsfoot oil, and the vaseline is thinned by heating it, and the ingredients are mixed by shaking together. When the mixture cools it will be in the form of a grease or paste which is rubbed well into the leather to be preserved or softened.

If a car has been used on a wet or stormy day the top should be kept up until it is thoroughly dry, as if it is inserted in the top case or folded while wet the lining might mildew or rot. In folding tops

care should be taken to have the folds even and to have as few wrinkles as possible. The various bows comprising the framework of the top should be separated by small rubber pads and the whole firmly strapped together by leather bands applied at each side of the folded top frame to prevent rattle.

Upholstery is usually preserved by slip covers of various grades of cloth applied to the cushions and to the backs of the seats. As most cushions and seat backs are upholstered with leather or the various fabrics imitating it, the same dressings that have been recommended for tops may be used to advantage in treating the cushions and seat backs. In some of the higher-priced cars, especially of the closed-body form, various grades of broadcloth, Bedford cord, or other textile fabrics are used. When these become dirty they must be treated very carefully and by an experienced cleaner because ordinary methods of removing grease spots will cause unsightly discolorations of the fine fabrics. Where high-grade upholstering materials are used slip covers are really necessary. These should be kept in place at all times that the passengers are in ordinary street or business dress, but may be removed and the clean upholstering used at such times that it is desirable not to dirty the clothing as when evening clothes are worn. If the cushions or seat backs are torn, or otherwise damaged, restoration can only be made by an upholsterer or carriage trimmer. Whenever any of the preservative dressings are applied to the upholstery, it is well to wipe off all traces of the dressing very carefully in order that it will not soil the clothing.

How to Keep the Hands Soft.—The mechanism of an automobile is very dirty and the fact that this grime is very hard to remove from the hands often deters motorists from making necessary adjustments. It is not difficult to keep the hands soft and to remove dirt or grease accumulations if proper precautions are taken before the work is started. The first operation is to coat the hands thoroughly with a fine soft-soap paste and rub it thoroughly into the pores of the skin and under the finger nails before starting in to work. After a little rubbing the soap is absorbed by the pores and apparently disappears. When the repairs are completed the hands are dipped in water and a little powdered pumice stone or sawdust soaked in kerosene oil is rubbed in thoroughly until the soap is brought to a lather. The hands are then washed in the ordinary manner and the dirty soap removed from under the finger nails. As the pores are filled with soap they cannot fill with dirt and the protecting influence of the soap under the nails keeps out the dirt, which cannot collect at points where it is not readily accessible. Bran or sawdust moistened in kerosene and

used in connection with ordinary soap is very good to remove the dirt without injuring the hands. Various grades of prepared hand soap may be obtained on the market but most of these contain ingredients which injure the skin. Strong alkalies are used in many cases to remove the dirt and such compounds should not be used if they discolor the can in which they are sold. Any substance that will have a strong enough chemical action on metal to corrode it is not fit to be used on the skin.

A Few Words of Caution in Conclusion.—In order to obtain the best results from an automobile it is imperative that the owner familiarize himself with all the details of its operation unless he is sufficiently wealthy to hire help to drive and look after the car. All car owners who expect to look after their own machines must first acquire a knowledge of all details of the oiling system and the various points of the chassis that require oiling. More machines wear out because of lack of proper attention to lubrication than because of the amount of work done, as present designs of modern automobile parts are thoroughly reliable and can be depended on to give satisfactory service for many thousand miles without mechanical deterioration. These results can only be obtained if care is taken to keep every moving part clean and properly lubricated.

The rules given for the proper care of tires should be followed to the letter because the item of tire maintenance is one of the most costly of all the expenses incidental to motor-car operation. Careful driving and the judicious control of the car will do much toward maintaining efficiency of the mechanism and it is well to remember that more harm can be done to the various chassis parts by a fast run of a few hundred miles than will result from thousands of miles of slower driving. It is well to drive cautiously at all times and to remember that other users of the highways have rights that must be respected. When operating a car on rough roads the speed should always be reduced to a low point, and usually the comfort of the passengers will provide the best indication of whether the car is being operated at the proper speed or not.

As soon as any parts are defective and repairs are necessary that cannot be made by the motorist himself the work of restoration should be given to a competent mechanic even if his charges are higher than those having less experience. At the end of every active riding season and before the inception of the new period of service the car should be thoroughly overhauled, and one who is able to appreciate the value of this work of restoration and who takes care of the mechanism always has a machine that is in good running order and that will give satis-

factory service. Many motorists are short-sighted because they neglect the mechanism and run the machine as long as it will hold together. As a rule, these are the pessimists who hold that automobiles are an unreliable and costly possession.

Note.—More complete instructions on car driving and maintenance, as well as the control systems of all the latest cars, can be found in "How to Run an Automobile," by Pagé. Price, $1.00. The Norman W. Henley Publishing Company, 2 West 45th Street, New York City.

INDEX

A

Accessories for Running Board, 939.
Accessories for Winter Comfort, 938.
Acetylene Gas, Compressed, 929.
Acetylene Gas Generator, 927.
Acetylene Gas Lighting, 926.
Ackerman Type Axle, 743.
Action of Entz Electric Transmission, 703.
Actual Duration of Cycle Functions, 135.
Actuation of Ring Valves, 283.
Adjustable Brake and Clutch Pedals, 735.
Advancing the Spark, 960.
Advantages of Rear Location of Tank, 366.
Agricultural Automobiles, 84.
Air, Chemical Composition, 358.
Air Cleaner, 45.
Air Cooled Engine Design, 623.
Air Cooled Two-Cycle Engine, 626.
Air Cooling, 606.
Air Cooling Advantages, 629.
Air Cooling, Auxiliary Exhaust Valves Assist, 624.
Air Cooling, by Convection, 606.
Air Cooling, Newton's Law, 623.
Air Cooling, by Radiation, 606.
Air Cooling, Simple Method of, 622.
Air Currents, Flow of, 37.
Air Flow About Poor Body Design, 37.
Air Flow Around Good Body Design, 38.
Air Jackets for Cooling, 626.
Air Lock System of Oil Supply, 592.
Air Needed to Burn Gasoline, 358.
Air Pressure of Tires, 875.
Air Resistance, Factors Governing, 35.
Air Resistance, Influence of Speed, 37.
Air Resistance, Power Needed to Overcome, 36.
Air Starters for Engines, 885.
Air Stove, Utility of, 370.
Air-Valves for Carburetors, 387.
Air, Weight of, 358.
Alarm Signals, 934.
Alcohol, Advantages of, 352.
Alcohol-Benzol Fuel, 355.
Alcohol, Glycerine and Water Solutions, 980.
Alcohol, Compared with Gasoline, 353.
Alcohol, Disadvantages of, 355.
Alcohol Engines, Compression of, 353.
Alcohol, Engines for Using, 353.
Alcohol, Fire Risk of, 354.
Alcohol as Fuel, 352.
Alcohol, Production of, 353.
Alcohol, Taylor-White Process of Using, 353.
Alcohol-Water Solutions, 979.
Aluminum Cylinders, 312.
Aluminum Pistons, 312.
Ambulance Body, Convertible, 100.
Ampere, Definition of, 489.
Anti-freezing Solutions, 979.
Anti-Friction Bearing Classes, 824.
Anti-skid Chains, 853.
Anti-skid Tire Treads, 849.
Applying Non-skid Chains, 853.
Armature Speed for Various Magneto Forms, 542.
Armored Automobile, Mack 2 Ton, 94.
Armored Automobiles, 92.
Armored Car Parts, Weight of, 96.
Artillery Type Wheel, 831.
Assembling Typical Chassis, 28.
Atwater-Kent Ignition System, 522.

Auto-Lite Starting System, 896.
Automatic Spark Advance, Delco, 525.
Automatic Spark Advance in Magneto, 567.
Automobile Ambulance, 100.
Automobiles, Armored, 92.
Automobile Brakes, Utility of, 809.
Automobile Body, Washing, 1006.
Automobile Chassis, Modern Design, 730.
Automobile Chassis, Parts of, 711.
Automobile Components, Important, 18.
Automobile Control Systems, 970.
Automobile Design, Tendency in, 18.
Automobile Design, Variation in, 111.
Automobile, Division into Groups, 20.
Automobile Driving, Rules for, 977.
Automobile, for Emergency War Work, 96.
Automobile, Gasoline-Electric, 102.
Automobiles, How Steered, 742.
Automobile Parts, Function of, 22.
Automobile Parts, How Arrangement Varies, 22.
Automobile Plow, 91.
Automobile Power Transmission System, 633.
Automobile Steering Gears, 744.
Automobile Tires, Forms of, 840.
Automobile Trucks, Repair Shops on, 96.
Automobile Types, Classification of, 41.
Automobile Wheels, Wooden, 830.
Automobiles, Winter Care of, 978.
Automobile, Wood's Dual Power, 102.
Auxiliary Exhaust Valves Assist Cooling, 624.
Auxiliary Spark Gap, 514.
Auxiliary Springs, 932.
Auxiliary Air Valve, Ball and Reed Type, 388.
Auxiliary Air Valve Forms, 387.
Auxiliary Air Valves, Poppet Type, 388.
Axles Without Differential, 786.

B

Ball and Ball Two Stage Carburetor, 428.
Ball Bearings, 825.
Ball Bearing Connecting Rod, 316.
Ball Bearing Crankshaft, 330.
Ball Bearings, Method of Mounting on Crankshaft, 331.
Ball and Roller Bearings, 822.
Barrel Type Crankcase, 343.
Battery Ignition Systems Distributor and Single Coil, 519.
Battery Ignition Systems, Four Point Timer, 518.
Bennet Kerosene Carburetor, 451.
Benzol, Production of, 351.
Benzol, Properties of, 351.
Bevel Drive Gearing, Skew, 792.
Bi-Fuel Carburetor, 449.
Block Castings, 218.
Blowing Back, Cause of, 292.
Blow-out, How to Repair, 878.
Body Design, Dimensions Needed, 57.
Body Design, Double Cowl, 50.
Body Design, Four Passenger Roadster, 52.
Body Designs, New, 53.
Body Designs, Standard, 47.
Body Design and Wind Resistance, 32.
Body, Maintenance of, 1005.
Body Type Definitions, Berline, 47.
Body Type Definitions, Brougham, 47.
Body Type Definitions, Convertible Sedan, 47.
Body Type Definitions, Convertible Touring Car, 47.
Body Type Definitions, Clover Leaf, 47.
Body Type Definitions, Coupé, 47.
Body Type Definitions, Coupélet, 47.
Body Type Definitions, Landaulet, 47.
Body Type Definitions, Limousine, 47.
Body Type Definitions, Open Limousine, 47.
Body Type Definitions, Open Sedan, 47.
Body Type Definitions, Roadster, 47.
Body Type Definitions, Salon, 47.

Body Type Definitions, Sedan, 47.
Body Type Definitions, Touring Car, 47.
Bore and Stroke Ratio, 227.
Borg and Beck Clutch, 648.
Brake Control and Equalizing Members, 734.
Brake, Friction Shoe Type, 810.
Brake, Knox Hydraulic, 822.
Brake, Vacuum Operated, 820.
Brakes, Adjustment of, 816.
Brakes, Adjustment and Care of, 1004.
Brakes for Automobiles, 809.
Brakes, Front, 817.
Brakes, How Installed, 813.
Brakes, Multiple Disc, 815.
Breeze Automatic Carburetor, 405.
Brush Eight Cylinder Engine, 241.
Brush Runabout Engine, 128.
Brush Spring Suspension, 724.
Brush Type Automobile Frame, 715.
Bubbling Type Carburetor, 374.
Buick Light Six Power Plant, 197.
Built Up Crankshaft, 325.
Built Up Steel Cylinders, 346.
Bulbs, Types of, 913.
Bumpers, Utility of, 933.
Butt Joint Ring, 310.

C

Cadillac Eight Cylinder Engine, 155.
Calcium Chloride Solutions, 979.
Cam Followers, 251.
Cam Forms, 251.
Cam, How it Lifts Valve, 249.
Cam for Quick Lift, 249.
Camphor Carburetor, 457.
Camshaft Case, Removable, 255.
Camshaft Drive by Gears, 256.
Camshaft Driving Methods, 256.
Camshaft Drive by Silent Chains, 256.
Cams, Drum Type for Valve Actuation, 263.
Camshaft Forms, 320.
Camshaft, Overhead, 259.
Cams, Valve Lifting, 249.
Cantilever Springs, Installation of, 722.
Cantilever Springs, 721.
Carbon Cone Valve, 281.
Carburetion Principles Outlined, 357.
Carburetor, Automatic Compensation in, 381.
Carburetor and Fuel System Troubles, 992.
Carburetors, Auxiliary Air Valves for, 387.
Carburetor Ball and Ball Two Stage, 328.
Carburetor, Bennet Kerosene, 451.
Carburetor, Bi-Fuel, 449.
Carburetor, Breeze Automatic, 405.
Carburetor, Bubbling Type, 374.
Carburetor, Camphor, 457.
Carrying Capacity of Tires, 874.
Carburetor, Claudel, 415.
Carburetor, Compound Nozzle Zenith, 408.
Carburetor, Concentric Float Type, 381.
Carburetors, Construction of Modern, 392.
Carburetor, Cork Float for, 384.
Carburetor, Elements of Design, 381.
Carburetor, Fiat, 422.
Carburetor, Filtering Type, 376.
Carburetor, Float Bowl Design in, 384.
Carburetor Float, Cork, 384.
Carburetor Float Feed, 378.
Carburetor, Float Mechanism for, 385.
Carburetor Floats, Sheet Metal, 384.
Carburetor, Ford, 396.
Carburetor, G. and A. Automatic, 401.
Carburetor, Gas Supply Regulation in, 388.
Carburetor, Gasoline Spray Nozzle for, 386.
Carburetor, Good Kerosene, 453.
Carburetor, Holley, 397.
Carburetor, Holley Kerosene, 445.
Carburetors, Kerosene, 437.
Carburetor, Kerosene Type, 444.

Carburetor, Kingston, 395.
Carburetor, Krice Angular Spray, 432.
Carburetor, Marvel-Buick, 429.
Carburetor, Master Multiple Jet, 434.
Carburetor, Maybach's Early Design, 379.
Carburetor, Mercedes, 401.
Carburetor Mixing Chamber Forms, 383.
Carburetor, Multiple Nozzle Forms, 420.
Carburetor, Partial Combustion Type, 455.
Carburetor, Peerless Early Type, 403.
Carburetor, Pierce Automatic, 401.
Carburetor, Rayfield Mixed Type, 418.
Carburetor, Saurer Economy, 423.
Carburetor, Schebler Metering Pin Type, 395.
Carburetor, Schebler Water Attachment for, 450.
Carburetor, Schebler, Simple Type, 393.
Carburetor, Scott-Robinson, 417.
Carburetor, Sheet Metal Floats for, 382.
Carburetor, Simple Mixing Valve Type, 377.
Carburetors, Spraying Type, 376.
Carburetor, Stewart Metering Pin, 416.
Carburetor, Stromberg One Nozzle Type, 405.
Carburetors, Stromberg Two Jet Type, 421.
Carburetor, Stromberg Type M. B., 413.
Carburetor, Sunderman, 427.
Carburetor, Tillotson Two Jet, 425.
Carburetor, Use of Throttle, 388.
Carburetor, Using Water Spray, 444.
Carburetor, Venturi Type Mixing Chambers, 382.
Carburetor, What It Should Do, 359.
Carburetor, Wick Type, 374.
Carburetor, Zenith Duplex, 412.
Car Lifting Jacks, 950.
Care of Automobile Tops, 1007.
Care of Automobiles, Winter, 978.
Care of Body and Upholstery, 1005.
Care of Brakes, 1004.
Care of Dynamo and Motors, 923.
Care of Front Axle, 1003.
Care of Storage Battery, 920.
Care of Tires, Rules for, 881.
Carter Diaphragm Fuel Supply System, 372.
Carter Diaphragm Pump, 373.
Case, Three-Quarter Floating Axle, 774.
Casing for Chain, 798.
Castor Oil for Lubrication, 575.
Causes of Engine Stop, 987.
Center of Gravity, Placing, 20.
Centrifugal Governor for Gas Regulation, 389.
Centrifugal Water Pump, 611.
Chain Driving Method, 798.
Chains, Care of Driving, 1002.
Chains, Non-skid, 853.
Change Speed Gearing, Installation of, 681.
Change Speed Gearing Derangements, 1000.
Change Speed Gearing, Dodge, 677.
Change Speed Gearing, Marmon, 674.
Change Speed Gearing, Individual Clutch Type, 665.
Change Speed Gearing, Sliding Gear, 669.
Change Speed Gearing, White, 672.
Change Speed Gearing for Four Wheel Drive, 688.
Change Speed Gearing, Why Needed, 654.
Change Speed Gears, Planetary, 659.
Change Speed Gears, Friction, 655.
Chart for Tractive Force, 106.
Chassis Frame Construction, 713.
Chassis, Oakland Model 34, 731.
Chassis Oiling, 752.
Chassis Overloading, Evils of, 736.
Chassis, Packard Truck, 733.
Chassis Parts, 711.
Chassis Parts, Care of Miscellaneous, 1004.
Chassis Parts, Lubricant for, 750.
Chassis Parts, Relation of, 32.

Chassis Simplified by Hotchkiss Drive, 732.
Chassis, Steps in Assembling, 28.
Chassis Underslung, 712.
Chassis, 1917 Pathfinder, 730.
Chemical Current Producers, Disadvantages of, 492.
Chemical Current Producers, Storage Battery, 490.
Church Fuel Feed System, 370.
Classification of Motor Car Types, 41.
Claudel Carburetor, 415.
Cleaning Dirt from Shoes, 939.
Clutch, All Metal Discs, 651.
Clutch and Brake Pedal Design, 735.
Clutch and Gearset Assembly, 671.
Clutch, Borg and Beck Three Plate, 648.
Clutch, Cause of Slipping, 999.
Clutch Cone, Attachment of Leather, 641.
Clutch, Conventional Cone, 638.
Clutch, Franklin, 653.
Clutch, Friction, 635.
Clutch, Function of, 633.
Clutch, Gradual Engagement Cone Type, 643.
Clutch, Harsh Acting, 999.
Clutch, How it Transmits Power, 636.
Clutch, Inverted Cone, 641.
Clutch, Knox Three Plate, 646.
Clutch, Premier Multiple Disc, 653.
Clutch, Why It is Needed, 633.
Clutches, Cone, 637.
Clutches, Cone Type in Oil, 642.
Clutches, Cork Inserts for, 637.
Clutches, Defects in, 998.
Clutches, Design Considerations of Cone Type, 645.
Clutches, Five Plate, 649.
Clutches, Forms of, 635.
Clutches, Friction Facings for, 637.
Clutches, Magnetic-Centrifugal, 705.
Clutches, Materials Used in, 637.
Clutches, Multiple Disc, 650.
Clutches Not Needed on Steam or Electric Cars, 634.
Clutches, Requirements of, 635.
Clutches, Three Plate, 646.
Coil Vibrator, Use of, 507.
Cole Eight Fuel Tank Location, 361.
Combination Cushion Tires, 859.
Combination Gasoline-Electric Drive, 691.
Combination Piston and Sleeve Valve Action, 275.
Combined Bevel and Spur Gear Axle, 799.
Combustion Chamber Design, 226.
Comparison of Design Practice, 111.
Competitive Records, 1909 to 1916, 113.
Composite Axle Forms, 769.
Compound Distributors, 570.
Compound Manifolds, 439.
Compound Piston Rings, 311.
Compressed Air Starters, 885.
Compression of Alcohol Engines, 353.
Compression Stroke, Why Needed, 125.
Concentric Float and Mixing Chambers, 382.
Concentric Piston Rings, 309.
Concentric Valves, 244.
Cone Clutch Efficiency, 645.
Cone Clutches, 637.
Cone Clutches, Advantages of, 644.
Cone Type Rotary Valves, 280.
Connecting Rod, Function of, 123.
Connection Rod, Hinged Cap Type, 316.
Connecticut Ignition System, 530.
Connecticut Timer-Distributor, 532.
Connecting Rod, Ball Bearing, 316.
Connecting Rod Forms, 315.
Connecting Rod, Marine Type, 316.
Connecting Rod, Master, 320.
Connecting Rod, One Piece, 316.
Connecting Rod Shims, 318.
Connecting Rods, Fork and Blade Type, 319.
Connecting Rods for V Engines, 319.
Connecting Rods, Side by Side, 320.
Constant Pressure Cycle Engine, 209.
Construction of Flywheel, 336.
Construction of Pistons, 304.
Control Devices for Starter System, 895.

Control of Friction Transmission, 963.
Control of Planetary Gearset, 964.
Control System, Essentials of, 20.
Controlling Speed of Engine, 958.
Conversion Sets, for Ford, 100.
Convertible Ambulance Body, 100.
Convertible Six or Twelve Cylinder Engine, 978.
Cooling Action of Radiator, 609.
Cooling by Air Jackets, 626.
Cooling by Positive Water Circulation, 606.
Cooling Fan Construction, 618.
Cooling Solutions, Anti-Freezing, 979.
Cooling System Temperature Regulators, 620.
Cooling System Troubles, 994.
Cooling Systems Generally Used, 606.
Cooling Systems, Why Necessary, 604.
Cord Tires, 845.
Cork Float, 384.
Counter-Weighted Crankshafts, 332.
Couple-Gear Drive Wheel, 700.
Couple-Gear Gas-Electric Drive, 697.
Cowl Tank for Fuel, 361.
Crankcase, Barrel Type, 343.
Crankcase Construction, 342.
Crankcase, Horizontally Divided, 344.
Crankcase, Vertically Divided, 345.
Crankshaft Ball Bearings, 330.
Crankshaft, Built Up, 325.
Crankshaft Counter-Weighted, 332.
Crankshaft, Four Cylinder, Five Bearings, 327.
Crankshaft, Four Cylinder, Three Bearing, 327.
Crankshaft, Function of, 123.
Crankshaft, Hudson Super-Six, 332.
Crankshaft, Six Cylinder, 325.
Crankshaft, Six Cylinder, Four Bearings, 328.
Crankshaft, Six Cylinder, Seven Bearing, 328.
Crankshaft, Two Bearings, 330.
Crankshaft, Two Cylinder, 327.
Crankshaft Types, 324.
Crankshafts, Materials Used in, 324.
Crankshafts, Method of Manufacture, 324.
Current Generation by Dry Cells, 486.
Current Generation by Storage Battery, 490.
Current Generator, Simple Chemical, 485.
Current Production by Chemical Action, 484.
Cushion Tire, Combination, 859.
Cushion Tires, 857.
Cutout Valve, Utility of, 478.
Cyclecar Engines, 202.
Cyclecars, Auto-Carriers, 78.
Cyclecars, Baby Peugeot, 78.
Cyclecars, Bedelia, 79.
Cyclecars, De Cross, 79.
Cyclecars, Humber, 78.
Cyclecars and Light Cars, 78.
Cyclecars, Marlborough, 78.
Cyclecars, Narrow Tread, 81.
Cyclecars, Pilot, 81.
Cylinder Blocks, Aluminum, 312.
Cylinder Castings, Influence of Crankshaft Design, 225.
Cylinder Construction, Influence of Engine Design, 232.
Cylinder Construction Methods, 217.
Cylinder, Function of, 123.
Cylinder Head, I Form, 237.
Cylinder Head, L Form, 239.
Cylinder Head, T Form, 235.
Cylinder Head, Knox Design, 240.
Cylinder with Removable Head, 219.
Cylinders, Advantage of Off-set, 230.
Cylinders, Cast in Blocks, 218.
Cylinders, Individually Cast, 217.
Cylinders with Water Jackets Integral, 221.

D

Dampening Spring Action, 932.
Darracq Rotary Valve Motor, 286.
Delco Electric Starting System, 898.
Delco Generator Construction, 907.
Delco Ignition System, 524.
Delco Timer with Automatic Spark Advance, 525.

Delco Timer-Distributor, 503.
Delco Timer for Twin Six Engine, 525.
Demountable Rims, 854.
Demountable Rim, How to Remove, 872.
Demountable Rims, Removing, 857.
Demountable Rim, Replacing, 872.
Demountable Steel Disc Wheels, 833.
Depolarizer, Why Used, 486.
Derangements of Change Speed Gearing, 1000.
Depreciation of Tires, 877.
Designing Fundamentals, 19.
Design Fundamentals, Tractor, 85.
Design Practice, Automobile, 111.
Detachable Rims, 855.
Detachable Tops for Open Cars, 49.
Details of Knight Engine, 145.
Determination of Tractive Force, 106.
Devices for Supplying Oil, 582.
Diagonal Cut Joint, Piston Ring, 311.
Diagram, Four Cycle Action, 124.
Diagrams, Typical Valve Timing, 296.
Diameter of Flywheel, Factors Restricting, 339.
Diesel Engine Action, 207.
Diesel Engine for Automobile Work, 205.
Diesel Motor, Modified, 208.
Diesel System of Fuel Supply, 467.
Differential Gear, How it Works, 780.
Differential Gear, Substitute, 782.
Differential Gear, Why Used, 779.
Differential Locks, Advantages of, 795.
Differential Locks, How They Work, 795.
Differential Piston, 305.
Differential, Positive Drive, 785.
Dimensions of Body, Typical, 57.
Direct Air Cooling Methods, 622.
Direct Drive Axle, Two Speed, 793.
Dirt Track Records, to 1916, 113.
Disc Type Rotary Valve, 278.
Distributors, Compound, 570.
Distributors for Eight and Twelve Cylinder Engines, 571.
Distributor, Secondary, 502.
Dodge Change Speed Gear, 677.
Dodge Fuel System, 362.
Double Chain Drive, 760.
Double Cowl Body Design, 50.
Double Reduction Axles, 765.
Drawbar Pull of Motor Trucks, 105.
Dressings for Tops, 1007.
Drive for Speedometer, 936.
Driving an Automobile, 977.
Driving Chains, Care of, 1002.
Driving Instructions, General, 977.
Driving Systems for Motor Truck, 761.
Drum Cams for Valve Actuation, 263.
Dry Battery Construction, 486.
Dry Cells, Disadvantages of, 489.
Dry Cells, Methods of Wiring, 486.
Dry Cells, Number Needed, 489.
Dry Cell Parts, 486.
Dry Cells, Series Connection, 486.
Dry Cells, Series-Multiple Connection, 487.
Dual Cushion Tires, 858.
Dual Ignition Systems, 563.
Dual Power Car, 102.
Duplex Ignition System, 564.
Dynamo, Action of, 493.
Dynamo, Advantages of, 493.
Dynamo and Motor, Care of Starting, 923.
Dynamo Electric Machines, 493.
Dynamo, How it Generates Current, 495.
Dynamo, Typical Governed, 496.
Dynamo with Timer Integral, 498.

E

Early Vaporizer Forms, 374.
Eccentric Piston Ring, 309.
Eight Cylinder Engine, Why Used, 152.
Eight Cylinder V Engine, 150.
Electric Gearshift, Vulcan, 708.
Electrically Heated Steering Wheel, 938.
Electric Lamps, New, 916.
Electric Lighting Systems, 910.

Electric Starters, Parts of, 890.
Electric Starting Systems, 889.
Electric Starting System, Auto-Lite, 896.
Electric Starting System, Delco, 898.
Electric Starting Systems, Voltage of, 893.
Electric Transmission, Entz, 700.
Electrolyte, Function of, 485.
Elliptic Springs, 719.
Emergency Field Car for War, 96.
Engine Action, Compared to Cannon, 121.
Engine Stoppage Analyzed, 987.
Engines, Air Cooled, 626.
Engines, Amplex Two-cycle, 170.
Engine Base Construction, 342.
Engines, Best Operating Temperature for, 606.
Engines, Blower Cooled, 627.
Engines, Brush Eight Cylinder, 241.
Engine, Brush Runabout, 128.
Engines, Buick Light Six, 197.
Engines, Buick Light Six Sectional View, 216.
Engines, Cadillac Eight Cylinder, 155.
Engines, Cole-Northway Eight, 156.
Engine Cooling Systems, 606.
Engines, Constant Pressure Cycle, 209.
Engine, Convertible Six or Twelve Cylinder, 978.
Engines, Coté Two-cycle, 172.
Engines, Cyclecar, 202.
Engine Cylinders, Steel, 346.
Engines, Darracq Rotary Valve, 286.
Engines, Details Tabulated, 199.
Engines, Diesel, 205.
Engines, Differential Piston Two-Cycle, 168.
Engine, Early Reo, 127.
Engine, Eight Cylinder Vee, 150.
Engine, Elementary Parts of, 123.
Engines, Fischer Slide Valve, 289.
Engines for Alcohol, 353.
Engine, Four-Cycle Action, 122.
Engines, Four-Cylinder Action, 133.
Engines, Forms Generally Used in Automobiles, 118.
Engines, Four-Point Support, 186.
Engines, Franklin Air-Cooled, 215.
Engines, Haynes Light Six, 195.
Engines, Heat Losses in, 606.
Engines, Hewitt Piston Valve, 287.
Engine, How to Start, 956.
Engine, Horizontal One-Cylinder, 128.
Engines, Horsepower Curves of Typical, 198.
Engines, Installation in Trucks, 190.
Engines, Installation of, 187.
Engines, Itala Rotary Valve, 277.
Engines, King Eight-Cylinder, 155.
Engines, Knight Slide Valve, 141.
Engines, Legros Two-Cycle, 171.
Engines, Liquid Fuels for, 349.
Engines, Mead Rotary Valve, 280.
Engines, Miesse Combination Valve, 275.
Engines, Moline Knight, 143.
Engines, Multiple Cylinder, Why Best, 132.
Engines, Noisy Operation of, 995.
Engines, Oakland Light Six, 243.
Engines, Oiling V Type, 601.
Engine, One Vertical Cylinder, 129.
Engine, Operating Principles of, 121.
Engines, Packard Twelve-Cylinder, 157.
Engine Parts, Function of, 140.
Engines, Piston and Rotary Valve Types, 272.
Engine Practice, 1917 Automobile, 191.
Engines, Racing, 192.
Engines, Raynor Two-Cycle, 173.
Engines, Reynolds Rotary Disc Valve, 278.
Engine Starters, Compressed Air, 885.
Engine Speed Control, Methods of, 958.
Engine Starters, Electric, 889.
Engine Starters, Ignition, 884.
Engines, Sheffield-Simplex Details, 231.
Engines, Single Cylinder, 128.
Engines, Six-Cylinder Action, 133.
Engines, Sphinx Ring Valve, 283.
Engines, Stearns-Knight Eight, 149.

Engine Troubles, Hints for Locating, 996.
Engine Troubles, Location of, 988.
Engines, Three-Point Support, 187.
Engines, Three-Port Two-Cycle, 167.
Engines, Two-Cycle Action, 163.
Engines, Two-Cycle Air Cooled, 626.
Engines, Two-Cylinder, 137.
Engines, Two-Cylinder Vertical, 202.
Engines, Two-Cylinder V, Air Cooled, 202.
Engines, Two-Port Two-Cycle, 163.
Engine, Unit Power Plant, 185.
Engines Used in 1917 Automobiles, 199.
Engines, Weidely Twelve-Cylinder, 242.
Engines, Willys-Knight, 142.
Engines, Wisconsin Aviation Type, 260.
Entz Electric Transmission, 700.
Epicyclic Gearing, 659.
Equipment for Tire Repairs, 866.
Exhaust Closing, 293.
Exhaust Gas Silencers, 474.
Exhaust Stroke, What Happens During, 126.
Exhaust Valve, Lead Given, 293.
Exhaust Valve Time, Why Advanced, 292.
Explosion, How it Occurs, 125.
Explosions, Overlap of, 136.

F

Face Friction Gearing, 655.
Factors Determining Flywheel Weight, 337.
Failure of Ignition Systems, 989.
Filtering Type Carburetor, 376.
Fischer Slide Valve Engine, 289.
Five Bearing Crankshaft, 327.
Fiat Carburetor, 422.
Five Plate Clutches, 649.
Float Carburetor, Development of, 378.
Float Mechanism for Carburetor, 385.
Flywheel Design, Typical, 337.
Flywheels, Construction of, 336.
Flywheel Diameter, Factors Restricting, 338.
Flywheel, Fan Blade Type, 339.
Flywheel Flange Retention, 342.
Flywheel, Function of, 123.
Flywheel, Key Retention, 340.
Flywheel, Key and Taper Retention, 341.
Flywheel, Method of Marking, 342.
Flywheels, Retention of, 336.
Flywheel, Rim Marks for Timing, 298.
Flywheel, Solid Webbed Type, 339.
Flywheel, Spoke Type, 339.
Flywheel Weight, Factors Determining, 337.
Focusing Electric Headlight, 915.
Ford Car, How to Drive, 966.
Ford Gasoline Carburetor, 396.
Ford Ignition System, 561.
Ford Magneto, 499.
Ford Model T, Rear Axle, 771.
Ford Planetary Gearing, 663.
Ford Transmission Control, 966.
Ford Truck Conversion Sets, 100.
Formula for Top Dressings, 1007.
Four-Cycle Engine Diagram, 124.
Four-Cylinder Engine Action, 133.
Four-Cylinder Engines, Why Used, 129.
Four-Speed Gear with Direct Drive on Third, 681.
Four-Speed Gear with Direct Drive on Fourth, 680.
Four-Speed Gearset, Locomobile, 674.
Four-Stroke Cycle Engine, 122.
Four-Wheel Drive Repair Truck, 99.
Four-Wheel Drive and Steer System, Jeffery, 801.
Four-Wheel Drive Trucks, 77.
Four-Valve Engines, 265.
Fuel Economizing Devices, 462.
Fuel Feed System, Church, 370.
Fuel, Preheating, 458.
Fuel Mixing Valve, 456.
Fuels, Solid Gasoline, 356.
Fuel Storage, Cowl Tank, 361.
Fuel Supply, Carter System, 372.
Fuel System, Dodge, 362.
Fuel System Faults, 992.

Fuel System, Marmon, 360.
Fuel System, National Roadster, 363.
Fuel System, Packard Twin Six, 364.
Fuel System Pressure Feed, 365.
Fuel Tank Locations Summarized, 366.
Fuel Tank at Rear of Frame, 361.
Full Floating Axle, National, 775.
Full Floating Rear Axle, 770.
Functions of Automobile Parts, 23.
Fundamentals on which Design is Based, 19.
Frame, Brush Type, 715.
Frame Camber, Object of, 714.
Frame Design and Construction, 711.
Frame, Drop, 715.
Frame, Materials Used for, 713.
Frame, Pressed Steel, 715.
Frame Suspension, 716.
Franklin Air Cooled Engine, 215.
Franklin Clutch, 653.
Freezing Points of Cooling Solutions, 980.
Frictional Adhesion, 636.
Friction Clutches, 636.
Friction, Definition of, 573.
Friction Gear Action, 656.
Friction Gearing, 655.
Friction, Reduction of, 574.
Friction Transmission, Control of, 963.
Front Axles, I-Beam, 756.
Front Axles Forms, 755.
Front Axles and Steering Connections, Care of, 1003.
Front Axles, Tubular, 756.
Front Wheel Brakes, 817.
Front Wheel Drive System, 806.

G

G. and A. Automatic Carburetor, 401.
Gas-Electric Drive, Couple Gear, 697.
Gas-Electric Drive, Hoadley, 693.
Gas Lighting System, 926.
Gasoline, Air Needed to Burn, 358.
Gasoline-Electric Car, 102.
Gasoline-Electric Drive, 691.
Gasoline Engine, How it Works, 121.
Gasoline Engines, Self-starters for, 883.
Gasoline, as Fuel, 351.
Gasoline Spray Nozzle, Forms of, 386.
Gasoline Strainers, Types of, 435.
Gas Supply Regulation, Automatic Governor for, 389.
Gas Supply Regulation, Kramer Governor for, 391.
Gas Supply Regulation, Methods of, 388.
Gate Shift System of Control, 970.
Gauge for Oil Pressure, 597.
Gear Oil Pump, 585.
Gear Type Water Pump, 611.
Gears for Camshaft Drive, 256.
Gearset and Rear Axle Unit, 688.
General Driving Instructions, 977.
Generator, Utility of, in Starting System, 894.
Glass Windshields, 930.
Good Kerosene Vaporizer, 453.
Governed Type Dynamo, 496.
Grade Determination, Methods of, 108.
Gravity Feed Oiling Systems, 584.
Gravity Readings of Storage Battery, 922.

H

Hands, How to Keep Soft, 1009.
Harsh Acting Clutch, Cause of, 999.
Haynes Light Six-Engine Construction, 195.
Heat Loss, Bearing on Efficiency, 605.
Heat Loss Through Water Jacket, 605.
Heat Utilization Chart, 210.
Heater for Automobile Body, 938.
Headlight, Electric, 915.
Headlights, Automobile, 927.
Hewitt Piston Valves, 288.
High Altitude, Effect on Power, 465.
Hinged Cap Connecting Rod, 316.
Hints for Tire Manipulation, 868.
Hoadley Gas-Electric Drive, 693.

Holley Carburetor, 397.
Hollow Metal Float, 384.
Honeycomb Radiator Section, 609.
Horizontal Cylinder Engine, 128.
Horsepower Curves of Typical Engines, 198.
Horsepower Table, 200.
Hotchkiss Drive, 732.
How to Drive an Automobile, 977.
Hudson Super-Six Crankshaft, 332.
Hydraulic Brake, Action of, 822.
Hydraulic Brake, Knox, 822.
Hydraulic Governor for Fuel Regulation, 390.

I

Igniter for Low Tension Ignition, 534.
Ignition by Compression, 483.
Ignition by Flame, 483.
Ignition by Platinum Tube, 483.
Ignition, Electrical Systems, 483.
Ignition, Methods of, 483.
Ignition System, Atwater Kent, 522.
Ignition System, Battery and Magneto, 549.
Ignition System, Connecticut, 530.
Ignition System, Delco, 524.
Ignition System, Duplex, 564.
Ignition System, Essential Parts of, 483.
Ignition System Failure, 989.
Ignition System, Ford, 561.
Ignition System, Magneto-Transformer Coil, 543.
Ignition System, Parts of Simple, 505.
Ignition System, Remy, 529.
Ignition System, Remy Battery and Coil, 533.
Ignition System, True High Tension Magneto, 544.
Ignition System, Two-Spark Magneto, 549.
Ignition System, Westinghouse, 529.
Ignition Systems, Distributor and Single Coil, 519.
Ignition Systems, Dual, 563.
Ignition Systems, Four-Cylinder Battery and Coil, 518.
Ignition Systems, Low Tension, 534.
Ignition Systems, Non-vibrator Coil Distributor, 520.
Ignition Timing, 295.
Ignition Unit, Westinghouse, 529.
Important Automobile Components, 18.
Impulse Starter, Advantages of, 568.
Individual Clutch Type Gearing, 665.
Individual Cylinder Casting, 217.
Individual Pump Oilers, 601.
Induction Coil, Construction of, 505.
Induction Coil, Four Unit, 510.
Induction Coil, Function of, 505.
Induction Coil, Internal Connections, 508.
Induction Coil, Two-Unit, 510.
Induction Coil, Vibrator Type, 506.
Induction Coils, Typical, 509.
Induction Coils, Windings in, 508.
Inlet Valve Closing, 295.
Inlet Valve Opening, 293.
Installation and Drive of Magnetos, 557.
Installation of Change Speed Gears, 681.
Installation of Motor-Car Brakes, 813.
Installing Ball and Roller Bearings, 828.
Installing Spark Plugs, 513.
Insulating Materials for Spark Plugs, 512.
Intake Manifold Design, 468.
Intake Stroke, What Happens During, 125.
Itala Rotary Valve, 277.

J

Jacks for Raising Cars, 950.
Jackson Control System, 976.
Jeffery Four-Wheel Drive and Steer Truck, 801.
Jeffery Quadruple Drive Wheel Construction, 894.
Jeffery Repair Truck, 96.

K

Kemco Combined Fan and Generator, 920.
Kerosene as Fuel, 352.
Kerosene Carburetor, Holley, 445.
Kerosene, How to Utilize, 437.
Kerosene, Special Vaporizers Needed, 352.
Kerosene, Supplying by Direct Injection, 442.
King Eight-Cylinder Engine, 155.
Kingston Carburetor, 395.
Knight Engine Details, 144.
Knight Engine, Endurance Tests of, 150.
Knight Sleeve Valve Action, 145.
Knight Slide Valve Engine, 141.
Knox Three-Plate Clutch, 646.
Krice Annular Spray Carburetor, 432.

L

Lamp Troubles and Causes, 924.
Lamps, Combination Electric and Oil, 912.
Lamps for Electric Lighting System, 912.
Lanchester Wick Carburetor, 377.
Lap Joint Ring, 310.
Lead Given Exhaust Valve, 293.
Leaf Springs, Design of, 718.
Leather Disc Universal Joint, 737.
Leather Preservative, 1006.
Leather Tire Protectors, 851.
Lighting System Troubles, 925
Lighting Systems, Electric, 910.
Lighting Systems, Gas, 926.
Liquid Fuel Advantages, 350.
Liquid Fuel, Alcohol-Benzol, 355.
Liquid Fuel, Hydro Carbons, 350.
Liquid Fuel Storage and Supply, 359.
Liquid Fuels, Alcohol, 352.
Liquid Fuels, Benzol, 351.
Liquid Fuels, Distillation of Petroleum, 350.
Liquid Fuels, Gasoline, 351.
Liquid Fuels, Kerosene, 352.
Locating Engine Troubles, Hints for, 996.
Location of Engine Troubles, Systematic, 988.
Locomobile Four-Speed Gearset, 674.
Locomobile Six-Cylinder Engine, 217.
Low Tension Ignition Disadvantages, 536.
Low Tension Ignition, Features of, 533.
Lubrication by Constant Level Splash System, 589.
Lubrication by Gravity Feed, 582.
Lubrication by Mechanical Oiler, 585.
Lubrication by Pressure System, 594.
Lubrication by Sight Feed Oil Cups, 582.
Lubricants, Castor Oil, 576.
Lubricants, Classification of, 576.
Lubricants, Correct Oil Body Important, 577.
Lubricants, Derivation of, 575.
Lubricants for Chassis Parts, 750.
Lubricants, Mineral, 575.
Lubricants, Organic, 575.
Lubricants, Requirements of, 574.
Lubricants, Solid, 576.
Lubrication, Why Needed, 572.
Lubrication Don'ts, 603.
Lubrication System Troubles, 993.
Lubrication Systems, Self-contained, 591.
Lubrication, Theory of, 574.
Luggage Carrier for Running Board, 939.
Luggage Carrier, Simple, 939.

M

Mack Armored Automobile, 94.
Magnetic-Centrifugal Clutch Transmission, 705.
Magneto, Action of, 496.
Magneto Armature Rotation, Speed of, 542.
Magneto-Coil Ignition System, 543.
Magneto Construction, 537.
Magneto Distributor Segments, Spacing of, 540.
Magneto for Multi-Cylinder Ignition, 538.

Magneto for Single Cylinder Ignition, 537.
Magneto, Ford Type, 499.
Magneto, Impulse Starters for, 568.
Magneto, Inductor Type, 550.
Magneto, True High Tension, 544.
Magneto with Automatic Advance, 567.
Magnetos, Installation and Drive, 557.
Magnetos, Typical, 554
Maintenance of Body, 1005.
Maintenance of Tires, 876.
Maintenance of Upholstery, 1005.
Manifold, Design of Intake, 468.
Manifold, Ejector Type, 477.
Manifolds, Compound, 439.
Marine Type Connecting Rod, 316.
Marmon Axle Parts, 776.
Marmon Fuel System, 360.
Marmon Gearset Parts, 674.
Marmon Three-Quarter Floating Axle, 775.
Marvel-Buick Carburetor, 429.
Master Connecting Rod Design, 320.
Master Multiple Jet Carburetor, 434.
Mat for Cleaning Dirt from Shoes, 939.
Material for Tire Repairs, 866.
Materials Used in Clutches, 637.
Mead Rotary Valve, 280.
Mechanical Oiling Systems, 585.
Mercedes Carburetor, 401.
Method of Setting Car in Motion, 972.
Methods of Driving Cam Shaft, 256.
Miesse Combination Valve, 275.
Mitchell Automobile Control, 975.
Mixing Chamber Forms, 383.
Mixing Chamber, Venturi Type, 382.
Mixing Valve Type Carburetor, 377.
Mobile Repair Shops, 96.
Modern Chassis Designs, 730.
Motor Car Brakes, External, 811.
Motor Car Brakes, Internal, 810.
Motor Car Mechanism, Division into Groups, 20.
Motor Hard to Start, Remedy for, 982.
Motor Truck Design, 60.
Motor Truck Driving System, 761.
Motor Truck Models, Range of, 60.
Motor Trucks, Drawbar Pull of, 105.
Motor Vehicle Suspension, Requirements of, 717.
Mounting Ball Bearings on Crankshaft, 331.
Mufflers for Burnt Gases, 473.
Multiple Disc Brakes, 815.
Multiple Disc Clutch, 650.
Multiple Exhaust System, 479.
Multiple Nozzle Carburetors, 420.

N

National Fuel System, 363.
National Full Floating Axle, 777.
Natural Water Circulation, 611.
Noisy Operation, Some Causes of, 995.
Non-competitive Records, to 1916, 114.
Non-skid Casings, 849.
Non-skid Chains, 853.

O

Oakland Eight Valve Timing, 301.
Oakland Light Six Engine, 243.
Oakland Light Six Valve Timing, 300.
Off-set, Amount Allowable, 230.
Off-set Cylinders, 229.
Oil Destruction Due to Heat, 579.
Oil Distribution, 586.
Oil Pressure Gauge, Function of, 597.
Oil Pressure Regulation, 598.
Oil Pressure Relief Valve, 599.
Oil Pumps, Forms of, 585.
Oil Supply by Air Lock System, 592.
Oil Viscosity, How Tested, 579.
Oiling by Individual Pumps, 601.
Oiling System Faults, 993.
Oiling the Automobile Chassis, 753.
Oiling V Engines, 601.
One Cylinder Engine, Disadvantages of, 129.
One Unit Starting System, 890.

Operating Selective Gearset, 969.
Operating Sliding Gearsets, 968.
Oscillating Wristpin, 309.
Overhead Camshaft, 259.
Overheating, Causes of, 994.
Overland Valve Timing, 299.
Overrunning Clutch for Starting, 908.

P

Packard Repair Truck, 98.
Packard Twelve Cylinder Engine, 157.
Packard Twin-Six Control System, 969.
Packard Twin-Six Fuel System, 364.
Packard Twin-Six Engine, 1917 Model, 162.
Packard Vibration Damper, 334.
Partial Combustion Type Carburetor, 455.
Peerless Carburetor, 403.
Permanent Convertible Tops, 49.
Pierce-Arrow Control System, 969.
Pierce Automatic Carburetor, 401.
Piston Design Details, 305.
Piston, Differential, 305.
Piston, Function of, 123.
Piston Pins, How Held, 308.
Piston Ring, Butt Joint, 310.
Piston Ring, Diagonal Cut Joint, 311.
Piston Ring Joints, 310.
Piston Ring, Lap Joint, 310.
Piston Rings, Compound, 311.
Piston Rings, Concentric, 309.
Piston Rings, Eccentric, 309.
Piston Rings, Why Used, 309.
Piston Speed, Meaning of, 228.
Piston Valves, Hewitt, 288.
Pistons, Aluminum, 312.
Pistons, Construction of, 304.
Planetary Gearing Action, 659.
Planetary Gearing, Ford, 663.
Planetary Gearset Control, 964.
Pleasure Car Bodies, Trend of Design, 48.
Plow, Automobile, 91.
Plunger Oil Pump, 585.
Pneumatic Tires, Construction of, 841.
Power Curves Hudson Super-Six, 333.
Power Needed to Overcome Air Resistance, 36.
Power Plant Installation, 185.
Power Plant, Parts Comprising, 21.
Power Plants Used in Automobiles, 199.
Power Required to Propel Automobile, 39.
Power to Weight Ratio in Automobiles, 40.
Power Transmission by Double Chain, 760.
Power Transmission by Shaft, 760.
Power Transmission by Single Chain, 758.
Power Transmission Gears, 788.
Power Transmission System, Care of, 1002.
Power Transmission System, Typical, 633.
Power Transmission System, Typical, 758.
Power Transmission to Front Wheels, 806.
Preheating Fuel, 458.
Premier Clutch, 653.
Preparations for Removing Spots, 983.
Preservative of Leather, 1006.
Pressed Steel Frame, Typical, 714.
Pressure Feed Fuel System, 365.
Pressure, Increase of Tire when Driving, 875.
Pressure, in Tires, 875.
Pressure Oiling System, 594.
Priming Motor for Easy Starting, 982.
Priming Outfits, 460.
Principles of Carburetion, 357.
Protectors for Tires, 851.
Puncture in Inner Tube, How to Repair, 878.

R

Racing Engines, Wisconsin-Stutz, 192.

Radiator Construction, 621.
Radiator, Cooling Action of, 609.
Radiator, Core and Shell Type, 620.
Radiator Location, 613.
Radiator Shield for Winter, 982.
Radiator, Solderless, 622.
Radiator with Shutters for Temperature Control, 619.
Radiators for Trucks, 620.
Raised Tread Casings, 848.
Range of Truck Models, 60.
Ratio of Bore and Stroke, 227.
Rayfield Mixed Type Carburetor, 418.
Rayner Two-Cycle Engine, Action of, 181.
Rear Axle, Ford Model T, 771.
Rear Axle Forms, Dead, 767.
Rear Axle Forms, Live, 766.
Rear Axle, Full Floating, 770.
Rear Axle Nomenclature, 770.
Rear Axle, Semi-Floating, 770.
Rear Axle, Seven-Eighths Floating, 770.
Rear Axle, Three-Quarter Float, 773.
Rear Axle, Three-Quarter Floating, 770.
Rear Axle Using Double Reduction Gearing, 797.
Rear Axles, Combination Dead and Live, 769.
Rear Axles for Pleasure Cars, 766.
Records, Speedway and Competitive, 114.
Removable Head Construction, 219.
Removable Head Advantages, 241.
Removing Demountable Rims, 857.
Removing Tire from Rim, 872.
Remy Battery and Coil System of Ignition, 533.
Remy Ignition System, 529.
Reo Control System, 969.
Reo Engine, Early Model, 127.
Repair Shop, Mobile, 96.
Repair Truck, Four-Wheel Drive, 99.
Repair Truck, Jeffery, 96.
Repair Truck, Packard, 98.
Repairing Tire Blowout, 878.
Repairing Tires, 876.
Replacing Demountable Rim, 872.
Retaining Piston Pins, 308.
Retention of Flywheels, 336.
Reynolds Rotary Disc Valve, 278.
Rims, Demountable, 853
Rims, Detachable and Demountable, 854.
Ring Valves, Sphinx Type, 283.
Road Resistance of Trucks and Trailers, 106.
Roadster, Four Passenger, 52.
Roller Bearing, Flexible, 826.
Roller Bearing Straight Roller, 825.
Roller Bearing, Taper, 825.
Rotary Valve, Disc Type, 278.
Rotary Valve, Itala, 277.
Rotary Valve, Mead, 280.
Rotary Valves, Carbon, 281.
Rotary Valves, Darracq, 286.
Rotary Valves, Double Cone Type, 280.
Rotary Valves, Single Cone Type, 280.
Round Tread Casings, 848.
Rubber Tires, Solid, 862.
Rules for Care of Tires, 881.
Running Board Accessories, 939.

S

Saurer Economy Carburetor, 423.
Schebler Carburetor, 393.
Schebler Metering Pin Carburetor, 395.
Schebler Water Attachment for Carburetor, 450.
Scissors Joint Rods, 319.
Scott-Robinson Carburetor, 417.
Seating Arrangement in New Bodies, 54.
Segments of Timer, Spacing, 504.
Selective Gearset Operation, 969.
Selective Sliding Gearset, 673.
Semi-Floating Axle, 770.
Semi-Floating Axle, Stearns-Knight, 772.
Semi-Floating Axle, Using Taper Roller Bearings, 772.
Sequence of Operations, Four Cycle, 129.
Series Connection of Dry Cells, 486.

Series Multiple Connection, 487.
Seven-Eighths Floating Rear Axle, 770.
Shaft Drive System, 760.
Shaft-Driving Systems, Care of, 1003.
Sheffield-Simplex Engine Details, 231.
Shifting Gears by Electricity, 708.
Shifting Gears, Trouble in, 1001.
Shims for Connecting Rods, 318.
Shock Absorber Types, 931.
Shock Absorbers, Function of, 931.
Shoe Brake, 810.
Side by Side Connecting Rods, 320.
Sight Feed Oil Cups, 582.
Signals and Alarms, 934.
Silent Chain Camshaft Drive, 256.
Silent Chains for Change Speed Gearing, 666.
Simple Cell, Action of, 485.
Simple Ignition System, Parts of, 505.
Simple Luggage Carrier, 939.
Single Chain Drive, 758.
Single Cylinder Engine, High Speed Type, 129.
Single Cylinder Engine, Slow Speed Type, 128.
Six-Cylinder Engine Action, 133.
Six-Cylinder Engine, Locomobile, 217.
Six-Cylinder Four-Bearing Crankshaft, 328.
Sixteen Valve Engine, 268.
Size Selection Data for Tires, 874.
Skew Bevel Drive Gearing, 792.
Sleeve Valve Movements, 272.
Sleeve Valves, Action of, 146.
Slide Valves, Fischer, 290.
Sliding Gears, 670.
Sliding Gearset, Progressive Shift, 670.
Sliding Gearset, Selective, 673.
Sliding Gearsets, How to Operate, 968.
Slip Covers for Upholstery, 1009.
Slipping Clutch, Cause of, 999.
Slow Speed One-Cylinder Engine, 128.
Solderless Radiator for Trucks, 622.
Solid Detachable Tires, 862.
Solid Gasoline as Fuel, 356.
Solid Rubber Tires, 862.
Spare Parts for Car Upkeep, 946.
Spark Advance, How it is Done, 960.
Spark and Throttle Control, 960.
Spark Gap, Auxiliary, 514.
Spark Lever Manipulation, 959.
Spark Plug Connection, Watertight, 516.
Spark Plug Construction, 512.
Spark Plug Design, 510.
Spark Plug for Two-Spark Ignition, 517.
Spark Plug Installation, 512.
Spark Plug, Insulating Materials for, 512.
Spark Plug, Mica Insulation, 511.
Spark Plug, Porcelain Insulation, 511.
Spark Plug, Priming Type, 514.
Spark Plug, Visible Spark Type, 514.
Spark Plugs, Gap Between Electrodes, 512.
Speed Governor, Centrifugal, 389.
Speed Governor, Kramer, 391.
Speed Governor, Hydraulic, 390.
Speed, Its Influence on Air Resistance, 37.
Speed Measuring Devices, 935.
Speedometer Drive, 936.
Speedometers, 935.
Speedway Body Design, 39.
Speedway Records, to 1916, 114.
Sphinx Ring Valve, 283.
Splash System of Oiling, 589.
Spot Removing Preparations, 983.
Spraying Carburetors, 376.
Spring Action Dampeners, 932.
Spring Plate Universal Joint, 739.
Spring Suspension, Brush, 724.
Spring Wheels, Advantages of, 840.
Spring Wheels, 838.
Spring Wheels for Automobiles, 839.
Springless Valves, 261.
Springs, Auxiliary, 932.
Springs, Cantilever, 721.
Springs for Front End of Motor Car, 719.
Springs, Full Elliptic, 718.
Springs, Leaf, 718.
Springs, Scroll Elliptic, 719.
Springs, Semi-Elliptic, 719.

Springs, Three-Quarter Elliptic, 719.
Springs, Type without Shackles, 726.
Springs, Unconventional, 729.
Standard Body Nomenclature, 47.
Starter System, Control Devices for, 894.
Starters, One-Unit Electric, 890.
Starters, Principles of, 884.
Starters, Two-Unit Electric, 892.
Starting Car, Method of, 972.
Steel Engine Cylinders, 347.
Starting Engine, Method of, 956.
Steering Gear, Construction of, 747.
Steering Gear, Rack and Pinion, 744.
Steering Gear, Screw and Nut Type, 746.
Steering Gear, Worm and Worm Gear, 744.
Steering Gears for Automobiles, 744.
Steering Knuckle, Elliot, 757.
Steering Knuckle Form, 757.
Steering Knuckle, LeMoine, 758.
Steering Knuckle, Mercedes, 757.
Steering System, Care of, 1003.
Steering Wheel, Heater for, 938.
Steering Wheel, Tilting, 749.
Stewart Metering Pin Carburetor, 416.
Stewart Vacuum Fuel Feed, 368.
Stewart Vacuum Tank, Construction of, 369.
Storage Battery Action, 490.
Storage Battery Capacity, 491.
Storage Battery, Care of, 920.
Storage Battery, Charging from Outside Source, 923.
Storage Battery for Automobile Work, 491.
Storage Battery for Ignition, 491.
Storage Battery for Starting System, 894.
Storage Battery Electrolyte, Gravity of, 922.
Storage Battery, Parts of, 490.
Storage Battery, Simple Form, 490.
Straight Line Drive, 761.
Straightaway Records to 1916, 115.
Stream Line Body, Air Flow Around, 38.
Strokes, Classification of, 126.
Stromberg M. B. Carburetor, 413.
Stromberg One Nozzle Type Carburetor, 405.
Stromberg Two Jet Carburetor, 421.
Studded Tire Protectors, 851.
Suggestions for Chassis Oiling, 752.
Summary of Fuel Tank Locations, 366.
Sunderman Carburetor, 427.
Supplies, Methods of Carrying, 952.
Supplies for Car Upkeep, 946.
Systematic Location of Engine Troubles, 988.

T

Tank Location at Rear Advantages, 366.
Tank Location at Rear Disadvantages, 366.
Tank Location, Cole Eight Chassis, 361.
Tank Location Under Cowl, Advantages of, 367.
Tank Location Under Cowl, Disadvantages of, 367.
Tank Location Under Front Seat, Advantages of, 366.
Tank Location Under Front Seat, Disadvantages of, 367.
Taylor White Process of Using Alcohol, 353.
Temperature Regulators, Cooling System, 620.
Temperatures of Motor Parts, 580.
Tendency of Design, 18.
Tests of Knight Engine, 150.
Thermostat Release, Connecticut Ignition System, 530.
Thermostatic Temperature Regulators, 620.
Thermo-Syphon Water Cooling, 613.
Three Bearing Crankshaft, 327.
Three Plate Clutches, 646.
Three Point vs. Four Point Engine Support, 187.
Three-Quarter Floating Axle, Case, 774.
Three-Quarter Floating Axle, Marmon, 775.

Three-Quarter Floating Rear Axle, 770.
Three-Speed Gearset, Overland, 670.
Three-Wheel Tractor for Hauling, 66.
Throttle Control of Engine Speed, 958.
Tilting Steering Wheel, 749.
Time of Ignition, 295.
Timer and Coil Unit, Westinghouse, 529.
Timer and Distributor Forms, 499.
Timer Cam, Speed of Rotation, 500.
Timer, Delco, for Twin-Six Engine, 525.
Timer-Distributor, Atwater Kent, 523.
Timer-Distributor, Delco, 503.
Timers for One-Cylinder Engines, 501.
Timer, Roller Contact Type, 502.
Timers, Arrangement of Segments in, 504.
Timers for Multiple Cylinder Engines, 501.
Timing Diagrams, 296.
Timing Valves, 291.
Tire Casing, the Dunlop, 846.
Tire Casings, Bolted-on-Type, 847.
Tire Casings, Non-skid, 849.
Tire Casings, Raised Tread, 848.
Tire Casings, Round Tread, 848.
Tire Chains, Non-skid, 853.
Tire, How to Remove from Demountable Rim, 872.
Tire Irons, Forms of, 865.
Tire Maintenance, 876.
Tire Manipulation Hints, 868.
Tire, Outer Casings, General Design of, 844.
Tire Protectors, 851.
Tire Removing Tools, 871.
Tire Repair Material, 866.
Tire Repairing, 876.
Tire Repairing, Blowout, 878.
Tire Repairs, Tools for, 863.
Tire, Replacing on Demountable Rim, 872.
Tire, the Cord, 845.
Tire, the Cord, Method of Construction, 845.
Tire Valve, Construction of, 844.
Tire Valve, Trouble, 878.
Tires, Air Pressure of, 875.
Tires, Blowout in, 878.
Tires, Carrying Capacity of, 874.
Tires, Clincher, 846.
Tires, Cushion, 857.
Tires, Depreciation of, 877.
Tires, Equipment for Upkeep, 864.
Tires, Fitted to Simple Clincher Rim, 842.
Tires, Outer Casings, Composed of, 843.
Tires, Outer Casing Forms, 848.
Tires, Pneumatic, Rim Forms, 846.
Tires, Size Selection Data, 874.
Tires, Solid, 840.
Tires, Solid Rubber, 862.
Tires, the Tread of, 843.
Tires, Tools for Repairs of, 863.
Tires, Twin Solid, 862.
Tires, Vulcanizers for, 867.
Tonneau Heater, 938.
Tool Outfit for Repairing, 941.
Tools and Equipment for Car Upkeep, 940.
Tools for Tire Removal, 871.
Tools for Tire Repairs, 863.
Tools, Methods of Carrying, 942.
Top, One Man, 984.
Tops, Care of, 1007.
Torque Diagrams of Engines, 152.
Tractive Force, 106.
Tractive Force Determination, 106.
Tractive Force Example, 108.
Tractive Resistance, 106.
Tractor Attachment, 68.
Tractor Design Fundamentals, 85.
Tractor for Fire Apparatus, 67.
Tractor, Knox Four-Wheel, 68.
Tractor Requirements, 84.
Tractor-Truck Combination, 85.
Tractors, Agricultural, 84.
Tractors, Farm, 92.
Tractors, Four-Wheel Drive, 74.
Trailer Types in Common Use, 70.
Trailers and Semi-Trailers, 74.
Trailers, Four Wheels, 74.
Trailers, Two Wheel, 74.
Troubles in Cooling System, 994.

Troubles in Ignition System, 989.
Troubles in Oiling System, 993.
Truck Radiators, 620.
True High Tension Magneto, 544.
Tubular Drive Shaft, 738.
Twelve-Cylinder Engine, Advantage of, 157.
Twin Solid Tires, 862.
Twin-Six Engine, Packard, 157.
Two-Cycle Engine, Air Cooled, 626.
Two-Cycle Engine, Differential Piston Type, 168.
Two-Cycle Motor, Why it is Not Used in Automobiles, 169.
Two-Cylinder Crankshaft, 327.
Two-Spark Ignition, Reason for, 516.
Two-Speed Direct Drive Axle, 793.
Two-Stroke Cycle Engines, Operating Principles of, 163.
Two-Wheel Front Drive Trucks, 75.
Two-Unit Starting System, 892.
Types of Lamp Bulbs, 913.
Types of Windshields, 930.
Typical Chassis, Steps in Assembling, 28.

U

Underslung Chassis, Advantages of, 712.
Universal Joint, Fabric, 740.
Universal Joint, Leather Disc, 737.
Universal Joint, Spring Plate, 739.
Universal Joints, Construction of, 738.
Universal Joints, Types of, 737.
Upholstery, Maintenance of, 1005.
Upholstery, Slip Covers for, 1009.
Utility of Automobile Brakes, 809.
Utility of Bumpers, 933.

V

V Engines, Connecting Rods for, 319.
Vacuum Fuel Feed, Stewart, 368.
Vacuum Operated Brake, 820.
Valve Actuation, 248.
Valve Actuation by Oil Pressure, 253.
Valve Arrangement, Unconventional, 270.
Valve Construction, 247.
Valve Design Considerations, 246.
Valve in the Head Designs, 237.
Valve Lift Plungers, 251.
Valve-Lifting Cams, 248.
Valve Location, Concentric Intake and Exhaust, 244.
Valve Location, Why Important, 233.
Valve Operating Means, 251.
Valve Placing Diagrams, 253.
Valve Springs, 271.
Valve Timing, 291.
Valve Timing, Exhaust Closing, 293.
Valve Timing, Exhaust Lead, 293.
Valve Timing, Flywheel Rim Marks for, 298.
Valve Timing, Inlet Closing, 295.
Valve Timing, Inlet Valve Opening, 293.
Valve Timing, Oakland Eight, 301.
Valve Timing, Oakland Six, 300.
Valve Timing, Overland Motor, 299.
Valve Timing Table, 303.
Valve Timing, Typical, 296.
Valves, Forms of Mushroom, 247.
Valves, Four Per Cylinder, 265.
Valves, Function of, 123.
Valves Operated by Drum Cams, 263.
Valves, Positively Closed, 262.
Valves, Rotary Carbon, 281.
Valves, Rotary Cone, 280.
Valves, Sphinx Ring Type, 283.
Valves, Springless, 261.
Vapor Humidifiers, 461.
Vaporizers, Early Forms of, 374.
Variations in Design for Eight Years, 111.
Venturi Mixing Chamber, Action of, 382.
Venturi Tube Theory, 384.
Vertical Cylinder Engine, 129.
Vibration Damper, Function of, 335.
Vibration Damper, Lanchester Packard, 334.
Vibration, Function of, 507.
Volt, Definition of, 489.
Vulcan Electric Gearshift, 708.
Vulcanizers for Tires, 867.

Vulcanizers, How to Use in Repairing, 878.
Vulcanizing, Methods of, 879.
Vulcanizing Temperatures, 879.

W

Washing the Car Body, 1006.
Water Circulating Pumps, 610.
Water Circulation by Natural System, 611.
Water Cooling, 606.
Water Cooling Tubes Used in Radiators, 609.
Water Pump on Fan Shaft Extension, 611.
Water Pump, Gear Type, 611.
Water Pump, Centrifugal, 611.
Water Spaces for Natural Circulation, 616.
Watertight Spark Plug Connection, 516.
Weidely Engine Design, 242.
Weight of Flywheel, 337.
Westinghouse Ignition Unit, 529.
Wheel, Artillery Type, 831.
Wheels, Demountable Steel Disc, 833.
Wheels, Spring, 838.
Wheels, Wire and Metal, 832.
Wick Carburetor, 374.
Wick Carburetor, Lanchester, 377.
Wind Resistance and Body Design, 32.
Windshield, Celluloid and Leather, 930.
Windshields, Automobile, 930.
Windshields, Glass, 930.
Winter Care of Automobiles, 978.
Wire and Metal Wheels, 832.
Wire Wheels, Advantages, 835.
Wire Wheels, Demountable, 836.
Wire Wheels, Strength of, 835.
Wisconsin Aviation Engine, 260.
Wisconsin-Stutz Racing Engine, 192.
Wood's Dual Power Car, 102.
Worm Gear Axles, 762.
Worm Gear for Pierce Motor Truck, 788.
Worm Gears for Power Transmission, 788.
Wristpin, Oscillating in Piston Bosses, 309.
Wristpin Retention, 307.

Z

Zenith Compound Nozzle Carburetor, 408.
Zenith Duplex Type Carburetor, 412.
Zenith Horizontal Type Carburetor, 410.

LATEST

REVISED

CATALOGUE

of the Best

Practical and Mechanical Books

Including Automobile and Aviation Books

PRACTICAL BOOKS FOR PRACTICAL MEN

Each Book in this Catalogue is written by an Expert and is written so you can understand it

PUBLISHED BY

THE NORMAN W. HENLEY PUBLISHING CO.

2 West 45th Street, New York, U. S. A.

Established 1890

☞ **Any Book in this Catalogue sent prepaid on receipt of price**

Manuscripts solicited on Practical Subjects

INDEX

	PAGE
Abrasives and Abrasive Wheels	29
Accidents	25
Air Brakes	24, 26
Arithmetic	13, 27, 37
Automobile Books	3, 4, 5, 6
Automobile Charts	6, 7
Automobile Ignition Systems	7
Automobile Lighting	4
Automobile Questions and Answers	5
Automobile Repairing	5
Automobile Starting Systems	4
Automobile Trouble Charts	6, 7
Automobile Welding	6
Aviation	8
Bells, Electric	14
Bevel Gear	21
Boats, Motor	30
Boiler Room Chart	9
Boilers, Marine	30
Brazing	9
Cams	21
Carburetion Trouble Charts	7
Carburetors	4
Car Charts	9
Cements	12
Change Gear	21
Charts	6, 7, 9
Chemistry	10
Coal	24
Combustion	19
Concrete	10, 11, 12
Concrete for Farm Use	11
Concrete for Shop Use	11
Cosmetics	32
Dictionary	12, 17
Dies	12
Drawing	13, 32
Drawing for Plumbers	32
Dynamo Building	14
Electric Bells	14
Electric Dictionary	17
Electric Switchboards	15
Electric Toy Making	16
Electric Wiring	15
Electricity	13, 14, 15, 16, 17, 18
Electroplating	19
Encyclopedia	29
Engine, Aviation	8
E-T Air Brake	26
Factory Management	19
Ford Automobile	4
Ford Tractor	4
Ford Trouble Chart	7
Formulas and Recipes	34
Fuel	19
Gas Engines	20, 21
Gas Tractor	39
Gearing and Cams	21
Glossary Aviation Terms	8
Heating	37
High Frequency Apparatus	15
Horse-Power Chart	36
Hot Water Heating	37
House Wiring	17, 18
Hydraulics	22
Ice	22
Ignition Systems	4
Ignition Trouble Chart	7
India Rubber	35
Interchangeable Manufacturing	27
Inventions	22
Kerosene Carburetors	4
Knots	23

	PAGE
Lathe Work	23
Link Motions	24
Liquid Air	24
Locomotive Boilers	25
Locomotive Breakdowns	25
Locomotive Engineering	24, 25, 26
Machinist Books	27, 28, 29
Manual Training	30
Marine Engineering	30
Marine Gasoline Engines	21
Mechanical Drawing	13
Mechanical Movements	28
Metal Work	12
Model Making	29
Motor Boats	30
Motorcycles	7, 31
Motor Truck	3
Naval Engineering	30
Patents	22
Pattern Making	31
Perfumery	32
Perspective	13
Plumbing	32, 33
Punches	12
Producer Gas	21
Questions and Answers on Automobile	5
Questions on Heating	38
Radio Time Signal Receiver	16, 17
Railroad Accidents	25
Railroad Charts	9
Recipe Book	34
Refrigeration	22
Repairing Automobiles	5
Rope Work	23
Rubber	35
Rubber Stamps	35
Saw Filing	35
Saws, Management of	35
Screw Cutting	35
Shipbuilders' Pocket Book	30
Shop Construction	27
Shop Management	27
Shop Practice	27, 28, 29
Shop Tools	29
Sketching Paper	13
Slide Valve	24
Soldering	9
Splices and Rope Work	23
Steam Engineering	35, 36, 37
Steam Heating	37
Steel	38
Storage Batteries	18
Submarine Chart	9
Switchboards	15
Tapers	23
Telegraphy, Wireless	14, 16, 18
Telephone	18
Thread-Cutting	27
Tool Making	27
Tool Steel	38
Toy Making	16
Tractive Power Chart	9
Tractor, Gas	39
Train Rules	26
Vacuum Heating	38
Valve Setting	24
Ventilation	37
Walschaert Valve Gear	26
Waterproofing	12
Welding	6, 39
Wireless Telegraphy	14, 16, 18
Wiring	15, 17, 18
Wiring Diagrams	15

Any of these books promptly sent prepaid to any address in the world on receipt of price.

HOW TO REMIT.—By Postal Money Order, Express Money Order, Bank Draft, or Registered Letter.

AUTOMOBILES

THE MODERN GASOLINE AUTOMOBILE—ITS DESIGN, CONSTRUCTION, MAINTENANCE AND REPAIR. By Victor W. Pagé, M.E.

The latest and most complete treatise on the Gasoline Automobile ever issued. Written in simple language by a recognized authority, familiar with every branch of the automobile industry. Free from technical terms. Everything is explained so simply that anyone of average intelligence may gain a comprehensive knowledge of the gasoline automobile. The information is up-to-date and includes, in addition to an exposition of principles of construction and description of all types of automobiles and their components, valuable money-saving hints on the care and operation of motor-cars propelled by internal combustion engines. Among some of the subjects treated might be mentioned: Torpedo and other symmetrical body forms designed to reduce air resistance; sleeve valve, rotary valve and other types of silent motors; increasing tendency to favor worm-gear power-transmission: universal application of magneto ignition; development of automobile electric-lighting systems; block motors; under-slung chassis; application of practical self-starters; long stroke and offset cylinder motors; latest automatic lubrication systems; silent chains for valve operation and change-speed gearing; the use of front wheel brakes and many other detail refinements. By a careful study of the pages of this book one can gain practical knowledge of automobile construction that will save time, money and worry. The book tells you just what to do, how and when to do it. Nothing has been omitted, no detail has been slighted. Every part of the automobile, its equipment, accessories, tools, supplies, spare parts necessary, etc., have been discussed comprehensively. If you are or intend to become a motorist, or are in any way interested in the modern Gasoline Automobile, this is a book you cannot afford to be without. 1032 pages— and more than 1,000 new and specially made detail illustrations, as well as many full-page and double-page plates, showing all parts of the automobile. Including 12 large folding plates. New Edition. Price **$4.00**

WHAT IS SAID OF THIS BOOK:

"It is the best book on the Automobile seen up to date."—J. H. Pile, Associate Editor *Automobile Trade Journal.*

"Every Automobile Owner has use for a book of this character."—*The Tradesman.*

"This book is superior to any treatise heretofore published on the subject."—*The Inventive Age.*

"We know of no other volume that is so complete in all its departments, and in which the wide field of automobile construction with its mechanical intricacies is so plainly handled, both in the text and in the matter of illustrations."—*The Motorist.*

"The book is very thorough, a careful examination failing to disclose any point in connection with the automobile, its care and repair, to have been overlooked."—*Iron Age.*

"Mr. Pagé has done a great work, and benefit to the Automobile Field."—W. C. Hasford, Mgr. Y. M. C. A. Automobile School, Boston, Mass.

"It is just the kind of a book a motorist needs if he wants to understand his car."—*American Thresherman.*

THE MODERN MOTOR TRUCK, ITS DESIGN, CONSTRUCTION, OPERATION AND REPAIR. By Victor W. Pagé.

Just off the press and treats on all types of motor trucks and industrial tractors and trailers. It considers all types of trucks, gasoline and electric, and all varieties of truck bodies. This book is written in language everyone can understand and is not in any sense of the word a technical treatise. It is a practical volume that will make special appeal to the truck driver who seeks to better his position and to the mechanic charged with the repair and upkeep of trucks. The factory or business executive who wants to obtain a complete working knowledge of truck operation problems will find this book a reference work of great value. The truck salesman or automobile dealer will find that this work contains information that means money to them. All garage and service station men should have a copy of this book for reference because truck construction differs from passenger car design in many important respects. Anyone who reads this book is in touch with all the practical features that have been tested out in real service. 1921 Edition. Cloth, 6 x 9, 962 pages, 750 illustrations Price. **$5.00**

THE MODEL T FORD CAR, ITS CONSTRUCTION, OPERATION AND REPAIR, INCLUDING THE FORDSON FARM TRACTOR, F. A. LIGHTING AND STARTING SYSTEM, FORD MOTOR TRUCK. By VICTOR W. PAGÉ.

This is the most complete and practical instruction book ever published on the Ford car and Fordson tractor. All parts of the Ford Model T car and Fordson tractor are described and illustrated in a comprehensive manner. The construction is fully treated and operating principle made clear to everyone. Complete instructions for driving and repairing are given. To the New Revised Edition matter has been added on the Ford Truck and Tractor Conversion Sets and Genuine Fordson Tractor. All parts are described. All repair processes illustrated and fully explained. Written so all can understand—no theory, no guesswork. New revised and enlarged Edition just published. 153 illustrations, 410 pages, 2 large folding plates. Price . **$2.00**

AUTOMOBILE STARTING, LIGHTING AND IGNITION SYSTEMS. By VICTOR W. PAGÉ, M.E.

This practical volume has been written with special reference to the requirements of the non-technical reader desiring easily understood, explanatory matter, relating to all types of automobile ignition, starting and lighting systems. It can be understood by anyone, even without electrical knowledge, because elementary electrical principles are considered before any attempt is made to discuss features of the various systems. These basic principles are clearly stated and illustrated with simple diagrams. *All the leading systems of starting, lighting and ignition have been described and illustrated with the co-operation of the experts employed by the manufacturers.* Wiring diagrams are shown in both technical and non-technical forms. All symbols are fully explained. It is a comprehensive review of modern starting and ignition system practice, and includes a complete exposition of storage battery construction, care and repair. All types of starting motors, generators, magnetos, and all ignition or lighting system units are fully explained. The systems of cars already in use as well as those that are to come are considered. *Every person in the automobile business needs this volume.* 5¼x7½. Cloth. 815 pages, 492 illustrations, 3 folding plates. New revised and enlarged edition. Price **$3.00**

GASOLINE AND KEROSENE CARBURETORS, CONSTRUCTION, INSTALLATION AND ADJUSTMENT. By VICTOR W. PAGÉ. A new up-to-date Book on Modern Carburetion Practice.

This is a simple, comprehensive, and authoritative treatise for practical men explaining all basic principles pertaining to carburetion, showing how liquid fuels are vaporized and turned into gas for operating all types of internal combustion engines intended to operate on vapors of gasoline, kerosene, benzol, and alcohol. All leading types of carburetors are described in detail, special attention being given to the forms devised to use the cheaper fuels such as kerosene. Carburetion troubles, fuel system troubles, carburetor repairs and installation, electric primers and economizers, hot spot manifolds and all modern carburetor developments are considered in a thorough manner. Methods of adjusting all types of carburetors are fully discussed as well as suggestions for securing maximum fuel economy and obtaining highest engine power.
This book is invaluable to repairmen, students, and motorists, as it includes the most complete exposition on kerosene carburetors ever published. The drawings showing carburetor construction are made from accurate engineering designs and show all parts of late types of carburetors. 213 pages. 89 illustrations. . **$2.00**

HINTS AND TIPS FOR AUTOMOBILISTS. By VICTOR W. PAGÉ.

The book is ideal for the busy man or woman who wants to know about car operation and upkeep because of the economies possible when an automobile is intelligently operated. It contains many money-saving hints and a brief simple exposition of location and remedy of roadside troubles apt to occur under ordinary operating conditions. Price . . . . . **75 cents**

AUTOMOBILE REPAIRING MADE EASY. By VICTOR W. PAGÉ, M.E.

A comprehensive, practical exposition of every phase of modern automobile repairing practice. Outlines every process incidental to motor car restoration. Gives plans for workshop construction, suggestions for equipment, power needed, machinery and tools necessary to carry on the business successfully. Tells how to overhaul and repair all parts of all automobiles. Everything is explained so simply that motorists and students can acquire a full working knowledge of automobile repairing. This work starts with the engine, then considers carburetion, ignition, cooling and lubrication systems. The clutch, change-speed gearing and transmission system are considered in detail. Contains instructions for repairing all types of axles, steering gears and other chassis parts. Many tables, short cuts in figuring and rules of practice are given for the mechanic. Explains fully valve and magneto timing, "tuning" engines, systematic location of trouble, repair of ball and roller bearings, shop kinks, first aid to injured and a multitude of subjects of interest to all in the garage and repair business.

This book contains special instructions on electric starting, lighting and ignition systems, tire repairing and rebuilding, autogenous welding, brazing and soldering, heat treatment of steel, latest timing practice, eight and twelve-cylinder motors, etc. 5¾x8. Cloth. 1060 pages, 1,000 illustrations, 11 folding plates. Price. **$4.00**

WHAT IS SAID OF THIS BOOK:

"'Automobile Repairing Made Easy' is the best book on the subject I have ever seen and the only book I ever saw that is of any value in a garage."—Fred Jeffrey, Martinsburg, Neb.

"I wish to thank you for sending me a copy of 'Automobile Repairing Made Easy.' I do not think it could be excelled."—S. W. Gisriel, Director of Instruction, Y. M. C. A., Philadelphia, Pa.

QUESTIONS AND ANSWERS RELATING TO MODERN AUTOMOBILE CONSTRUCTION, DRIVING AND REPAIR. By VICTOR W. PAGÉ, M.E.

A practical self-instructor for students, mechanics and motorists, consisting of thirty-seven lessons in the form of questions and answers, written with special reference to the requirements of the non-technical reader desiring easily understood, explanatory matter relating to all branches of automobiling. The subject-matter is absolutely correct and explained in simple language. If you can't answer all of the following questions, you need this work. The answers to these and nearly 2000 more are to be found in its pages. Give the name of all important parts of an automobile and describe their functions? Describe action of latest types of kerosene carburetors? What is the difference between a "double" ignition system and a "dual" ignition system? Name parts of an induction coil? How are valves timed? What is an electric motor starter and how does it work? What are advantages of worm drive gearing? Name all important types of ball and roller bearings? What is a "three-quarter" floating axle? What is a two-speed axle? What is the Vulcan electric gear shift? Name the causes of lost power in automobiles? Describe all noises due to deranged mechanism and give causes? How can you adjust a carburetor by the color of the exhaust gases? What causes "popping" in the carburetor? What tools and supplies are needed to equip a car? How do you drive various makes of cars? What is a differential lock and where is it used? Name different systems of wire wheel construction, etc., etc. A popular work at a popular price. 5¼x7½. Cloth. 701 pages, 387 illustrations, 3 folding plates. New revised edition. Price **$2.50**

WHAT IS SAID OF THIS BOOK:

"If you own a car—get this book."—*The Glassworker.*

"Mr. Pagé has the faculty of making difficult subjects plain and understandable."—*Bristol Press.*

"We can name no writer better qualified to prepare a book of instruction on automobiles than Mr. Victor W. Pagé."—*Scientific American.*

"The best automobile catechism that has appeared."—*Automobile Topics.*

"There are few men, even with long experience, who will not find this book useful. Great pains have been taken to make it accurate. Special recommendation must be given to the illustrations, which have been made specially for the work. Such excellent books as this greatly assist in fully understanding your automobile."—*Engineering News.*

HOW TO RUN AN AUTOMOBILE. By Victor W. Pagé.

This treatise gives concise instructions for starting and running all makes of gasoline automobiles, how to care for them, and gives distinctive features of control. Describes every step for shifting gears, controlling engine, etc. Among the chapters contained are: I. Automobile Parts and Their Functions. II. General Starting and Driving Instructions. III. Control Systems—Care of Automobiles. Thoroughly illustrated. 178 pages. 72 illustrations. Price **$1.50**

THE AUTOMOBILIST'S POCKET COMPANION AND EXPENSE RECORD. By Victor W. Pagé.

This book is not only valuable as a convenient cost record, but contains much information of value to motorists. Includes a condensed digest of auto laws of all States, a lubrication schedule, hints for care of storage battery, and care of tires, location of road troubles, anti-freezing solutions, horse-power table, driving hints and many useful tables and recipes of interest to all motorists. Not a technical book in any sense of the word, just a collection of practical facts in simple language for the every-day motorist. Convenient pocket size. Price **$1.50**

AUTOMOBILE WELDING WITH THE OXY-ACETYLENE FLAME. By M. Keith Dunham.

Explains in a simple manner apparatus to be used, its care, and how to construct necessary shop equipment. Proceeds then to the actual welding of all automobile parts, in a manner understandable by everyone. Gives principles never to be forgotten. This book is of utmost value, since the perplexing problems arising when metal is heated to a melting point are fully explained and the proper methods to overcome them shown. 167 pages. Fully illustrated. Price. **$1.50**

AUTOMOBILE, AVIATION AND MOTORCYCLE CHARTS

AVIATION CHART—LOCATION OF AIRPLANE POWER PLANT TROUBLES MADE EASY. By Major Victor W. Pagé, A.S., S.C.U.S.R.

A large chart outlining all parts of a typical airplane power plant, showing the points where trouble is apt to occur and suggesting remedies for the common defects. Intended especially for aviators and aviation mechanics on school and field duty. Price . . . . . **35 cents**

CHART. GASOLINE ENGINE TROUBLES MADE EASY—A CHART SHOWING SECTIONAL VIEW OF GASOLINE ENGINE. Compiled by Victor W. Pagé, M.E.

It shows clearly all parts of a typical four-cylinder gasoline engine of the four-cycle type. It outlines distinctly all parts liable to give trouble and also details the derangements apt to interfere with smooth engine operation.
Valuable to students, motorists, mechanics, repairmen, garagemen, automobile salesmen, chauffeurs, motorboat owners, motor-truck and tractor drivers, aviators, motorcyclists, and all others who have to do with gasoline power plants.
It simplifies location of all engine troubles, and while it will prove invaluable to the novice, it can be used to advantage by the more expert. It should be on the walls of every public and private garage, automobile repair shop, club house or school. It can be carried in the automobile or pocket with ease, and will insure against loss of time when engine trouble manifests itself.
This sectional view of engine is a complete review of all motor troubles. It is prepared by a practical motorist for all who motor. More information for the money than ever before offered. No details omitted. Size 25x38 inches. Securely mailed on receipt of . . . . . **35 cents**

CHART. LOCATION OF FORD ENGINE TROUBLES MADE EASY. Compiled by VICTOR W. PAGÉ, M.E.

This shows clear sectional views depicting all portions of the Ford power plant and auxiliary groups. It outlines clearly all parts of the engine, fuel supply system, ignition group and cooling system, that are apt to give trouble, detailing all derangements that are liable to make an engine lose power, start hard or work irregularly. This chart is valuable to students, owners, and drivers. as it simplifies location of all engine faults. Of great advantage as an instructor for the novice, it can be used equally well by the more expert as a work of reference and review. It can be carried in the tool-box or pocket with ease and will save its cost in labor eliminated the first time engine trouble manifests itself. Prepared with special reference to the average man's needs and is a practical review of all motor troubles because it is based on the actual experience of an automobile engineer-mechanic with the mechanism the chart describes. It enables the non-technical owner or operator of a Ford car to locate engine derangements by systematic search, guided by easily recognized symptoms instead of by guesswork. It makes the average owner independent of the roadside repair shop when touring. Must be seen to be appreciated. Size 25x38 inches. Printed on heavy bond paper. Price . . . . . **35 cents**

CHART. LUBRICATION OF THE MOTOR CAR CHASSIS. Compiled by VICTOR W. PAGÉ, M.E.

This chart presents the plan view of a typical six-cylinder chassis of standard design and all parts are clearly indicated that demand oil, also the frequency with which they must be lubricated and the kind of oil to use. A practical chart for all interested in motor-car maintenance. Size 24x38 inches. Price . . . . . **35 cents**

CHART. LOCATION OF CARBURETION TROUBLES MADE EASY. Compiled by VICTOR W. PAGÉ, M.E.

This chart shows all parts of a typical pressure feed fuel supply system and gives causes of trouble, how to locate defects and means of remedying them. Size 24x38 inches. Price . . . . . **35 cents**

CHART. LOCATION OF IGNITION SYSTEM TROUBLES MADE EASY. Compiled by VICTOR W. PAGÉ, M.E.

In this diagram all parts of a typical double ignition system using battery and magneto current are shown, and suggestions are given for readily finding ignition troubles and eliminating them when found. Size 24x38 inches. Price . . . . . **35 cents**

CHART. LOCATION OF COOLING AND LUBRICATION SYSTEM FAULTS. Compiled by VICTOR W. PAGÉ, M.E.

This composite diagram shows a typical automobile power plant using pump circulated water-cooling system and the most popular lubrication method. Gives suggestions for curing all overheating and loss of power faults due to faulty action of the oiling or cooling group. Size 24x38 inches. Price . . . . . **35 cents**

CHART. LOCATION OF STARTING AND LIGHTING SYSTEM FAULTS.

The most complete chart yet devised, showing all parts of the modern automobile starting, lighting and ignition systems, giving instructions for systematic location of all faults in wiring, lamps, motor or generator, switches and all other units. Invaluable to motorists, chauffeurs and repairmen. Size 24x38 inches. Price . **35 cents**

CHART. MOTORCYCLE TROUBLES MADE EASY. Compiled by VICTOR W. PAGÉ, M.E.

A chart showing sectional view of a single-cylinder gasoline engine. This chart simplifies location of all power-plant troubles. A single-cylinder motor is shown for simplicity. It outlines distinctly all parts liable to give trouble and also details the derangements apt to interfere with smooth engine operation. This chart will prove of value to all who have to do with the operation, repair or sale of motorcycles. No details omitted. Size 30x20 inches. Price . . . . . **35 cents**

AVIATION

A B C OF AVIATION. By Major Victor W. Pagé.

This book describes the basic principles of aviation, tells how a balloon or dirigible is made and why it floats in the air. Describes how an airplane flies. It shows in detail the different parts of an airplane, what they are and what they do. Describes all types of airplanes and how they differ in construction; as well as detailing the advantages and disadvantages of different types of aircraft. It includes a complete dictionary of aviation terms and clear drawings of leading airplanes. The reader will find simple instructions for unpacking, setting up, and rigging airplanes. A full description of airplane control principles is given and methods of flying are discussed at length.

This book answers every question one can ask about modern aircraft, their construction and operation. A self-educator on aviation without an equal. 274 pages. 130 specially made illustrations with 7 plates. Price **$2.50**

AVIATION ENGINES—DESIGN; CONSTRUCTION; REPAIR. By Major Victor W. Pagé, A.S., S.C.U.S.R.

This treatise, written by a recognized authority on all of the practical aspects of internal combustion engine construction, maintenance, and repair, fills the need as no other book does. The matter is logically arranged; all descriptive matter is simply expressed and copiously illustrated, so that anyone can understand airplane engine operation and repair even if without previous mechanical training. This work is invaluable for anyone desiring to become an aviator or aviation mechanic. The latest rotary types, such as the Gnome Monosoupape, and LeRhone, are fully explained, as well as the recently developed Vee and radial types. The subjects of carburetion, ignition, cooling, and lubrication also are covered in a thorough manner. The chapters on repair and maintenance are distinctive and found in no other book on this subject. Not a technical book, but a practical, easily understood work of reference for all interested in aeronautical science. 589 pages. 253 illustrations. Price, net **$3.00**

GLOSSARY OF AVIATION TERMS — ENGLISH-FRENCH; FRENCH-ENGLISH. By Major Victor W. Pagé, A.S., S.C.U.S.R., and Lieut. Paul Montariol, of the French Flying Corps.

A complete glossary of practically all terms used in aviation, having lists in both French and English with equivalents in either language. Price, net . . **$1.00**

APPLIED AERODYNAMICS. By G. P. Thompson.

This is a scientific and mathematical treatise that has a special appeal to the student and engineer who are seeking exact information on the aerodynamics of heavier-than-air craft and data on airplane design testing. This book gives an up-to-date presentation of the existing state of Aeronautical Science. In addition to a very full discussion of the qualities which determine the speed and rate of climb of an aeroplane and the method by which they can be calculated, special attention is paid to stability —a problem now fairly well understood, and to controllability—our knowledge of which is at present in a much more elementary state. Attention is directed to the numerous directions in which further information is required, especially in the form of full-scale experiments. 312 pages (7 x 10). Illustrated with over 142 Diagrams and Graphic Charts. Price **$12.50**

AVIATION CHART—LOCATION OF AIRPLANE POWER PLANT TROUBLES MADE EASY. By Major Victor W. Pagé, A.S., S.C.U.S.R.

A large chart outlining all parts of a typical airplane power plant, showing the points where trouble is apt to occur and suggesting remedies for the common defects. Intended especially for aviators and aviation mechanics on school and field duty. Price . . . . . **35 cents**

BRAZING AND SOLDERING

BRAZING AND SOLDERING. By James F. Hobart.

The only book that shows you just how to handle any job of brazing or soldering that comes along; it tells you what mixture to use, how to make a furnace if you need one. Full of valuable kinks. The fifth edition of this book has just been published, and to it much new matter and a large number of tested formulæ for all kinds of solders and fluxes have been added. Illustrated. . . . . **35 cents**

SOLDERING AND BRAZING. By Raymond Francis Yates.

This treatise gives all the necessary "kinks" that will enable one to accomplish successful soldering. If a mechanic has not succeeded in his soldering, this book may tell him just what he needs to produce good work—something that he may heretofore have forgotten. Price . . . . . **75 cents**

CHARTS

MODERN SUBMARINE CHART.

A cross-section view, showing clearly and distinctly all the interior of a Submarine of the latest type. You get more information from this chart, about the construction and operation of a Submarine, than in any other way. No details omitted—everything is accurate and to scale. All the machinery and devices fitted in a modern Submarine Boat are shown. . . . . **35 cents**

BOX CAR CHART.

A chart showing the anatomy of a box car, having every part of the car numbered and its proper name given in a reference list. . . . . **35 cents**

GONDOLA CAR CHART.

A chart showing the anatomy of a gondola car, having every part of the car numbered and its proper reference name given in a reference list. . . . . **35 cents**

PASSENGER-CAR CHART.

A chart showing the anatomy of a passenger-car, having every part of the car numbered and its proper name given in a reference list. . . . . **35 cents**

STEEL HOPPER BOTTOM COAL CAR.

A chart showing the anatomy of a steel Hopper Bottom Coal Car, having every part of the car numbered and its proper name given in a reference list. . . . . **35 cents**

TRACTIVE POWER CHART.

A chart whereby you can find the tractive power or drawbar pull of any locomotive without making a figure. Shows what cylinders are equal, how driving wheels and steam pressure affect the power. What sized engine you need to exert a given drawbar pull or anything you desire in this line. . . . . **50 cents**

HORSE-POWER CHART

Shows the horse-power of any stationary engine without calculation. No matter what the cylinder diameter of stroke, the steam pressure of cut-off, the revolutions, or whether condensing or non-condensing, it's all there. Easy to use, accurate, and saves time and calculations. Especially useful to engineers and designers. **50 cents**

BOILER ROOM CHART. By Geo. L. Fowler.

A chart—size 14x28 inches—showing in isometric perspective the mechanisms belonging in a modern boiler room. The various parts are shown broken or removed, so that the internal construction is fully illustrated. Each part is given a reference number, and these, with the corresponding name, are given in a glossary printed at the sides. . . . . **35 cents**

CHEMISTRY

HOW TO MAKE AND USE A SMALL CHEMICAL LABORATORY. By Raymond Francis Yates.

The treatise covers all of the essentials of elementary chemistry. The law of definite proportions, solutions, crystalloids, colloids, electrolysis, etc., are explained. The second part of the book is devoted to chemical and electro-chemical experiments. Only those experiments that will tend to broaden the reader's knowledge of chemistry in general have been chosen. Price . . . . . **75 cents**

CONCRETE

JUST PUBLISHED—CONCRETE WORKERS' REFERENCE BOOKS. A SERIES OF POPULAR HANDBOOKS FOR CONCRETE USERS. Prepared by A. A. Houghton. . . . . Each **75 cents**

The author, in preparing this Series, has not only treated on the usual types of construction, but explains and illustrates molds and systems that are not patented, but which are equal in value and often superior to those restricted by patents. These molds are very easily and cheaply constructed and embody simplicity, rapidity of operation, and the most successful results in the molded concrete. Each of these Twelve books is fully illustrated, and the subjects are exhaustively treated in plain English.

CONCRETE WALL FORMS. By A. A. Houghton.

A new automatic wall clamp is illustrated with working drawings. Other types of wall forms, clamps, separators, etc., are also illustrated and explained. (No. 1 of Series) . . . . . **75 cents**

CONCRETE FLOORS AND SIDEWALKS. By A. A. Houghton.

The molds for molding squares, hexagonal and many other styles of mosaic floor and sidewalk blocks are fully illustrated and explained. (No. 2 of Series) . . **75 cents**

PRACTICAL CONCRETE SILO CONSTRUCTION. By A. A. Houghton.

Complete working drawings and specifications are given for several styles of concrete silos, with illustrations of molds for monolithic and block silos. The tables, data, and information presented in this book are of the utmost value in planning and constructing all forms of concrete silos. (No. 3 of Series) . . . . . **75 cents**

MOLDING CONCRETE CHIMNEYS, SLATE AND ROOF TILES. By A. A. Houghton.

The manufacture of all types of concrete slate and roof tile is fully treated. Valuable data on all forms of reinforced concrete roofs are contained within its pages. The construction of concrete chimneys by block and monolithic systems is fully illustrated and described. A number of ornamental designs of chimney construction with molds are shown in this valuable treatise. (No. 4 of Series.) . . . . . **75 cents**

MOLDING AND CURING ORNAMENTAL CONCRETE. By A. A. Houghton.

The proper proportions of cement and aggregates for various finishes, also the method of thoroughly mixing and placing in the molds, are fully treated. An exhaustive treatise on this subject that every concrete worker will find of daily use and value (No. 5 of Series.) . . . . . **75 cents**

CONCRETE MONUMENTS, MAUSOLEUMS AND BURIAL VAULTS. By A. A. Houghton.

The molding of concrete monuments to imitate the most expensive cut stone is explained in this treatise, with working drawings of easily built molds. Cutting inscriptions and designs are also fully treated. (No. 6 of Series.) . . . **75 cents**

MOLDING CONCRETE BATHTUBS, AQUARIUMS AND NATATORIUMS. By A. A. HOUGHTON.

Simple molds and instruction are given for molding many styles of concrete bathtubs, swimming-pools, etc. These molds are easily built and permit rapid and successful work. (No. 7 of Series.) . . . . . **75 cents**

CONCRETE BRIDGES, CULVERTS AND SEWERS. By A. A. HOUGHTON.

A number of ornamental concrete bridges with illustrations of molds are given. A collapsible center or core for bridges, culverts and sewers is fully illustrated with detailed instructions for building. (No. 8 of Series.) . . . . . **75 cents**

CONSTRUCTING CONCRETE PORCHES. By A. A. HOUGHTON.

A number of designs with working drawings of molds are fully explained so anyone can easily construct different styles of ornamental concrete porches without the purchase of expensive molds. (No. 9 of Series.) . . . . . **75 cents**

MOLDING CONCRETE FLOWER-POTS, BOXES, JARDINIERES, ETC. By A. A. HOUGHTON.

The molds for producing many original designs of flower-pots, urns, flower-boxes, jardinieres, etc., are fully illustrated and explained, so the worker can easily construct and operate same. (No. 10 of Series.) . . . . . **75 cents**

MOLDING CONCRETE FOUNTAINS AND LAWN ORNAMENTS. By A. A. HOUGHTON.

The molding of a number of designs of lawn seats, curbing, hitching posts, pergolas, sun dials and other forms of ornamental concrete for the ornamentation of lawns and gardens, is fully illustrated and described. (No. 11 of Series) . . . . . **75 cents**

CONCRETE FROM SAND MOLDS. By A. A. HOUGHTON.

A Practical Work treating on a process which has heretofore been held as a trade secret by the few who possessed it, and which will successfully mold every and any class of ornamental concrete work. The process of molding concrete with sand molds is of the utmost practical value, possessing the manifold advantages of a low cost of molds, the ease and rapidity of operation, perfect details to all ornamental designs, density and increased strength of the concrete, perfect curing of the work without attention and the easy removal of the molds regardless of any undercutting the design may have. 192 pages. Fully illustrated. Price **$2.00**

ORNAMENTAL CONCRETE WITHOUT MOLDS. By A. A. HOUGHTON.

The process for making ornamental concrete without molds has long been held as a secret, and now, for the first time, this process is given to the public. The book reveals the secret and is the only book published which explains a simple, practical method whereby the concrete worker is enabled, by employing wood and metal templates of different designs, to mold or model in concrete any Cornice, Archivolt, Column, Pedestal, Base Cap, Urn or Pier in a monolithic form—right upon the job. These may be molded in units or blocks, and then built up to suit the specifications demanded. This work is fully illustrated, with detailed engravings. Price . **$2.00**

CONCRETE FOR THE FARM AND IN THE SHOP. By H. COLIN CAMPBELL, C.E., E.M.

A new book illustrating and describing in plain, simple language many of the numerous applications of concrete within the range of the home worker. Among the subjects treated are:

Principles of reinforcing; methods of protecting concrete so as to insure proper hardening; home-made mixers; mixing by hand and machine; form construction, described and illustrated by drawings and photographs; construction of concrete walls and fences; concrete fence posts; concrete gate posts; corner posts; clothes line posts; grape arbor posts; tanks; troughs; cisterns; hog wallows; feeding floors and barnyard pavements; foundations; well curbs and platforms; indoor floors; sidewalks; steps; concrete hotbeds and cold frames; concrete slab roofs; walls for buildings; repairing leaks in tanks and cisterns, etc., etc. A number of convenient and practical tables for estimating quantities, and some practical examples, are also given. (5 x 7). 149 pages, 51 illustrations. Price **$1.00**

POPULAR HANDBOOK FOR CEMENT AND CONCRETE USERS. By MYRON H. LEWIS.

This is a concise treatise of the principles and methods employed in the manufacture and use of cement in all classes of modern works. The author has brought together in this work all the salient matter of interest to the user of concrete and its many diversified products. The matter is presented in logical and systematic order, clearly written, fully illustrated and free from involved mathematics. Everything of value to the concrete user is given, including kinds of cement employed in construction, concrete architecture, inspection and testing, waterproofing, coloring and painting, rules, tables, working and cost data. The book comprises thirty-three chapters, 430 pages, 126 illustrations. Price **$3.00**

WATERPROOFING CONCRETE. By MYRON H. LEWIS.

Modern Methods of Waterproofing Concrete and Other Structures. A condensed statement of the Principles, Rules, and Precautions to be Observed in Waterproofing and Dampproofing Structures and Structural Materials. Price . . . . **75 cents**

DICTIONARIES

STANDARD ELECTRICAL DICTIONARY. By T. O'CONOR SLOANE.

An indispensable work to all interested in electrical science. Suitable alike for the student and professional. A practical handbook of reference containing definitions in about 5000 distinct words, terms and phrases. The definitions are terse and concise and include every term used in electrical science. Recently issued. An entirely new edition. Should be in the possession of all who desire to keep abreast with the progress of this branch of science. Complete, concise and convenient. Nearly 800 pages. Nearly 500 illustrations. New Revised and Enlarged Edition. Price **$5.00**

DIES—METAL WORK

DIES: THEIR CONSTRUCTION AND USE FOR THE MODERN WORKING OF SHEET METALS. By J. V. WOODWORTH.

A most useful book, and one which should be in the hands of all engaged in the press-working of metals; treating on the Designing, Constructing, and Use of Tools, Fixtures and Devices, together with the manner in which they should be used in the Power Press, for the cheap and rapid production of the great variety of sheet-metal articles now in use. It is designed as a guide to the production of sheet-metal parts at the minimum of cost with the maximum of output. The hardening and tempering of Press tools and the classes of work which may be produced to the best advantage by the use of dies in the power press are fully treated. Its 505 illustrations show dies, press fixtures and sheet-metal working devices, the descriptions of which are so clear and practical that all metal-working mechanics will be able to understand how to design, construct and use them. Many of the dies and press fixtures treated were either constructed by the author or under his supervision. Others were built by skilful mechanics and are in use in large sheet-metal establishments and machine shops. 6th Edition. 400 pages, 523 illustrations. Price **$3.50**

PUNCHES, DIES AND TOOLS FOR MANUFACTURING IN PRESSES. By J. V. WOODWORTH.

This work is a companion volume to the author's elementary work entitled "Dies, Their Construction and Use." It does not go into the details of die-making to the extent of the author's previous book, but gives a comprehensive review of the field of operations carried on by presses. A large part of the information given has been drawn from the author's personal experience. It might well be termed an Encyclopedia of Die-Making, Punch-Making, Die-Sinking, Sheet-Metal Working, and Making of Special Tools, Subpresses, Devices and Mechanical Combinations for Punching, Cutting, Bending, Forming, Piercing, Drawing, Compressing and Assembling Sheet-Metal Parts, and also Articles of other Materials in Machine Tools. 3rd Edition. 483 pages, 702 illustrations. Price **$4.50**

DRAWING—SKETCHING PAPER

PRACTICAL PERSPECTIVE. By Richards and Colvin.

Shows just how to make all kinds of mechanical drawings in the only practical perspective isometric. Makes everything plain so that any mechanic can understand a sketch or drawing in this way. Saves time in the drawing room, and mistakes in the shops. Contains practical examples of various classes of work. 4th Edition. **75 cents**

LINEAR PERSPECTIVE SELF-TAUGHT. By Herman T. C. Kraus.

This work gives the theory and practice of linear perspective, as used in architectural, engineering and mechanical drawings. Persons taking up the study of the subject by themselves will be able, by the use of the instruction given, to readily grasp the subject, and by reasonable practice become good perspective draftsmen. The arrangement of the book is good; the plate is on the left-hand, while the descriptive text follows on the opposite page, so as to be readily referred to. The drawings are on sufficiently large scale to show the work clearly and are plainly figured. There is included a self-explanatory chart which gives all information necessary for the thorough understanding of perspective. This chart alone is worth many times over the price of the book. 2d Revised and enlarged Edition. **$3.00**

SELF-TAUGHT MECHANICAL DRAWING AND ELEMENTARY MACHINE DESIGN. By F. L. Sylvester, M.E., Draftsman, with additions by Erik Oberg, associate editor of "Machinery."

This is a practical treatise on Mechanical Drawing and Machine Design, comprising the first principles of geometric and mechanical drawing, workshop mathematics, mechanics, strength of materials and the calculations and design of machine details. The author's aim has been to adapt this treatise to the requirements of the practical mechanic and young draftsman and to present the matter in as clear and concise a manner as possible. To meet the demands of this class of students, practically all the important elements of machine design have been dealt with, and in addition algebraic formulas have been explained, and the elements of trigonometry treated in the manner best suited to the needs of the practical man. The book is divided into 20 chapters, and in arranging the material, mechanical drawing, pure and simple, has been taken up first, as a thorough understanding of the principles of representing objects facilitates the further study of mechanical subjects. This is followed by the mathematics necessary for the solution of the problems in machine design which are presented later, and a practical introduction to theoretical mechanics and the strength of materials. The various elements entering into machine design, such as cams, gears, sprocket-wheels, cone pulleys, bolts, screws, couplings, clutches, shafting and fly-wheels, have been treated in such a way as to make possible the use of the work as a text-book for a continuous course of study. 333 pages, 218 engravings. Price **$2.50**

A NEW SKETCHING PAPER.

A new specially ruled paper to enable you to make sketches or drawings in isometric perspective without any figuring or fussing. It is being used for shop details as well as for assembly drawings, as it makes one sketch do the work of three, and no workman can help seeing just what is wanted. Pads of 40 sheets, 6x9 inches, **40 cents.** Pads of 40 sheets, 9x12 inches, **75 cents**; 40 sheets, 12x18, Price **$1.50**

ELECTRICITY

ARITHMETIC OF ELECTRICITY. By Prof. T. O'Conor Sloane.

A practical treatise on electrical calculations of all kinds reduced to a series of rules, all of the simplest forms, and involving only ordinary arithmetic; each rule illustrated by one or more practical problems, with detailed solution of each one. This book is classed among the most useful works published on the science of electricity, covering as it does the mathematics of electricity in a manner that will attract the attention of those who are not familiar with algebraical formulas. 22nd Edition. 196 pages. Price **$1.50**

COMMUTATOR CONSTRUCTION. By Wm. Baxter, Jr.

The business end of any dynamo or motor of the direct current type is the commutator. This book goes into the designing, building, and maintenance of commutators, shows how to locate troubles and how to remedy them; everyone who fusses with dynamos needs this. 5th Edition . . . . . **35 cents**

CONSTRUCTION OF A TRANSATLANTIC WIRELESS RECEIVING SET. By L. G. Pacent and T. S. Curtis.

A work for the Radio student who desires to construct and operate apparatus that will permit of the reception of messages from the large stations in Europe with an aerial of amateur proportions. 36 pages. 23 illustrations, cloth. Price . **35 cents**

DYNAMO BUILDING FOR AMATEURS, OR HOW TO CONSTRUCT A FIFTY-WATT DYNAMO. By Arthur J. Weed, Member of N. Y. Electrical Society.

A practical treatise showing in detail the construction of a small dynamo or motor, the entire machine work of which can be done on a small foot lathe. Dimensioned working drawings are given for each piece of machine work, and each operation is clearly described. This machine, when used as a dynamo, has an output of fifty watts; when used as a motor it will drive a small drill press or lathe. It can be used to drive a sewing machine on any and all ordinary work. The book is illustrated with more than sixty original engravings showing the actual construction of the different parts. Among the contents are chapters on: 1. Fifty-Watt Dynamo. 2. Side Bearing Rods. 3. Field Punching. 4. Bearings. 5. Commutator. 6. Pulley. 7. Brush Holders. 8. Connection Board. 9. Armature Shaft. 10. Armature. 11. Armature Winding. 12. Field Winding. 13. Connecting and Starting. Price, cloth, **$1.00**

DESIGN DATA FOR RADIO TRANSMITTERS AND RECEIVERS. By Milton B. Sleeper.

Far from being a collection of formulas, Design Data takes up in proper sequence the problems encountered in planning all types of receiving sets for short, medium and long wave work, and spark coil, transformer and vacuum tube transmitters operating on 200 meters. Tables have been worked out so that values can be found without the use of mathematics. Radio experimenters will find here information which will enable them to have the most modern and efficient equipment. Price . . **75 cents**

DYNAMOS AND ELECTRIC MOTORS AND ALL ABOUT THEM. By Edward Trevert.

This volume gives practical directions for building a two H. P. Dynamo of the Edison type capable of lighting about fifty mazda lamps of the 20-watt size. In addition, it gives directions for building two small electric motors suitable for running sewing machines. The concluding chapter describes the construction of a simple bichromate battery adapted for running electric motors. 96 pages. Fully illustrated with detail drawings. Cloth. Price **$1.00**

ELECTRIC BELLS. By M. B. Sleeper.

A complete treatise for the practical worker in installing, operating, and testing bell circuits, burglar alarms, thermostats, and other apparatus used with electric bells. Both the electrician and the experimenter will find in this book new material which is essential in their work. Tools, bells, batteries, unusual circuits, burglar alarms, annunciators, systems, thermostats, circuit breakers, time alarms, and other apparatus used in bell circuits are described from the standpoints of their application, construction, and repair. The detailed instructions for building the apparatus will appeal to the experimenter particularly. The practical worker will find the chapters on Wiring Calculation of Wire Sizes and Magnet Windings, Upkeep of Systems and the Location of Faults of the greatest value in their work. 124 pages. Fully illustrated. Price . . . . . **75 cents**

EXPERIMENTAL HIGH FREQUENCY APPARATUS — HOW TO MAKE AND USE IT. By THOMAS STANLEY CURTIS.

This book tells you how to build simple high frequency coils for experimental purpose in the home, school laboratory, or on the small lecture platform. The book is really a supplement to the same author's "High Frequency Apparatus." The experimental side only is covered in this volume, which is intended for those who want to build small coils giving up to an eighteen-inch spark. The book contains valuable information for the physics or the manual training teacher who is on the lookout for interesting projects for his boys to build or experiment with. The apparatus is simple, cheap and perfectly safe, and with it some truly startling experiments may be performed. Among the contents are: Induction Coil Outfits Operated on Battery Current. Kicking Coil Apparatus. One-Half Kilowatt Transformer Outfit. Parts and Materials, etc., etc. 69 pages. Illustrated. Price . . . . . **50 cents**

HIGH FREQUENCY APPARATUS, ITS CONSTRUCTION AND PRACTICAL APPLICATION. By THOMAS STANLEY CURTIS.

The most comprehensive and thorough work on this interesting subject ever produced. The book is essentially practical in its treatment and it constitutes an accurate record of the researches of its author over a period of several years, during which time dozens of coils were built and experimented with. The work has been divided into six basic parts. The first two chapters tell the uninitiated reader what the high frequency current is, what it is used for, and how it is produced. The second section, comprising four chapters, describes in detail the principles of the transformer, condenser, spark gap, and oscillation transformer, and covers the main points in the design and construction of these devices as applied to the work in hand. The third section covers the construction of small high frequency outfits designed for experimental work in the home laboratory or in the classroom. The fourth section is devoted to electro-therapeutic and X-Ray apparatus. The fifth describes apparatus for the cultivation of plants and vegetables. The sixth section is devoted to a comprehensive discussion of apparatus of large size for use upon the stage in spectacular productions. The closing chapter, giving the current prices of the parts and materials required for the construction of the apparatus described, is included with a view to expediting the purchase of the necessary goods. The Second Edition includes much new matter along the line of home-made therapeutic outfits for physicians' use. The matter on electro plant culture has also been elaborated upon. Second Revised and Enlarged Edition. 266 pages. New second edition. Fully illustrated. Price . **$3.00**

ELECTRIC WIRING, DIAGRAMS AND SWITCHBOARDS. By NEWTON HARRISON.

A thoroughly practical treatise covering the subject of Electric Wiring in all its branches, including explanations and diagrams which are thoroughly explicit and greatly simplify the subject. Practical, every-day problems in wiring are presented and the method of obtaining intelligent results clearly shown. Only arithmetic is used. Ohm's law is given a simple explanation with reference to wiring for direct and alternating currents. The fundamental principle of drop of potential in circuits is shown with its various applications. The simple circuit is developed with the position of mains, feeders and branches; their treatment as a part of a wiring plan and their employment in house wiring clearly illustrated. Some simple facts about testing are included in connection with the wiring. Molding and conduit work are given careful consideration; and switchboards are systematically treated, built up and illustrated, showing the purpose they serve, for connection with the circuits, and to shunt and compound wound machines. The simple principles of switchboard construction, the development of the switchboard, the connections of the various instruments, including the lightning arrester, are also plainly set forth.

Alternating current wiring is treated, with explanations of the power factor, conditions calling for various sizes of wire, and a simple way of obtaining the sizes for single-phase, two-phase and three-phase circuits. This is the only complete work issued showing and telling you what you should know about direct and alternating current wiring. It is a ready reference. The work is free from advanced technicalities and mathematics, arithmetic being used throughout. It is in every respect a handy, well-written, instructive, comprehensive volume on wiring for the wireman, foreman, contractor, or electrician. 3rd edition, revised and enlarged. 315 pages; 137 illustrations. Price **$2.50**

ELECTRIC TOY MAKING, DYNAMO BUILDING, AND ELECTRIC MOTOR CONSTRUCTION. By Prof. T. O'Conor Sloane.

This work treats of the making at home of electrical toys, electrical apparatus, motors, dynamos and instruments in general, and is designed to bring within the reach of young and old the manufacture of genuine and useful electrical appliances. The work is especially designed for amateurs and young folks.

Thousands of our young people are daily experimenting, and busily engaged in making electrical toys and apparatus of various kinds. The present work is just what is wanted to give the much needed information in a plain, practical manner, with illustrations to make easy the carrying out of the work. 20th Edition. 210 pages, 77 illustrations. Price **$1.50**

ELECTRICIANS' HANDY BOOK. By Prof. T. O'Conor Sloane.

This work is intended for the practical electrician who has to make things go. The entire field of electricity is covered within its pages. Among some of the subjects treated are: The Theory of the Electric Current and Circuit, Electro-Chemistry, Primary Batteries, Storage Batteries, Generation and Utilization of Electric Powers, Alternating Current, Armature Winding, Dynamos and Motors, Motor Generators, Operation of the Central Station Switchboards, Safety Appliances, Distribution of Electric Light and Power, Street Mains, Transformers, Arc and Incandescent Lighting, Electric Measurements, Photometry, Electric Railways, Telephony, Bell-Wiring, Electric-Plating, Electric Heating, Wireless Telegraphy, etc. It contains no useless theory; everything is to the point. It teaches you just what you want to know about electricity. It is the standard work published on the subject. Forty-six chapters, 600 engravings. New 5th Edition, Revised and Enlarged. Price **$4.00**

ELECTRICITY SIMPLIFIED. By Prof. T. O'Conor Sloane.

The object of "Electricity Simplified" is to make the subject as plain as possible and to show what the modern conception of electricity is; to show how two plates of different metal, immersed in acid, can send a message around the globe; to explain how a bundle of copper wire rotated by a steam engine can be the agent in lighting our streets, to tell what the volt, ohm and ampere are, and what high and low tension mean; and to answer the questions that perpetually arise in the mind in this age of electricity. 15th Revised Edition. 218 pages. Illustrated. Price . . **$1.50**

EXPERIMENTAL WIRELESS STATIONS. By P. E. Edelman.

The theory, design, construction and operation is fully treated including Wireless Telephony, Vacuum Tube, and quenched spark systems. The new enlarged edition is just issued and is strictly up to date, correct and complete. This book tells how to make apparatus to not only hear all telephoned and telegraphed radio messages, but also how to make simple equipment that works for transmission over reasonably long distances. Then there is a host of new information included. The first and only book to give you all the recent important radio improvements, some of which have never before been published. This volume anticipates every need of the reader who wants the gist of the art, its principles, simplified calculations, apparatus dimensions, and understandable directions for efficient operation.

Vacuum tube circuits; amplifiers; long-distance sets; loop, coil, and underground receivers; tables of wave-lengths, capacity, inductance; such are a few of the subjects presented in detail that satisfies. It is independent and one of the few that describe *all* modern systems.

Endorsed by foremost instructors for its clear accuracy, preferred by leading amateurs for its dependable designs. The new experimental Wireless Stations is sure to be most satisfactory for your purposes. 27 chapters, 392 pages. 167 illustrations. Price **$3.00**

RADIO TIME SIGNAL RECEIVER. By Austin C. Lescarboura.

This new book, "A Radio Time Signal Receiver," tells you how to build a simple outfit designed expressly for the beginner. You can build the outfits in your own workshop and install them for jewelers either on a one-payment or a rental basis. The apparatus is of such simple design that it may be made by the average amateur mechanic possessing a few ordinary tools. 42 pages. Paper. Price . . **35 cents**

HOUSE WIRING. By Thomas W. Poppe.

This work describes and illustrates the actual installation of Electric Light Wiring, the manner in which the work should be done, and the method of doing it. The book can be conveniently carried in the pocket. It is intended for the Electrician, Helps, and Apprentice. It solves all Wiring Problems and contains nothing that conflicts with the rulings of the National Board of Fire Underwriters. It gives just the information essential to the Successful Wiring of a Building. Among the subjects treated are Locating the Meter. Panel Boards. Switches. Plug Receptacles. Brackets. Ceiling Fixtures. The Meter Connections. The Feed Wires. The Steel Armored Cable System. The Flexible Steel Conduit System. The Ridig Conduit System. A digest of the National Board of Fire Underwriters' rules relating to metallic wiring systems. Various switching arrangements explained and diagrammed. The easiest method or testing the Three- and Four-way circuits explained. The grounding of all metallic wiring systems and the reason for doing so shown and explained. The insulation of the metal parts of lamp fixtures and the reason for the same described and illustrated. 208 pages. 4th Edition, revised and enlarged. 160 illustrations. Flexible cloth. Price **$1.00**

HOW TO BECOME A SUCCESSFUL ELECTRICIAN. By Prof. T. O'Conor Sloane.

Every young man who wishes to become a successful electrician should read this book. It tells in simple language the surest and easiest way to become a successful electrician. The studies to be followed, methods of work, field of operation and the requirement, of the successful electrician are pointed out and fully explained. Every young engineer will find this an excellent stepping stone to more advanced works on electricity which he must master before success can be attained. Many young men become discouraged at the very outstart by attempting to read and study books that are far beyond their comprehension. This book serves as the connecting link between the rudiments taught in the public schools and the real study of electricity. It is interesting from cover to cover. 19th Revised Edition, just issued. 205 pages. Illustrated. Price **$1.50**

RADIO HOOK-UPS. By Milton B. Sleeper.

In this book the best circuits for different instruments and various purposes have been carefully selected and grouped together. All the best circuits for damped and undamped wave receiving sets, buzzer, spark coil and transformer sending equipment, as well as vacuum tube telegraph and telephone transmitters, wavemeters, vacuum tube measuring instruments, audibility meters, etc., are shown in this book. . **75 cents**

STANDARD ELECTRICAL DICTIONARY. By T. O'Conor Sloane.

An indispensable work to all interested in electrical science. Suitable alike for the student and professional. A practical handbook of reference containing definitions of about 5,000 distinct words, terms and phrases. The definitions are terse and concise and include every term used in electrical science. Recently issued. An entirely new edition. Should be in the possession of all who desire to keep abreast with the progress of this branch of science. In its arrangement and typography the book is very convenient. The word or term defined is printed in black-faced type which readily catches the eye, while the body of the page is in smaller but distinct type. The definitions are well worded, and so as to be understood by the non-technical reader. The general plan seems to be to give an exact, concise definition, and then amplify and explain in a more popular way. Synonyms are also given, and references to other words and phrases are made. A very complete and accurate index of fifty pages is at the end of the volume; and as this index contains all synonyms, and as all phrases are indexed in every reasonable combination of words, reference to the proper place in the body of the book is readily made. It is difficult to decide how far a book of this character is to keep the dictionary form, and to what extent it may assume the encyclopedia form. For some purposes, concise, exactly worded definitions are needed; for other purposes, more extended descriptions are required. This book seeks to satisfy both demands, and does it with considerable success. Complete, concise and convenient. 800 pages. Nearly 500 illustrations. New Revised and Enlarged Edition. Price **$5.00**

STORAGE BATTERIES SIMPLIFIED. By Victor W. Pagé, M.S.A.E.

A complete treatise on storage battery operating principles, repairs and applications. The greatly increasing application of storage batteries in modern engineering and mechanical work has created a demand for a book that will consider this subject completely and exclusively. This is the most thorough and authoritative treatise ever published on this subject. It is written in easily understandable, non-technical language so that anyone may grasp the basic principles of storage battery action as well as their practical industrial applications. All electric and gasoline automobiles use storage batteries. Every automobile repairman, dealer or salesman should have a good knowledge of maintenance and repair of these important elements of the motor car mechanism. This book not only tells how to charge, care for and rebuild storage batteries but also outlines all the industrial uses. Learn how they run street cars, locomotives and factory trucks. Get an understanding of the important functions they perform in submarine boats, isolated lighting plants, railway switch and signal systems, marine applications, etc. This book tells how they are used in central station standby service, for starting automobile motors and in ignition systems. Every practical use of the modern storage battery is outlined in this treatise. 208 pages. Fully illustrated. Price $2.00

TELEPHONE CONSTRUCTION, INSTALLATION, WIRING, OPERATION AND MAINTENANCE. By W. H. Radcliffe and H. C. Cushing.

This book is intended for the amateur, the wireman, or the engineer who desires to establish a means of telephonic communication between the rooms of his home, office, or shop. It deals only with such things as may be of use to him rather than with theories.

Gives the principles of construction and operation of both the Bell and Independent instruments; approved methods of installing and wiring them; the means of protecting them from lightning and abnormal currents; their connection together for operation as series or bridging stations; and rules for their inspection and maintenance. Line wiring and the wiring and operation of special telephone systems are also treated.

Intricate mathematics are avoided, and all apparatus, circuits and systems are thoroughly described. The appendix contains definitions of units and terms used in the text. Selected wiring tables, which are very helpful, are also included. Among the subjects treated are Construction, Operation, and Installation of Telephone Instruments; Inspection and Maintenance of Telephone Instruments; Telephone Line Wiring; Testing Telephone Line Wires and Cables; Wiring and Operation of Special Telephone Systems, etc. 2nd Edition, revised and enlarged. 223 pages. 154 illustrations $1.50

WIRELESS TELEGRAPHY AND TELEPHONY SIMPLY EXPLAINED. By Alfred P. Morgan.

This is undoubtedly one of the most complete and comprehensible treatises on the subject ever published, and a close study of its pages will enable one to master all the details of the wireless transmission of messages. The author has filled a long-felt want and has succeeded in furnishing a lucid, comprehensible explanation in simple language of the theory and practice of wireless telegraphy and telephony.

Among the contents are: Introductory; Wireless Transmission and Reception—The Aerial System, Earth Connections—The Transmitting Apparatus, Spark Coils and Transformers, Condensers, Helixes, Spark Gaps, Anchor Gaps, Aerial Switches—The Receiving Apparatus, Detectors, etc.—Tuning and Coupling, Tuning Coils, Loose Couplers, Variable Condensers, Directive Wave Systems—Miscellaneous Apparatus, Telephone Receivers, Range of Stations, Static Interference—Wireless Telephones, Sound and Sound Waves, The Vocal Cords and Ear—Wireless Telephone, How Sounds Are Changed into Electric Waves—Wireless Telephones, The Apparatus—Summary. 154 pages. 156 engravings. Price $1.50

WIRING A HOUSE. By Herbert Pratt.

Shows a house already built; tells just how to start about wiring it; where to begin; what wire to use; how to run it according to Insurance Rules; in fact, just the information you need. Directions apply equally to a shop. Fourth edition . . 35 cents

ELECTROPLATING

THE MODERN ELECTROPLATER. By Kenneth M. Coggeshall.

This is one of the most complete and practical books on electroplating and allied processes that has been published as a text for the student or professional plater. It is written in simple language and explains all details of electroplating in a concise yet complete manner. It starts at the beginning and gives an elementary outline of electricity and chemistry as relates to plating, then considers shop layout and equipment and gives all the necessary information to do reliable and profitable electroplating in a modern commercial manner. Full instructions are given for the preparation and finishing of the work and formulae and complete directions are included for making all kinds of plating solutions, many of these having been trade secrets until published in this instruction manual. Anyone interested in practical plating and metal finishing will find this book a valuable guide and complete manual of the art. Cloth. 142 illustrations. 276 pages. Price $3.00

FACTORY MANAGEMENT, ETC.

MODERN MACHINE SHOP CONSTRUCTION, EQUIPMENT AND MANAGEMENT. By O. E. Perrigo, M.E.

The only work published that describes the modern machine shop or manufacturing plant from the time the grass is growing on the site intended for it until the finished product is shipped. By a careful study of its thirty-six chapters the practical man may economically build, efficiently equip, and successfully manage the modern machine shop or manufacturing establishment. Just the book needed by those contemplating the erection of modern shop buildings, the rebuilding and reorganization of old ones, or the introduction of modern shop methods, time and cost systems. It is a book written and illustrated by a practical shop man for practical shop men who are too busy to read *theories* and want *facts*. It is the most complete all-around book of its kind ever published. It is a practical book for practical men, from the apprentice in the shop to the president in the office. It minutely describes and illustrates the most simple and yet the most efficient time and cost system yet devised. 384 pages. 219 illustrations. Price $5.00

FUEL

COMBUSTION OF COAL AND THE PREVENTION OF SMOKE. By Wm. M. Barr.

This book has been prepared with special reference to the generation of heat by the combustion of the common fuels found in the United States, and deals particularly with the conditions necessary to the economic and smokeless combustion of bituminous coals in Stationary and Locomotive Steam Boilers.

The presentation of this important subject is systematic and progressive. The arrangement of the book is in a series of practical questions to which are appended accurate answers, which describe in language, free from technicalities, the several processes involved in the furnace combustion of American fuels; it clearly states the essential requisites for perfect combustion, and points out the best methods for furnace construction for obtaining the greatest quantity of heat from any given quality of coal. 5th Edition. Nearly 350 pages, fully illustrated. Price. . . . $1.50

GAS AND OIL ENGINES

THE GASOLINE ENGINE ON THE FARM: ITS OPERATION, REPAIR AND USES. By Xeno W. Putnam.

This is a practical treatise on the Gasoline and Kerosene Engine intended for the man who wants to know just how to manage his engine and how to apply it to all kinds of farm work to the best advantage.

This book abounds with hints and helps for the farm and suggestions for the home and housewife. There is so much of value in this book that it is impossible to adequately describe it in such small space. Suffice to say that it is the kind of a book every farmer will appreciate and every farm home ought to have. Includes selecting the most suitable engine for farm work, its most convenient and efficient installation, with chapters on troubles, their remedies, and how to avoid them. The care and management of the farm tractor in plowing, harrowing, harvesting and road grading are fully covered; also plain directions are given for handling the tractor on the road. Special attention is given to relieving farm life of its drudgery by applying power to the disagreeable small tasks which must otherwise be done by hand. Many home-made contrivances for cutting wood, supplying kitchen, garden, and barn with water, loading, hauling and unloading hay, delivering grain to the bins or the feed trough are included; also full directions for making the engine milk the cows, churn, wash, sweep the house and clean the windows, etc. Very fully illustrated with drawings of working parts and cuts showing Stationary, Portable and Tractor Engines doing all kinds of farm work. All money-making farms utilize power. Learn how to utilize power by reading the pages of this book. It is an aid to the result getter, invaluable to the up-to-date farmer, student, blacksmith, implement dealer and, in fact, all who can apply practical knowledge of stationary gasoline engines or gas tractors to advantage. 530 pages. Nearly 180 engravings. Price **$3.00**

GASOLINE ENGINES: THEIR OPERATION, USE AND CARE. By A. Hyatt Verrill.

The simplest, latest and most comprehensive popular work published on Gasoline Engines, describing what the Gasoline Engine is; its construction and operation; how to install it; how to select it; how to use it and how to remedy troubles encountered. Intended for Owners, Operators and Users of Gasoline Motors of all kinds. This work fully describes and illustrates the various types of Gasoline Engines used in Motor Boats, Motor Vehicles and Stationary Work. The parts, accessories and appliances are described, with chapters on ignition, fuel, lubrication, operation and engine troubles. Special attention is given to the care, operation and repair of motors, with useful hints and suggestions on emergency repairs and makeshifts. A complete glossary of technical terms and an alphabetically arranged table of troubles and their symptoms form most valuable and unique features of this manual. Nearly every illustration in the book is original, having been made by the author. Every page is full of interest and value. A book which you cannot afford to be without. 275 pages. 152 specially made engravings. Price **$2.00**

GAS, GASOLINE, AND OIL ENGINES. By Gardner D. Hiscox.

Just issued, 23d revised and enlarged edition. Every user of a gas engine needs this book. Simple, instructive, and right up-to-date. The only complete work on the subject. Tells all about the running and management of gas, gasoline and oil engines, as designed and manufactured in the United States. Explosive motors for stationary marine and vehicle power are fully treated, together with illustrations of their parts and tabulated sizes, also their care and running are included. Electric ignition by induction coil and jump spark are fully explained and illustrated, including valuable information on the testing for economy and power and the erection of power plants.

The rules and regulations of the Board of Fire Underwriters in regard to the installation and management of gasoline motors are given in full, suggesting the safe installation of explosive motor power. A list of United States Patents issued on gas, gasoline, and oil engines and their adjuncts from 1875 to date is included. 640 pages. 435 engravings. Folding plates. Price **$3.00**

GAS ENGINES AND PRODUCER-GAS PLANTS. By R. E. Mathot, M.E.

This is a practical treatise, setting forth the principles of gas engine and producer design, the selection and installation of an engine, conditions of perfect operation, producer-gas engines and their possibilities; the care of gas engines and producer-gas plants, with a chapter on volatile hydrocarbon and oil engines. A practical guide for the gas engine designer, user and engineer in the construction, selection, purchase, installation, operation and maintenance of gas engines. *Every part of the gas engine is described in detail, tersely, clearly and with a thorough understanding of the requirements of the mechanic.* Recognizing the need of a volume that would assist the gas engine user in understanding the motor upon which he depends for power, the author has discussed the subject without the help of any mathematics. Helpful suggestions as to the purchase of an engine, its installation, care and operation, form a most valuable feature of the book. 6 x 9 inches. Cloth. 314 pages. 152 illustrations. Price . . **$3.00**

GAS ENGINE CONSTRUCTION, OR HOW TO BUILD A HALF-HORSE-POWER GAS ENGINE. By Parsell and Weed.

A practical treatise of 300 pages describing the theory and principles of the action of Gas Engines of various types and the design and construction of a half-horse-power Gas Engine, with illustrations of the work in actual progress, together with the dimensioned working drawings, giving clearly the sizes of the various details; for the student, the scientific investigator, and the amateur mechanic. This book treats of the subject more from the standpoint of practice than that of theory. The principles of operation of Gas Engines are clearly and simply described, and then the actual construction of a half-horse-power engine is taken up, step by step, showing in detail the making of the Gas Engine. 3d Edition. 300 pages. Price **$3.00**

HOW TO RUN AND INSTALL GASOLINE ENGINES. By C. Von Culin.

Revised and enlarged edition just issued. The object of this little book is to furnish a pocket instructor for the beginner, the busy man who uses an engine for pleasure or profit, but who does not have the time or inclination for a technical book, but simply to thoroughly understand how to properly operate, install and care for his own engine. The index refers to each trouble, remedy, and subject alphabetically. Being a quick reference to find the cause, remedy and prevention for troubles, and to become an expert with his own engine. Pocket size. Paper binding. Price . . **25 cents**

GEARING AND CAMS

BEVEL GEAR TABLES. By D. Ag. Engstrom.

A book that will at once commend itself to mechanics and draftsmen. Does away with all the trigonometry and fancy figuring on bevel gears, and makes it easy for anyone to lay them out or make them just right. There are 36 full-page tables that show every necessary dimension for all sizes or combinations you're apt to need. No puzzling, figuring or guessing. Gives placing distance, all the angles (including cutting angles), and the correct cutter to use. A copy of this prepares you for anything in the bevel-gear line. 3d Edition. 66 pages. **$1.50**

CHANGE GEAR DEVICES. By Oscar E. Perrigo.

A practical book for every designer, draftsman, and mechanic interested in the invention and development of the devices for feed changes on the different machines requiring such mechanism. All the necessary information on this subject is taken up, analyzed, classified, sifted, and concentrated for the use of busy men who have not the time to go through the masses of irrelevant matter with which such a subject is usually encumbered and select such information as will be useful to them.

It shows just what has been done, how it has been done, when it was done, and who did it. It saves time in hunting up patent records and re-inventing old ideas. 3rd Edition. 101 pages **$1.50**

DRAFTING OF CAMS. By Louis Rouillion.

The laying out of cams is a serious problem unless you know how to go at it right. This puts you on the right road for practically any kind of cam you are likely to run up against. 3d Edition. . . . . **35 cents**

HYDRAULICS

HYDRAULIC ENGINEERING. By GARDNER D. HISCOX.

A treatise on the properties, power, and resources of water for all purposes. Including the measurement of streams, the flow of water in pipes or conduits; the horse-power of falling water, turbine and impact water-wheels, wave motors, centrifugal, reciprocating and air-lift pumps. With 300 figures and diagrams and 36 practical tables. All who are interested in water-works development will find this book a useful one, because it is an entirely practical treatise upon a subject of present importance, and cannot fail in having a far-reaching influence, and for this reason should have a place in the working library of every engineer. Among the subjects treated are: Historical Hydraulics, Properties of Water, Measurement of the Flow of Streams; Flowing Water Suface Orifices and Nozzles; Flow of Water in Pipes; Siphons of Various Kinds; Dams and Great Storage Reservoirs; City and Town Water Supply; Wells and Their Reinforcement; Air Lift Methods of Raising Water; Artesian Wells, Irrigation of Arid Districts; Water Power; Water-Wheels; Pumps and Pumping Machinery; Reciprocating Pumps; Hydraulic Power Transmission; Hydraulic Mining; Canals; Dredges; Conduits and Pipe Lines; Marine Hydraulics; Tidal and Sea Wave Power, etc. 320 pages. Price **$4.50**

ICE AND REFRIGERATION

POCKETBOOK OF REFRIGERATION AND ICE MAKING. By A. J. WALLIS-TAYLOR.

This is one of the latest and most comprehensive reference books published on the subject of refrigeration and cold storage. It explains the properties and refrigerating effect of the different fluids in use, the management of refrigerating machinery and the construction and insulation of cold rooms with their required pipe surface for different degrees of cold; freezing mixtures and non-freezing brines, temperatures of cold rooms for all kinds of provisions, cold storage charges for all classes of goods, ice making and storage of ice, data and memoranda for constant reference by refrigerating engineers. with nearly one hundred tables containing valuable references to every fact and condition required in the installment and operation of a refrigerating plant. New edition just published. Price **$2.00**

INVENTIONS—PATENTS

INVENTORS' MANUAL, HOW TO MAKE A PATENT PAY.

This is a book designed as a guide to inventors in perfecting their inventions, taking out their patents and disposing of them. It is not in any sense a Patent Solicitor's Circular nor a Patent Broker's Advertisement. No advertisements of any description appear in the work. It is a book containing a quarter of a century's experience of a successful inventor, together with notes based upon the experience of many other inventors.

Among the subjects treated in this work are: How to Invent. How to Secure a Good Patent. Value of Good Invention. How to Exhibit an Invention. How to Interest Capital. How to Estimate the Value of a Patent. Value of Design Patents. Value of Foreign Patents. Value of Small Inventions. Advice on Selling Patents. Advice on the Formation of Stock Companies. Advice on the Formation of Limited Liability Companies. Advice on Disposing of Old Patents. Advice as to Patent Attorneys. Advice as to Selling Agents. Forms of Assignments. License and Contracts. State Laws Concerning Patent Rights. 1900 Census of the United States by Counts of Over 10,000 Population. New revised and enlarged edition. 144 pages. Illustrated. Price **$1.50**

KNOTS

KNOTS, SPLICES AND ROPE WORK. By A. Hyatt Verrill.

This is a practical book giving complete and simple directions for making all the most useful and ornamental knots in common use, with chapters on Splicing, Pointing, Seizing, Serving, etc. This book is fully illustrated with one hundred and fifty original engravings, which show how each knot, tie or splice is formed, and its appearance when finished. The book will be found of the greatest value to Campers, Yachtsmen, Travelers, Boy Scouts, in fact, to anyone having occasion to use or handle rope or knots for any purpose. The book is thoroughly reliable and practical, and is not only a guide, but a teacher. It is the standard work on the subject. Among the contents are: 1. Cordage, Kinds of Rope. Construction of Rope, Parts of Rope Cable and Bolt Rope. Strength of Rope, Weight of Rope. 2. Simple Knots and Bends. Terms Used in Handling Rope. Seizing Rope. 3. Ties and Hitches. 4. Noose, Loops and Mooring Knots. 5. Shortenings, Grommets and Salvages. 6. Lashings, Seizings and Splices. 7. Fancy Knots and Rope Work. 104 pages. 154 original engravings. Price **$1.00**

LATHE WORK

LATHE DESIGN, CONSTRUCTION, AND OPERATION, WITH PRACTICAL EXAMPLES OF LATHE WORK. By Oscar E. Perrigo.

A new revised edition, and the only complete American work on the subject, written by a man who knows not only how work ought to be done, but who also knows how to do it, and how to convey this knowledge to others. It is strictly up-to-date in its descriptions and illustrations. Lathe history and the relations of the lathe to manufacturing are given; also a description of the various devices for feeds and thread cutting mechanisms from early efforts in this direction to the present time. Lathe design is thoroughly discussed, including back gearing, driving cones, thread-cutting gears, and all the essential elements of the modern lathe. The classification of lathes is taken up, giving the essential differences of the several types of lathes including, as is usually understood, engine lathes, bench lathes, speed lathes, forge lathes, gap lathes, pulley lathes, forming lathes, multiple-spindle lathes, rapid-reduction lathes, precision lathes, turret lathes, special lathes, electrically-driven lathes, etc. In addition to the complete exposition on construction and design, much practical matter on lathe installation, care and operation has been incorporated in the enlarged 1915 edition. All kinds of lathe attachments for drilling, milling, etc., are described and complete instructions are given to enable the novice machinist to grasp the art of lathe operation as well as the principles involved in design. A number of difficult machining operations are described at length and illustrated. The new edition has nearly 500 pages and 350 illustrations. Price **$3.00**

LATHE WORK FOR BEGINNERS. By Raymond Francis Yates.

A simple, straightforward text-book for those desiring to learn the operation of a wood-turning or metal-turning lathe. The first chapter tells how to choose a lathe and all of the standard types on the market are described. Simple and more advanced lathe work is thoroughly covered and the operation of all lathe attachments such as millers, grinders, polishers, etc., is described. The treatment starts from the very bottom and leads the reader through to a point where he will be able to handle the larger commercial machines with very little instruction. The last chapter of the book is devoted to things to make on the lathe and includes a model rapid-fire naval gun. This is the only book published in this country that treats lathe work from the standpoint of the amateur mechanic. 162 illustrations. About 250 pages, 12mo. Price **$2.00**

TURNING AND BORING TAPERS. By Fred H. Colvin.

There are two ways to turn tapers; the right way and one other. This treatise has to do with the right way; it tells you how to start the work properly, how to set the lathe, what tools to use and how to use them, and forty and one other little things that you should know. Fifth edition. Price . . . . . **35 cents**

LIQUID AIR

LIQUID AIR AND THE LIQUEFACTION OF GASES. By T. O'CONOR SLOANE.

This book gives the history of the theory, discovery, and manufacture of Liquid Air, and contains an illustrated description of all the experiments that have excited the wonder of audiences all over the country. It shows how liquid air, like water, is carried hundreds of miles and is handled in open buckets. It tells what may be expected from it in the near future.

A book that renders simple one of the most perplexing chemical problems of the century. Startling developments illustrated by actual experiments.

It is not only a work of scientific interest and authority, but is intended for the general reader, being written in a popular style—easily understood by everyone. Third edition. Revised and Enlarged. 394 pages. New Edition. Price . . . **$3.00**

LOCOMOTIVE ENGINEERING

AIR-BRAKE CATECHISM. By ROBERT H. BLACKALL.

This book is a standard text-book. It covers the Westinghouse Air-Brake Equipment, including the No. 5 and the No. 6 E. T. Locomotive Brake Equipment; the K (Quick Service) Triple Valve for Freight Service; and the Cross-Compound Pump. The operation of all parts of the apparatus is explained in detail, and a practical way of finding their peculiarities and defects, with a proper remedy, is given. It contains 2,000 questions with their answers, which will enable any railroad man to pass any examination on the subject of Air Brakes. Endorsed and used by air-brake instructors and examiners on nearly every railroad in the United States. 28th Edition. 411 pages, fully illustrated with colored plates and diagrams. Price **$2.50**

COMBUSTION OF COAL AND THE PREVENTION OF SMOKE. By WM. M. BARR.

This book has been prepared with special reference to the generation of heat by the combustion of the common fuels found in the United States and deals particularly with the conditions necessary to the economic and smokeless combustion of bituminous coal in Stationary and Locomotive Steam Boilers.

Presentation of this important subject is systematic and progressive. The arrangement of the book is in a series of practical questions to which are appended accurate answers, which describe in language free from technicalities the several processes involved in the furnace combustion of American fuels; it clearly states the essential requisites for perfect combustion, and points out the best methods of furnace construction for obtaining the greatest quantity of heat from any given quality of coal. Nearly 350 pages, fully illustrated. Price **$1.50**

DIARY OF A ROUND-HOUSE FOREMAN. By T. S. REILLY.

This is the greatest book of railroad experiences ever published. Containing a fund of information and suggestions along the line of handling men, organizing, etc., that one cannot afford to miss. 158 pages. Price **$1.50**

LINK MOTIONS, VALVES AND VALVE SETTING. By FRED H. COLVIN, Associate Editor of *American Machinist.*

A handy book for the engineer or machinist that clears up the mysteries of valve setting. Shows the different valve gears in use, how they work, and why. Piston and slide valves of different types are illustrated and explained. A book that every railroad man in the motive power department ought to have. Contains chapters on Locomotive Link Motion, Valve Movements, Setting Slide Valves, Analysis by Diagrams, Modern Practice, Slip of Block, Slice Valves, Piston Valves, Setting Piston Valves, Joy-Allen Valve Gear, Walschaert Valve Gear, Gooch Valve Gear, Alfree-Hubbell Valve Gear, etc., etc. 3rd Edition, 101 pages. Fully illustrated. Price **75** cents

LOCOMOTIVE BOILER CONSTRUCTION. By Frank A. Kleinhans.

The construction of boilers in general is treated, and, following this, the locomotive boiler is taken up in the order in which its various parts go through the shop. Shows all types of boilers used; gives details of construction; practical facts, such as life of riveting, punches and dies; work done per day, allowance for bending and flanging sheets, and other data. Including the recent Locomotive Boiler Inspection Laws and Examination Questions with their answers for Government Inspectors. Contains chapters on Laying Out Work; Flanging and Forging; Punching; Shearing; Plate Planing; General Tables; Finishing Parts; Bending; Machinery Parts; Riveting; Boiler Details; Smoke Box Details; Assembling and Calking; Boiler Shop Machinery, etc., etc.

There isn't a man who has anything to do with boiler work, either new or repair work, who doesn't need this book. The manufacturer, superintendent, foreman, and boiler worker—all need it. No matter what the type of boiler, you'll find a mint of information that you wouldn't be without. 451 pages, 334 illustrations, five large folding plates. Price **$3.50**

LOCOMOTIVE BREAKDOWNS AND THEIR REMEDIES. By Geo. L. Fowler. Revised by Wm. W. Wood, Air-Brake Instructor. Just issued. Revised pocket edition.

It is out of the question to try and tell you about every subject that is covered in this pocket edition of Locomotive Breakdowns. Just imagine all the common troubles that an engineer may expect to happen some time, and then add all of the unexpected ones, troubles that could occur, but that you have never thought about, and you will find that they are all treated with the very best methods of repair. Walschaert Locomotive Valve Gear Troubles, Electric Headlight Troubles, as well as Questions and Answers on the Air Brake are all included. 293 pages. 8th Revised Edition. Fully illustrated. **$1.50**

PRACTICAL INSTRUCTOR AND REFERENCE BOOK FOR LOCOMOTIVE FIREMEN AND ENGINEERS. By Chas. F. Lockhart.

An entirely new book on the Locomotive. It appeals to every railroad man, as it tells him how things are done and the right way to do them. Written by a man who has had years of practical experience in locomotive shops and on the road firing and running. The information given in this book cannot be found in any other similar treatise. Eight hundred and fifty-one questions with their answers are included, which will prove specially helpful to those preparing for examination. Practical information on: The Construction and Operation of Locomotives; Breakdowns and their Remedies; Air Brakes and Valve Gears. Rules and Signals are handled in a thorough manner. As a book of reference it cannot be excelled. The book is divided into six parts, as follows: 1. The Fireman's Duties. 2. General Description of the Locomotive. 3. Breakdowns and their Remedies. 4. Air Brakes. 5. Extracts from Standard Rules. 6. Questions for Examination. The 851 questions have been carefully selected and arranged. These cover the examinations required by the different railroads. 368 pages. 88 illustrations. Price **$2.50**

PREVENTION OF RAILROAD ACCIDENTS, OR SAFETY IN RAILROADING. By George Bradshaw.

This book is a heart-to-heart talk with Railroad Employees, dealing with facts, not theories, and showing the men in the ranks, from every-day experience, how accidents occur and how they may be avoided. The book is illustrated with seventy original photographs and drawings showing the safe and unsafe methods of work. No visionary schemes, no ideal pictures. Just plain facts and Practical Suggestions are given. Every railroad employee who reads the book is a better and safer man to have in railroad service. It gives just the information which will be the means of preventing many injuries and deaths. All railroad employees should procure a copy; read it, and do your part in preventing accidents. 169 pages. Pocket size. Fully illustrated. Price . . . . . **50 cents**

TRAIN RULE EXAMINATIONS MADE EASY. By G. E. Collingwood.

This is the only practical work on train rules in print. Every detail is covered, and puzzling points are explained in simple, comprehensive language, making it a practical treatise for the Train Dispatcher, Engineman, Trainman, and all others who have to do with the movements of trains. Contains complete and reliable information of the Standard Code of Train Rules for single track. Shows Signals in Colors, as used on the different roads. Explains fully the practical application of train orders, giving a clear and definite understanding of all orders which may be used. The meaning and necessity for certain rules are explained in such a manner that the student may know beyond a doubt the rights conferred under any orders he may receive or the action required by certain rules. As nearly all roads require trainmen to pass regular examinations, a complete set of examination questions, with their answers, are included. These will enable the student to pass the required examinations with credit to himself and the road for which he works. Second Edition revised. 234 pages. Fully illustrated with Train Signals in Colors. Price **$1.50**

THE WALSCHAERT AND OTHER MODERN RADIAL VALVE GEARS FOR LOCOMOTIVES. By Wm. W. Wood.

If you would thoroughly understand the Walschaert Valve Gear you should possess a copy of this book, as the author takes the plainest form of a steam engine—a stationary engine in the rough, that will only turn its crank in one direction—and from it builds up—with the reader's help—a modern locomotive equipped with the Walschaert Valve Gear, complete. The points discussed are clearly illustrated; two large folding plates that show the positions of the valves of both inside or outside admission type, as well as the links and other parts of the gear when the crank is at nine different points in its revolution, are especially valuable in making the movement clear. These employ sliding cardboard models which are contained in a pocket in the cover.

The book is divided into five general divisions, as follows: 1. Analysis of the gear. 2. Designing and erecting the gear. 3. Advantages of the gear. 4. Questions and answers relating to the Walschaert Valve Gear. 5. Setting valves with the Walschaert Valve Gear; the three primary types of locomotive valve motion; modern radial valve gears other than the Walschaert; the Hobart All-free Valve and Valve Gear, with questions and answers on breakdowns; the Baker-Pilliod Valve Gear; the Improved Baker-Pilliod Valve Gear, with questions and answers on breakdowns.

The questions with full answers given will be especially valuable to firemen and engineers in preparing for an examination for promotion. 245 pages. Fully illustrated. Third Revised New Edition. Price **$2.50**

WESTINGHOUSE E-T AIR-BRAKE INSTRUCTION POCKET BOOK. By Wm. W. Wood, Air-Brake Instructor.

Here is a book for the railroad man, and the man who aims to be one. It is without doubt the only complete work published on the Westinghouse E-T Locomotive Brake Equipment. Written by an Air-Brake Instructor who knows just what is needed. It covers the subject thoroughly. Everything about the New Westinghouse Engine and Tender Brake Equipment, including the standard No. 5 and the Perfected No. 6 style of brake, is treated in detail. Written in plain English and profusely illustrated with Colored Plates, which enable one to trace the flow of pressures throughout the entire equipment. The best book ever published on the Air Brake. Equally good for the beginner and the advanced engineer. Will pass anyone through any examination. It informs and enlightens you on every point. Indispensable to every engineman and trainman.

Contains examination questions and answers on the E-T equipment. Covering what the E-T Brake is. How it should be operated. What to do when defective. Not a question can be asked of the engineman up for promotion, on either the No. 5 or the No. 6 E-T equipment, that is not asked and answered in the book. If you want to thoroughly understand the E-T equipment get a copy of this book. It covers every detail. Makes Air-Brake troubles and examinations easy. Second Revised and Enlarged Edition. Price **$2.50**

MACHINE-SHOP PRACTICE

AMERICAN TOOL MAKING AND INTERCHANGEABLE MANUFACTURING. By J. V. Woodworth.

A "shoppy" book, containing no theorizing, no problematical or experimental devices, there are no badly proportioned and impossible diagrams, no catalogue cuts, but a valuable collection of drawings and descriptions of devices, the rich fruits of the author's own experience. In its 500-odd pages the one subject only, Tool Making, and whatever relates thereto, is dealt with. The work stands without a rival. It is a complete practical treatise on the art of American Tool Making and system of interchangeable manufacturing as carried on to-day in the United States. In it are described and illustrated all of the different types and classes of small tools, fixtures, devices, and special appliances which are in general use in all machine-manufacturing and metal-working establishments where economy, capacity, and interchangeability in the production of machined metal parts are imperative. The science of jig making is exhaustively discussed, and particular attention is paid to drill jigs, boring, profiling and milling fixtures and other devices in which the parts to be machined are located and fastened within the contrivances. All of the tools, fixtures, and devices illustrated and described have been or are used for the actual production of work, such as parts of drill presses, lathes, patented machinery, typewriters, electrical apparatus, mechanical appliances, brass goods, composition parts, mould products, sheet metal articles, drop-forgings, jewelry, watches, medals, coins, etc. 3rd Edition. 531 pages. Price **$4.50**

MACHINE-SHOP ARITHMETIC. By Colvin-Cheney.

This is an arithmetic of the things you have to do with daily. It tells you plainly about: how to find areas in figures; how to find surface or volume of balls or spheres; handy ways for calculating; about compound gearing; cutting screw threads on any lathe; drilling for taps; speeds of drills; taps, emery wheels, grindstones, milling cutters, etc.; all about the Metric system with conversion tables; properties of metals; strength of bolts and nuts; decimal equivalent of an inch. All sorts of machine-shop figuring and 1,001 other things, any one of which ought to be worth more than the price of this book to you, and it saves you the trouble of bothering the boss. 7th edition. 131 pages. Price . . . . . **75 cents**

MODERN MACHINE-SHOP CONSTRUCTION, EQUIPMENT AND MANAGEMENT. By Oscar E. Perrigo.

The only work published that describes the Modern Shop or Manufacturing Plant from the time the grass is growing on the site intended for it until the finished product is shipped. Just the book needed by those contemplating the erection of modern shop buildings, the rebuilding and reorganization of old ones, or the introduction of Modern Shop Methods, time and cost systems. It is a book written and illustrated by a practical shop man for practical shop men who are too busy to read theories and want facts. It is the most complete all-round book of its kind ever published.. 384 pages. 219 original and specially-made illustrations. Revised and Enlarged Edition. Price **$5.00**

"SHOP KINKS." By Robert Grimshaw.

A book of 400 pages and 222 illustrations, being entirely different from any other book on machine-shop practice. Departing from conventional style, the author avoids universal or common shop usage and limits his work to showing special ways of doing things better, more cheaply and more rapidly than usual. As a result the advanced methods of representative establishments of the world are placed at the disposal of the reader. This book shows the proprietor where large savings are possible, and how products may be improved. To the employee it holds out suggestions that, properly applied, will hasten his advancement. No shop can afford to be without it. It bristles with valuable wrinkles and helpful suggestions. It will benefit all, from apprentice to proprietor. 5th edition. Price **$3.00**

THREADS AND THREAD-CUTTING. By Colvin and Stabel.

This clears up many of the mysteries of thread-cutting, such as double and triple threads, internal threads, catching threads, use of hobs, etc. Contains a lot of useful hints and several tables. 4th edition. Price . . . . . **35 cents**

THE WHOLE FIELD OF MECHANICAL MOVEMENTS COVERED BY MR. HISCOX'S TWO BOOKS

We publish two books by Gardner D. Hiscox that will keep you from "inventing" things that have been done before, and suggest ways of doing things that you have not thought of before. Many a man spends time and money, pondering over some mechanical problem, only to learn, after he has solved the problem, that the same thing has been accomplished and put in practice by others long before. Time and money spent in an effort to accomplish what has already been accomplished are time and money LOST. The whole field of mechanics, every known mechanical movement, and practically every device is covered by these two books. If the thing you want has been invented, it is illustrated in them. If it hasn't been invented, then you'll find in them the nearest things to what you want, some movements or devices that will apply in your case, perhaps; or which will give you a key from which to work. No book or set of books ever published is of more real value to the Inventor, Draftsman, or practical Mechanic than the two volumes described below.

MECHANICAL MOVEMENTS, POWERS, AND DEVICES. By GARDNER D. HISCOX.

This is a collection of 1,890 engravings of different mechanical motions and appliances, accompanied by appropriate text, making it a book of great value to the inventor, the draftsman, and to all readers with mechanical tastes. The book is divided into eighteen sections or chapters, in which the subject-matter is classified under the following heads: Mechanical Powers; Transmission of Power; Measurement of Power; Steam Power; Air Power Appliances; Electric Power and Construction; Navigation and Roads; Gearing; Motion and Devices; Controlling Motion; Horological; Mining; Mill and Factory Appliances; Construction and Devices; Drafting Devices; Miscellaneous Devices, etc. 15th edition enlarged. 400 octavo pages. Price . **$4.00**

MECHANICAL APPLIANCES, MECHANICAL MOVEMENTS AND NOVELTIES OF CONSTRUCTION. By GARDNER D. HISCOX.

This is a supplementary volume to the one upon mechanical movements. Unlike the first volume, which is more elementary in character, this volume contains illustrations and descriptions of many combinations of motions and of mechanical devices and appliances found in different lines of machinery, each device being shown by a line drawing with a description showing its working parts and the method of operation. From the multitude of devices described and illustrated might be mentioned, in passing, such items as conveyors and elevators, Prony brakes, thermometers, various types of boilers, solar engines, oil-fuel burners, condensers, evaporators, Corliss and other valve gears, governors, gas engines, water motors of various descriptions, airships, motors and dynamos, automobile and motor bicycles, railway lock signals, car couplers, link and gear motions, ball bearings, breech block mechanism for heavy guns, and a large accumulation of others of equal importance. 1,000 specially made engravings. 396 octavo pages. 4th Edition enlarged. Price **$4.00**

SHOP PRACTICE FOR HOME MECHANICS. By RAYMOND FRANCIS YATES.

A thoroughly practical and helpful treatment prepared especially for those who have had little or no experience in shop work. The introduction is given over to an elementary explanation of the fundamentals of mechanical science. This is followed by several chapters on the use of small tools and mechanical measuring instruments. Elementary and more advanced lathe work is treated in detail and directions given for the construction of a number of useful shop appliances. Drilling and reaming, heat treatment of tool steel, special lathe operations, pattern making, grinding, and grinding operations, home foundry work, etc., make up the rest of the volume. The book omits nothing that will be of use to those who use tools or to those who wish to learn the use of tools The great number of clear engravings (over 300) add tremendously to the text matter and to the value of the volume as a visual instructor. Octavo, 320 pages. 309 engravings. Price **$3.00**

MACHINE-SHOP TOOLS AND SHOP PRACTICE. By W. H. VANDERVOORT.

A work of 552 pages and 672 illustrations, describing in every detail the construction, operation, and manipulation of both hand and machine tools. Includes chapters on filing, fitting, and scraping surfaces; on drills, reamers, taps, and dies; the lathe and its tools; planers, shapers, and their tools; milling machines and cutters; gear cutters and gear cutting; drilling machines and drill work; grinding machines and their work; hardening and tempering; gearing, belting, and transmission machinery; useful data and tables. 7th Edition. 552 pages. 672 illustrations. Price **$4.50**

COMPLETE PRACTICAL MACHINIST. By JOSHUA ROSE.

The new, twentieth revised and enlarged edition is now ready. This is one of the best-known books on machine-shop work, and written for the practical workman in the language of the workshop. It gives full, practical instructions on the use of all kinds of metal-working tools, both hand and machine, and tells how the work should be properly done. It covers lathe work, vise work, drills and drilling, taps and dies, hardening and tempering, the making and use of tools, tool grinding, marking out work, machine tools, etc. No machinist's library is complete without this volume. 20th Edition. 547 pages. 432 illustrations. Price **$3.00**

HENLEY'S ENCYCLOPEDIA OF PRACTICAL ENGINEERING AND ALLIED TRADES. Edited by JOSEPH G. HORNER, A.M.I.Mech.E.

This book covers the entire practice of Civil and Mechanical Engineering. The best known experts in all branches of engineering have contributed to these volumes. The Cyclopedia is admirably well adapted to the needs of the beginner and the self-taught practical man, as well as the mechanical engineer, designer, draftsman, shop superintendent, foreman and machinist.

It is a modern treatise in five volumes. Handsomely bound in half morocco, each volume containing nearly 500 pages, with thousands of illustrations, including diagrammatic and sectional drawings with full explanatory details. Five large volumes. Price **$30.00**

MODEL MAKING Including Workshop Practice, Design and Construction of Models. Edited by RAYMOND F. YATES. Editor of "Everyday Engineering Magazine."

This book will help you to become a better mechanic. It is full of suggestions for those who like to make things, amateur and professional alike. It has been prepared especially for men with mechanical hobbies. Some may be engineers, machinists, jewelers, pattern makers, office clerks or bank presidents. Men from various walks of life have a peculiar interest in model engineering. MODEL MAKING will be a help and an inspiration to such men. It tells them "how-to-do" and "how-to-make" things in simple, understandable terms. Not only this, it is full of good, clear working drawings and photographs of the models and apparatus described. Each model has been constructed and actually works if it is made according to directions. 379 pages. 300 illustrations. Price **$3.00**

ABRASIVES AND ABRASIVE WHEELS. By FRED B. JACOBS.

A new book for everyone interested in abrasives or grinding. A careful reading of the book will not only make mechanics better able to use abrasives intelligently, but it will also tell the shop superintendent of many short cuts and efficiency-increasing kinks. The economic advantages in using large grinding wheels are fully explained, together with many other things that will tend to give the superintendent or workman a keen insight into abrasive engineering. 340 pages. 174 illustrations. This is an indispensable book for every machinist. Price **$3.00**

HOME MECHANIC'S WORKSHOP COMPANION. By ANDREW JACKSON, JR.

This treatise includes a compilation of useful suggestions that cannot fail to interest the handy man, and while it is not intended for mechanical experts or scientists, it will prove to be a veritable store of information for anyone who desires to rig up a small shop where odd jobs can be carried on. Price . . . . . **75 cents**

MARINE ENGINEERING

THE NAVAL ARCHITECT'S AND SHIPBUILDER'S POCKETBOOK. Of Formulæ, Rules, and Tables and Marine Engineer's and Surveyor's Handy Book of Reference. By CLEMENT MACKROW and LLOYD WOOLLARD.

The twelfth revised and enlarged edition of this most comprehensive work has just been issued. It is absolutely indispensable to all engaged in the Shipbuilding Industry, as it condenses into a compact form all data and formulæ that are ordinarily required. The book is completely up to date, including among other subjects a section on Aeronautics. 760 pages, limp leather binding. Price **$6.00**

MARINE ENGINES AND BOILERS—THEIR DESIGN AND CONSTRUCTION. THE STANDARD BOOK. By DR. G. BAUER, LESLIE S. ROBERTSON and S. BRYAN DONKIN.

In the words of Dr. Bauer, the present work owes its origin to an oft felt want of a condensed treatise embodying the theoretical and practical rules used in designing marine engines and boilers. The fact that the original German work was written by the chief engineer of the famous Vulcan Works, Stettin, is in itself a guarantee that this book is in all respects thoroughly up-to-date, and that it embodies all the information which is necessary for the design and construction of the highest types of marine engines and boilers. It may be said that the motive power which Dr. Bauer has placed in the fast German liners that have been turned out of late years from the Stettin Works represent the very best practice in marine engineering of the present day. The work is clearly written, thoroughly systematic, theoretically sound; while the character of the plans, drawings, tables, and statistics is without reproach. The illustrations are careful reproductions from actual working drawings, with some well-executed photographic views of completed engines and boilers. Fifth impression. 744 pages. 550 illustrations, and numerous tables. Cloth. Price . . . **$10.00**

MANUAL TRAINING

ECONOMICS OF MANUAL TRAINING. By LOUIS ROUILLION.

The only book published that gives just the information needed by all interested in Manual Training, regarding Buildings, Equipment, and Supplies. Shows exactly what is needed for all grades of the work from the Kindergarten to the High and Normal School. Gives itemized lists of everything used in Manual Training Work and tells just what it ought to cost. Also shows where to buy supplies, etc. Contains 174 pages, and is fully illustrated. 2d edition. Price **$2.00**

MOTOR BOATS

MOTOR BOATS AND BOAT MOTORS. By VICTOR W. PAGÉ AND A. C. LEITCH.

All who are interested in motor boats, either as owners, builders or repairmen, will find this latest work a most comprehensive treatise on the design, construction, operation and repair of motor boats and their power plants. It is really two complete books in one cover as it consists of two parts, each complete in itself. Part One deals with THE HULL AND ITS FITTINGS, Part Two considers THE POWER PLANT AND ITS AUXILIARIES. A valuable feature of this book is the complete set of dimensioned working drawings detailing the construction of five different types of boats ranging from a 16-foot shallow draft, tunnel stern general utility craft to a 25-foot cabin cruiser. These plans are by A. C. Leitch, a practical boat builder and expert naval architect, and are complete in every particular. Full instructions are given for the selection of a power plant and its installation in the hull. Valuable advice is included on boat and engine operation and latest designs of motors are described and illustrated. The instructions for overhauling boat and engine are worth many times the small cost of the book. It is a comprehensive work of reference for all interested in motor boating in any of its phases. Octavo. Cloth. 372 illustrations. 524 pages. Price . . . . . **$4.00.**

MOTORCYCLES

MOTORCYCLES AND SIDE CARS, THEIR CONSTRUCTION, MANAGEMENT AND REPAIR. By Victor W. Pagé, M.E.

The only complete work published for the motorcyclist and repairman. Describes fully all leading types of machines, their design, construction, maintenance, operation and repair. This treatise outlines fully the operation of two- and four-cycle power plants and all ignition, carburetion and lubrication systems in detail. Describes all representative types of free engine clutches, variable speed gears and power transmission systems. Gives complete instructions for operating and repairing all types. Considers fully electric self-starting and lighting systems, all types of spring frames and spring forks and shows leading control methods. For those desiring technical information a complete series of tables and many formulæ to assist in designing are included. The work tells how to figure power needed to climb grades, overcome air resistance and attain high speeds. It shows how to select gear ratios for various weights and powers, how to figure braking efficiency required, gives sizes of belts and chains to transmit power safely, and shows how to design sprockets, belt pulleys, etc. This work also includes complete formulæ for figuring horse-power, shows how dynamometer tests are made, defines relative efficiency of air- and water-cooled engines, plain and anti-friction bearings and many other data of a practical, helpful, engineering nature. Remember that you get this information in addition to the practical description and instructions which alone are worth several times the price of the book. 2nd Edition Revised and Enlarged. 693 pages. 371 specially made illustrations. Cloth. Price $3.00

WHAT IS SAID OF THIS BOOK:

"Here is a book that should be in the cycle repairer's kit."—*American Blacksmith.*

"The best way for any rider to thoroughly understand his machine, is to get a copy of this book; it is worth many times its price."—*Pacific Motorcyclist.*

PATTERN MAKING

PRACTICAL PATTERN MAKING. By F. W. Barrows.

This book, now in its second edition, is a comprehensive and entirely practical treatise on the subject of pattern making, illustrating pattern work in both wood and metal, and with definite instructions on the use of plaster of Paris in the trade. It gives specific and detailed descriptions of the materials used by pattern makers and describes the tools, both those for the bench and the more interesting machine tools; having complete chapters on the Lathe, the Circular Saw, and the Band Saw. It gives many examples of pattern work, each one fully illustrated and explained with much detail. These examples, in their great variety, offer much that will be found of interest to all pattern makers, and especially to the younger ones, who are seeking information on the more advanced branches of their trade.

In this second edition of the work will be found much that is new, even to those who have long practiced this exacting trade. In the description of patterns as adapted to the Moulding Machine many difficulties which have long prevented the rapid and economical production of castings are overcome; and this great, new branch of the trade is given much space. Stripping plate and stool plate work and the less expensive vibrator, or rapping plate work, are all explained in detail.

Plain, everyday rules for lessening the cost of patterns, with a complete system of cost keeping, a detailed method of marking, applicable to all branches of the trade, with complete information showing what the pattern is, its specific title, its cost, date of production, material of which it is made, the number of pieces and core-boxes, and its location in the pattern safe, all condensed into a most complete card record, with cross index.

The book closes with an original and practical method for the inventory and valuation of patterns. 2nd Edition. Containing nearly 350 pages and 170 illustrations. Price $2.50

PERFUMERY

PERFUMES AND COSMETICS, THEIR PREPARATION AND MANUFACTURE. By G. W. Askinson, Perfumer.

A comprehensive treatise, in which there has been nothing omitted that could be of value to the perfumer or manufacturer of toilet preparations. Complete directions for making handkerchief perfumes, smelling-salts, sachets, fumigating pastilles; preparations for the care of the skin, the mouth, the hair, cosmetics, hair dyes and other toilet articles are given, also a detailed description of aromatic substances; their nature, tests of purity, and wholesale manufacture, including a chapter on synthetic products, with formulas for their use. A book of general, as well as professional interest, meeting the wants not only of the druggist and perfume manufacturer, but also of the general public. Fourth Edition much enlarged and brought up-to-date. Nearly 400 pages, illustrated. Price **$5.00**

WHAT IS SAID OF THIS BOOK:

"The most satisfactory work on the subject of Perfumery that we have ever seen.

"We feel safe in saying that here is a book on Perfumery that will not disappoint you, for it has practical and excellent formulæ that are within your ability to prepare readily.

"We recommend the volume as worthy of confidence, and say that no purchaser will be disappointed in securing from its pages good value for its cost, and a large dividend on the same, even if he should use but one per cent of its working formulæ. There is money in it for every user of its information."—*Pharmaceutical Record.*

PLUMBING

MECHANICAL DRAWING FOR PLUMBERS. By R. M. Starbuck.

A concise, comprehensive and practical treatise on the subject of mechanical drawing in its various modern applications to the work of all who are in any way connected with the plumbing trade. Nothing will so help the plumber in estimating and in explaining work to customers and workmen as a knowledge of drawing, and to the workman it is of inestimable value if he is to rise above his position to positions of greater responsibility. Among the chapters contained are: 1. Value to plumber of knowledge of drawing; tools required and their use; common views needed in mechanical drawing. 2. Perspective versus mechanical drawing in showing plumbing construction. 3. Correct and incorrect methods in plumbing drawing; plan and elevation explained. 4. Floor and cellar plans and elevation; scale drawings; use of triangles. 5. Use of triangles; drawing of fittings, traps, etc. 6. Drawing plumbing elevations and fittings. 7. Instructions in drawing plumbing elevations. 8. The drawing of plumbing fixtures; scale drawings. 9. Drawings of fixtures and fittings. 10. Inking of drawings. 11. Shading of drawings. 12. Shading of drawings. 13. Sectional drawings; drawing of threads. 14. Plumbing elevations from architect's plan. 15. Elevations of separate parts of the plumbing system. 16. Elevations from the architect's plans. 17. Drawings of detail plumbing connections. 18. Architect's plans and plumbing elevations of residences. 19. Plumbing elevations of residence (continued): plumbing plans for cottage. 20. Plumbing elevations: roof connections. 21. Plans and plumbing elevations for six-flat building. 22. Drawing of various parts of the plumbing system; use of scales. 23. Use of architect's scales. 24. Special features in the illustrations of country plumbing. 25. Drawing of wrought-iron piping, valves, radiators, coils, etc. 26. Drawing of piping to illustrate heating systems. 150 illustrations. Price **$2.00**

MODERN PLUMBING ILLUSTRATED. By R. M. Starbuck.

This book represents the highest standard of plumbing work. It has been adopted and used as a reference book by the United States Government, in its sanitary work in Cuba, Porto Rico, and the Philippines, and by the principal Boards of Health of the United States and Canada.

It gives connections, sizes and working data for all fixtures and groups of fixtures. It is helpful to the master plumber in demonstrating to his customers and in figuring work. It gives the mechanic and student quick and easy access to the best modern plumbing practice. Suggestions for estimating plumbing construction are contained in its pages. This book represents, in a word, the latest and best up-to-date practice and should be in the hands of every architect, sanitary engineer and plumber who wishes to keep himself up to the minute on this important feature of construction. Contains following chapters, each illustrated with a full-page plate: Kitchen sink, laundry tubs, vegetable wash sink; lavatories, pantry sinks, contents of marble slabs; bath tub, foot and sitz bath, shower bath; water closets, venting of water closets; low-down water closets, water closets operated by flush valves, water closet range; slop sink, urinals, the bidet; hotel and restaurant sink, grease trap; refrigerators, safe wastes, laundry waste, lines of refrigerators, bar sinks, soda fountain sinks; horse stall, frost-proof water closets; connections for S traps, venting; connections for drum traps; soil pipe connections; supporting of soil pipe; main trap and fresh air inlet; floor drains and cellar drains, subsoil drainage; water closets and floor connections; local venting; connections for bath rooms; connections for bath rooms, continued; connections for bath rooms, continued; connections for bath rooms, continued; examples of poor practice; roughing work ready for test; testing of plumbing system; method of continuous venting; continuous venting for two-floor work; continuous venting for two lines of fixtures on three or more floors; continuous venting of water closets; plumbing for cottage house; construction for cellar piping; plumbing for residence, use of special fittings; plumbing for two-flat house; plumbing for apartment building, plumbing for double apartment building; plumbing for office building; plumbing for public toilet rooms; plumbing for public toilet rooms, continued; plumbing for bath establishment; plumbing for engine house, factory plumbing; automatic flushing for schools, factories, etc.; use of flushing valves; urinals for public toilet rooms; the Durham system, the destruction of pipes by electrolysis; construction of work without use of lead; automatic sewage lift; automatic sump tank; country plumbing; construction of cesspools; septic tank and automatic sewage siphon; country plumbing; water supply for country house; thawing of water mains and service by electricity; double boilers; hot water supply of large buildings; automatic control of hot water tank; suggestion for estimating plumbing construction. 407 octavo pages, fully illustrated by 58 full-page engravings. Third, revised and enlarged edition just issued. Price . **$5.00**

STANDARD PRACTICAL PLUMBING. By R. M. Starbuck.

A complete practical treatise of 450 pages covering the subject of Modern Plumbing in all its branches, a large amount of space being devoted to a very complete and practical treatment of the subject of Hot Water Supply and Circulation and Range Boiler Work. Its thirty chapters include about every phase of the subject one can think of, making it an indispensable work to the master plumber, the journeyman plumber, and the apprentice plumber, containing chapters on: the plumber's tools; wiping solder; composition and use; joint wiping; lead work; traps; siphonage of traps; venting; continuous venting; house sewer and sewer connections; house drain; soil piping, roughing; main trap and fresh air inlet; floor, yard, cellar drains, rain leaders, etc.; fixture wastes; water closets; ventilation; improved plumbing connections; residence plumbing; plumbing for hotels, schools, factories, stables, etc.; modern country plumbing; filtration of sewage and water supply; hot and cold supply; range boilers; circulation; circulating pipes; range boiler problems; hot water for large buildings; water lift and its use; multiple connections for hot water boilers; heating of radiation by supply system; theory for the plumber; drawing for the plumber. Fully illustrated by 347 engravings. Price **$3.50**

RECIPE BOOK

HENLEY'S TWENTIETH CENTURY BOOK OF RECIPES, FORMULAS AND PROCESSES. Edited by GARDNER D. HISCOX.

The most valuable Techno-chemical Formula Book published, including over 10,000 selected scientific, chemical, technological, and practical recipes and processes.

This is the most complete Book of Formulas ever published, giving thousands of recipes for the manufacture of valuable articles for everyday use. Hints, Helps, Practical Ideas, and Secret Processes are revealed within its pages. It covers every branch of the useful arts and tells thousands of ways of making money, and is just the book everyone should have at his command.

Modern in its treatment of every subject that properly falls within its scope, the book may truthfully be said to present the very latest formulas to be found in the arts and industries, and to retain those processes which long experience has proven worthy of a permanent record. To present here even a limited number of the subjects which find a place in this valuable work would be difficult. Suffice to say that in its pages will be found matter of intense interest and immeasurably practical value to the scientific amateur and to him who wishes to obtain a knowledge of the many processes used in the arts, trades and manufacture, a knowledge which will render his pursuits more instructive and remunerative. Serving as a reference book to the small and large manufacturer and supplying intelligent seekers with the information necessary to conduct a process, the work will be found of inestimable worth to the Metallurgist, the Photographer, the Perfumer, the Painter, the Manufacturer of Glues, Pastes, Cements, and Mucilages, the Compounder of Alloys, the Cook, the Physician, the Druggist, the Electrician, the Brewer, the Engineer, the Foundryman, the Machinist, the Potter, the Tanner, the Confectioner, the Chiropodist, the Manicure, the Manufacturer of Chemical Novelties and Toilet Preparations, the Dyer, the Electroplater, the Enameler, the Engraver, the Provisioner, the Glass Worker, the Goldbeater, the Watchmaker, the Jeweler, the Hat Maker, the Ink Manufacturer, the Optician, the Farmer, the Dairyman, the Paper Maker, the Wood and Metal Worker, the Chandler and Soap Maker, the Veterinary Surgeon, and the Technologist in general.

A mine of information, and up-to-date in every respect. A book which will prove of value to EVERYONE, as it covers every branch of the Useful Arts. Every home needs this book; every office, every factory, every store, every public and private enterprise — EVERYWHERE — should have a copy. 800 pages. Cloth Bound. Price **$4.00**

WHAT IS SAID OF THIS BOOK:

"Your Twentieth Century Book of Recipes, Formulas, and Processes duly received. I am glad to have a copy of it, and if I could not replace it, money couldn't buy it. It is the best thing of the sort I ever saw." (Signed) M. E. TRUX, Sparta, Wis.

"There are few persons who would not be able to find in the book some single formula that would repay several times the cost of the book."—*Merchants' Record and Show Window.*

"I purchased your book 'Henley's Twentieth Century Book of Recipes, Formulas and Processes' about a year ago and it is worth its weight in *gold.*"—WM. H. MURRAY, Bennington, Vt.

"THE BOOK WORTH THREE HUNDRED DOLLARS"

"On close examination of your 'Twentieth Century Receipt Book,' I find it to be a very valuable and useful book with the very best of practical information obtainable. The price of the book, $4.00, is very small in comparison to the benefits which one can obtain from it. I consider the book worth fully three hundred dollars to anyone." —DR. A. C. SPETTS, New York.

"ONE OF THE WORLD'S MOST USEFUL BOOKS"

"Some time ago, I got one of your 'Twentieth Century Books of Formulas' and have made my living from it ever since. I am alone since my husband's death with two small children to care for and am trying so hard to support them. I have customers who take from me Toilet Articles I put up, following directions given in the book, and I have found every one of them to be fine."—MRS. J. H. MCMAKEN, West Toledo, Ohio.

RUBBER

RUBBER HAND STAMPS AND THE MANIPULATION OF INDIA RUBBER. By T. O'Conor Sloane.

This book gives full details on all points, treating in a concise and simple manner the elements of nearly everything it is necessary to understand for a commencement in any branch of the India Rubber Manufacture. The making of all kinds of Rubber Hand Stamps, Small Articles of India Rubber, U. S. Government Composition, Dating Hand Stamps, the Manipulation of Sheet Rubber, Toy Balloons, India Rubber Solutions, Cements, Blackings, Renovating Varnish, and Treatment for India Rubber Shoes, etc.; the Hektograph Stamp Inks, and Miscellaneous Notes, with a Short Account of the Discovery, Collection and Manufacture of India Rubber, are set forth in a manner designed to be readily understood, the explanations being plain and simple. Including a chapter on Rubber Tire Making and Vulcanizing; also a chapter on the uses of rubber in Surgery and Dentistry. Third revised and enlarged edition. 175 pages. Illustrated **$1.50**

SAWS

SAW FILING AND MANAGEMENT OF SAWS. By Robert Grimshaw.

A practical hand-book on filing, gumming, swaging, hammering, and the brazing of band saws, the speed, work, and power to run circular saws, etc. A handy book for those who have charge of saws, or for those mechanics who do their own filing, as it deals with the proper shape and pitches of saw teeth of all kinds and gives many useful hints and rules for gumming, setting, and filing, and is a practical aid to those who use saws for any purpose. Complete tables of proper shape, pitch, and saw teeth as well as sizes and number of teeth of various saws are included. Fourth edition, revised and enlarged. Illustrated. Price **$1.50**

SCREW CUTTING

THREADS AND THREAD-CUTTING. By Colvin and Stable.

This clears up many of the mysteries of thread-cutting, such as double and triple threads, internal threads, catching threads, use of hobs, etc. Contains a lot of useful hints and several tables. Fourth Edition. Price . . . . . **35 cents**

STEAM ENGINEERING

MODERN STEAM ENGINEERING IN THEORY AND PRACTICE. By Gardner D. Hiscox.

This is a complete and practical work issued for Stationary Engineers and Firemen, dealing with the care and management of boilers, engines, pumps, superheated steam, refrigerating machinery, dynamos, motors, elevators, air compressors, and all other branches with which the modern engineer must be familiar. Nearly 200 questions with their answers on steam and electrical engineering, likely to be asked by the Examining Board, are included.

Among the chapters are: Historical: steam and its properties; appliances for the generation of steam; types of boilers; chimney and its work; heat economy of the feed water; steam pumps and their work; incrustation and its work; steam above atmospheric pressure; flow of steam from nozzles; superheated steam and its work; adiabatic expansion of steam; indicator and its work; steam engine proportions; slide valve engines and valve motion; Corliss engine and its valve gear; compound engine and its theory; triple and multiple expansion engine; steam turbine; refrigeration; elevators and their management; cost of power; steam engine troubles; electric power and electric plants. 487 pages. 405 engravings. 3d Edition. . . . **$3.50**

AMERICAN STATIONARY ENGINEERING. By W. E. Crane.

This book begins at the boiler room and takes in the whole power plant. A plain talk on every-day work about engines, boilers, and their accessories. It is not intended to be scientific or mathematical. All formulas are in simple form so that anyone understanding plain arithmetic can readily understand any of them. The author has made this the most practical book in print; has given the results of his years of experience, and has included about all that has to do with an engine room or a power plant. You are not left to guess at a single point. You are shown clearly what to expect under the various conditions; how to secure the best results; ways of preventing "shut downs" and repairs; in short, all that goes to make up the requirements of a good engineer, capable of taking charge of a plant. It's plain enough for practical men and yet of value to those high in the profession.

A partial list of contents is: The boiler room, cleaning boilers, firing, feeding; pumps, inspection and repair; chimneys, sizes and cost; piping; mason work; foundations; testing cement; pile driving; engines, slow and high speed; valves; valve setting; Corliss engines, setting valves, single and double eccentric; air pumps and condensers; different types of condensers; water needed; lining up; pounds; pins not square in crosshead or crank; engineers' tools; pistons and piston rings; bearing metal; hardened copper; drip pipes from cylinder jackets; belts, how made, care of; oils; greases; testing lubricants; rules and tables, including steam tables; areas of segments; squares and square roots; cubes and cube root; areas and circumferences of circles. Notes on: Brick work; explosions; pumps; pump valves; heaters, economizers; safety valves; lap, lead, and clearance. Has a complete examination for a license, etc., etc. Third edition. 311 pages. 131 Illustrations. Price . . . **$2.50**

ENGINE RUNNER'S CATECHISM. By Robert Grimshaw.

A practical treatise for the stationary engineer, telling how to erect, adjust, and run the principal steam engines in use in the United States. Describing the principal features of various special and well-known makes of engines: Temper Cut-off, Shipping and Receiving Foundations, Erecting and Starting, Valve Setting, Care and Use, Emergencies, Erecting and Adjusting Special Engines.

The questions asked throughout the catechism are plain and to the point, and the answers are given in such simple language as to be readily understood by anyone. All the instructions given are complete and up-to-date; and they are written in a popular style, without any technicalities or mathematical formulæ. The work is of a handy size for the pocket, clearly and well printed, nicely bound, and profusely illustrated.

To young engineers this catechism will be of great value, especially to those who may be preparing to go forward to be examined for certificates of competency; and to engineers generally it will be of no little service, as they will find in this volume more really practical and useful information than is to be found anywhere else within a like compass. 387 pages. Seventh edition. Price **$2.00**

HORSE-POWER CHART.

Shows the horse-power of any stationary engine without calculation. No matter what the cylinder diameter of stroke, the steam pressure of cut-off, the revolutions, or whether condensing or non-condensing, it's all there. Easy to use, accurate, and saves time and calculations. Especially useful to engineers and designers. **50 cents**

STEAM ENGINE CATECHISM. By Robert Grimshaw.

This unique volume of 413 pages is not only a catechism on the question and answer principle, but it contains formulas and worked-out answers for all the Steam problems that appertain to the operation and management of the Steam Engine. Illustrations of various valves and valve gear with their principles of operation are given. Thirty-four Tables that are indispensable to every engineer and fireman that wishes to be progressive and is ambitious to become master of his calling are within its pages. It is a most valuable instructor in the service of Steam Engineering. Leading engineers have recommended it as a valuable educator for the beginner as well as a reference book for the engineer. It is thoroughly indexed for every detail. Every essential question on the Steam Engine with its answer is contained in this valuable work. Sixteenth edition. Price **$2.00**

STEAM ENGINEER'S ARITHMETIC. By Colvin-Cheney.

A practical pocket-book for the steam engineer. Shows how to work the problems of the engine room and shows "why." Tells how to figure horse-power of engines and boilers; area of boilers; has tables of areas and circumferences; steam tables; has a dictionary of engineering terms. Puts you on to all of the little kinks in figuring whatever there is to figure around a power plant. Tells you about the heat unit; absolute zero; adiabatic expansion; duty of engines; factor of safety; and a thousand and one other things; and everything is plain and simple—not the hardest way to figure, but the easiest. Second Edition. . . . . **75 cents**

STEAM ENGINE TROUBLES. By H. Hamkens.

It is safe to say that no book has ever been published which gives the practical engineer such valuable and comprehensive information on steam engine design and troubles.

Not only does it describe the troubles the principal parts of steam engines are subject to; it contrasts good design with bad, points out the most suitable material for certain parts, and the most approved construction of the same; it gives directions for correcting existing evils by following which *breakdowns* and *costly accidents* can be avoided. Just look into the nature of the information this book gives on the following subjects. There are descriptions of cylinders, valves, pistons, frames, pillow blocks and other bearings, connecting rods, wristplates, dashpots, reachrods, valve gears, governors, piping, throttle and emergency valves, safety stops, fly-wheels, oilers, etc. If there is any trouble with these parts, the book gives you the reasons and tells how to remedy them.

The principal considerations in the building of foundations are given with the size, area and weight required for the same, also the setting of templets and lining up, and a complete account of the *erection* and "*breaking in*" of new engines in the language of the man on the job.

Contains special chapters on: I. Cylinders. II. Valves. III. Piping and Separators. IV. Throttle and Emergency Valves. V. Pistons. VI. Frames. VII. Bearings. VIII. Connecting Rods. IX. Hookrods. X. Dashpots. XI. Governors. XII. Releasing Gears. XIII. Wristplates and Valve Motions. XIV. Rodends and Bonnets. XV. Oilers. XVI. Receivers. XVII. Foundations. XVIII. Erection. XIX. Valve-Setting. XX. Operation. 284 pages. 276 illustrations. Price **$2.50**

STEAM HEATING AND VENTILATION

PRACTICAL STEAM, HOT-WATER HEATING AND VENTILATION. By A. G. King.

This book is the standard and latest work published on the subject and has been prepared for the use of all engaged in the business of steam, hot-water heating, and ventilation. It is an original and exhaustive work. Tells how to get heating contracts, how to install heating and ventilating apparatus, the best business methods to be used, with "Tricks of the Trade" for shop use. Rules and data for estimating radiation and cost and such tables and information as make it an indispensable work for everyone interested in steam, hot-water heating, and ventilation. It describes all the principal systems of steam, hot-water, vacuum, vapor, and vacuum-vapor heating, together with the new accelerated systems of hot-water circulation, including chapters on up-to-date methods of ventilation and the fan or blower system of heating and ventilation. Containing chapters on: I. Introduction. II. Heat. III. Evolution of artificial heating apparatus. IV. Boiler surface and settings. V. The chimney flue. VI. Pipe and fittings. VII. Valves, various kinds. VIII. Forms of radiating surfaces. IX. Locating of radiating surfaces. X. Estimating radiation. XI. Steam-heating apparatus. XII. Exhaust-steam heating. XIII. Hot-water heating. XIV. Pressure systems of hot-water work. XV. Hot-water appliances. XVI. Greenhouse heating. XVII. Vacuum vapor and vacuum exhaust heating. XVIII. Miscellaneous heating. XIX. Radiator and pipe connections. XX. Ventilation. XXI. Mechanical ventilation and hot-blast heating. XXII. Steam appliances. XXIII. District heating. XXIV. Pipe and boiler covering. XXV. Temperature regulation and heat control. XXVI. Business methods. XXVII. Miscellaneous. XXVIII. Rules, tables, and useful information. 402 pages. 300 detailed engravings. Third Edition—Revised. Price **$3.50**

500 PLAIN ANSWERS TO DIRECT QUESTIONS ON STEAM, HOT-WATER, VAPOR AND VACUUM HEATING PRACTICE. By ALFRED G. KING.

This work, just off the press, is arranged in question and answer form; it is intended as a guide and text-book for the younger, inexperienced fitter and as a reference book for all fitters. This book tells "how" and also tells "why." No work of its kind has ever been published. It answers all the questions regarding each method or system that would be asked by the steam fitter or heating contractor, and may be used as a text or reference book, and for examination questions by Trade Schools or Steam Fitters' Associations. Rules, data, tables and descriptive methods are given, together with much other detailed information of daily practical use to those engaged in or interested in the various methods of heating. Valuable to those preparing for examinations. Answers every question asked relating to modern Steam, Hot-Water, Vapor and Vacuum Heating. Among the contents are: The Theory and Laws of Heat. Methods of Heating. Chimneys and Flues. Boilers for Heating. Boiler Trimmings and Settings. Radiation. Steam Heating. Boiler, Radiator and Pipe Connections for Steam Heating. Hot Water Heating. The Two-Pipe Gravity System of Hot Water Heating. The Circuit System of Hot Water Heating. The Overhead System of Hot Water Heating. Boiler, Radiator and Pipe Connections for Gravity Systems of Hot Water Heating. Accelerated Hot Water Heating. Expansion Tank Connections. Domestic Hot Water Heating. Valves and Air Valves. Vacuum Vapor and Vacuo-Vapor Heating. Mechanical Systems of Vacuum Heating. Non-Mechanical Vacuum Systems. Vapor Systems. Atmospheric and Modulating Systems. Heating Greenhouses. Information, Rules and Tables. 214 pages, 127 illustrations. Octavo. Cloth. Price **$2.00**

STEEL

STEEL: ITS SELECTION, ANNEALING, HARDENING, AND TEMPERING. By E. R. MARKHAM.

This book tells how to select, and how to work, temper, harden, and anneal steel for everything on earth. It doesn't tell how to temper one class of tools and then leave the treatment of another kind of tool to your imagination and judgment, but it gives careful instructions for every detail of every tool, whether it be a tap, a reamer or just a screw-driver. It tells about the tempering of small watch springs, the hardening of cutlery, and the annealing of dies. In fact, there isn't a thing that a steel worker would want to know that isn't included. It is the standard book on selecting, hardening, and tempering all grades of steel. Among the chapter headings might be mentioned the following subjects: Introduction; the workman; steel; methods of heating; heating tool steel; forging; annealing; hardening baths; baths for hardening; hardening steel; drawing the temper after hardening; examples of hardening; pack hardening; case hardening; spring tempering; making tools of machine steel; special steels; steel for various tools, causes of trouble; high speed steels, etc. 400 pages. Very fully illustrated. Fourth Edition. Price **$3.00**

HARDENING, TEMPERING, ANNEALING, AND FORGING OF STEEL. INCLUDING HEAT TREATMENT OF MODERN ALLOY STEELS. By J. V. WOODWORTH.

A new work treating in a clear, concise manner all modern processes for the heating, annealing, forging, welding, hardening, and tempering of high and low grade steel, making it a book of great practical value to the metal-working mechanic in general, with special directions for the successful hardening and tempering of all steel tools used in the arts, including milling cutters, taps, thread dies, reamers, both solid and shell, hollow mills, punches and dies, and all kinds of sheet metal working tools, shear blades, saws, fine cutlery, and metal cutting tools of all description, as well as for all implements of steel both large and small. In this work the simplest and most satisfactory hardening and tempering processes are given.

The uses to which the leading brands of steel may be adapted are concisely presented, and their treatment for working under different conditions explained, also the special methods for the hardening and tempering of special brands.

A chapter devoted to the different processes for case-hardening is also included, and special reference made to the adaptation of machinery steel for tools of various kinds. 5th Edition. 321 pages. 201 illustrations. Price **$3.00**

TRACTORS

MODERN GAS TRACTOR: ITS CONSTRUCTION, UTILITY, OPERATION AND REPAIR. By Victor W. Pagé.

An enlarged and revised edition that treats exclusively on the design and construction of farm tractors and tractor power plants, and gives complete instructions on their care, operation and repair. All types and sizes of gasoline, kerosene and oil tractors are described, and every phase of traction engineering practice fully covered. Invaluable to all desiring reliable information on gas motor propelled traction engines and their use. All new 1921 types of tractors are described and complete instructions are given for their use on the farm. The chapter on engine repairing has been greatly enlarged and complete and detailed instructions are now given for repairing well-known and widely used tractor power plants, numerous new forms of which are described. Valuable information compiled by Government experts on laying out fields for tractor plowing and numerous practical suggestions for hitches so all types of agricultural machinery can be operated by tractors, are outlined. The chapter on tractor construction and upkeep has been more than doubled in size. Over 100 new illustrations have been added and the book greatly enlarged. Full instructions are now given for using kerosene and distillate as fuel. The 1921 edition is 50 per cent larger than the second edition and is more than ever the acknowledged authority on farm tractors and their many uses. 5¼ x 7½ inches. Cloth, nearly 700 pages, and about 300 illustrations, 3 folding plates. Price **$3.00**

WELDING

MODERN WELDING METHODS. By Victor W. Pagé.

One of the most instructive books on all methods of joining metals yet published for the mechanic and practical man. It considers in detail oxy-acetylene welding, the Thermit process and all classes of electric arc and resistance welding. It shows all the apparatus needed and how to use it. It considers the production of welding gases, construction and operation of welding and cutting torches of all kinds. It details the latest approved methods of preparing work for welding. All forms of gas and electric welding machines are described and complete instructions are given for installing electric spot and butt welders. Cost data are given and all methods of doing the work economically are described. It includes instructions for forge and dip brazing and manufacture of hard solders and spelters. It shows and explains soft soldering processes and tells how to make solders for any use. Complete instructions are given for soldering aluminum and authoritative formulas for aluminum solders are included. 292 pages. 200 illustrations. 1921 edition. Price . . **$3.00**

AUTOMOBILE WELDING WITH THE OXY-ACETYLENE FLAME. By M. Keith Dunham.

Explains in a simple manner apparatus to be used, its care, and how to construct necessary shop equipment. Proceeds then to the actual welding of all automobile parts, in a manner understandable by everyone. Gives principles never to be forgotten. This book is of utmost value, since the perplexing problems arising when metal is heated to a melting point are fully explained and the proper methods to overcome them shown. 167 pages. Fully illustrated. Price **$1.50**

Date Due

13 OCT 27			
6 OCT 19			
1 MAY 5 5			
NOV 21			
DEC 2 9 1998			
DEC 1 8 2000			

L. B. CAT. NO. 1137

TL205.P2 SCIII
3 5002 00185 9409
Page, Victor Wilfred
The modern gasoline automobile; its desi

PHYSICS LIBRARY
TL
205
P2

105594